

## PRODUCT INFORMATION

# DuPont™ Zytel® HTN51G35FWS BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

### Product Information

Zytel® HTN51G35FWS BK083 is a 35% glass reinforced, heat stabilized, lubricated, hydrolysis resistant high performance polyamide resin with improved fatigue and welding strength performance. It is also a PPA resin.

### General Information

Property	Value	Unit	Test Standard
Resin Identification	PA6T/XT-GF35	-	ISO 1043
Part Marking Code	PA6T/XT-GF35	-	ISO 11469
Part Marking Code	>PPA-GF35<	-	SAE J1344

### Rheological properties

Property	Value	Unit	Test Standard
Moulding shrinkage, parallel	dry / cond	-	-
Moulding shrinkage, normal	0.2 / -	%	ISO 294-4, 2577
	0.5 / -	%	ISO 294-4, 2577

### Mechanical properties

Property	Value	Unit	Test Standard
Tensile Modulus	dry / cond	-	-
Stress at break	13000 / 13000	MPa	ISO 527-1/-2
Strain at break	230 / 210	MPa	ISO 527-1/-2
Charpy notched impact strength, 23°C	2.6 / 2.6	%	ISO 527-1/-2

### Thermal properties

Property	Value	Unit	Test Standard
Glass transition temperature, 10°C/min	dry / cond	-	-
Temp. of deflection under load, 1.8 MPa	135 / 95	°C	ISO 11357-1/-2
	263 / *	°C	ISO 75-1/-2

### Flammability

Property	Value	Unit	Test Standard
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	23	mm/min	ISO 3795 (FMVSS 302)

### Other properties

Property	Value	Unit	Test Standard
Density	dry / cond	-	-
	1470 / -	kg/m <sup>3</sup>	ISO 1183

### VDA Properties

Property	Value	Unit	Test Standard
Odour	4	class	VDA 270

### Injection

Property	Value	Unit	Test Standard
Drying Recommended	yes	-	-
Drying Temperature	≥100	°C	-
Drying Time, Dehumidified Dryer	6 - 8	h	-
Processing Moisture Content	≤0.1	%	-
Melt Temperature Optimum	325	°C	-
Min. melt temperature	320	°C	-
Max. melt temperature	330	°C	-
Mold Temperature Optimum	150	°C	-
Min. mould temperature	140 <sup>1)</sup>	°C	-
Max. mould temperature	180	°C	-

1: Higher temperature needed for thinner sections.

### Characteristics

Processing	<ul style="list-style-type: none"> <li>Injection Moulding</li> </ul>
Special characteristics	<ul style="list-style-type: none"> <li>Heat stabilised or stable to heat</li> </ul>

### Processing Texts

#### Injection molding

During molding, use proper protective equipment and adequate ventilation. Avoid exposure to fumes and limit the hold up time and temperature of the resin in the machine. Purge degraded resin carefully with HDPE.

When lower mold temperatures are used, the initial warpage and shrinkage may be lower, but the surface appearance and chemical resistance may be reduced, and the dimensional change may be greater when parts are subsequently heated.

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To find out more, visit DuPont Performance Polymers or contact nearest DuPont location.

#### North America

Tel: +1 302 999-4592

Toll-Free (USA): 800 441-0575

#### Asia Pacific

Tel: +81 3 5521 8600

#### Europe/Middle East/Africa

Tel: +41 22 717 51 11



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