



Zytel® HTN51G35HSLR BK420J

HIGH PERFORMANCE POLYAMIDE RESIN

Zytel® HTN high performance polyamide resins feature high retention of properties upon exposure to elevated temperature, to high moisture and to harsh chemical environments. Polymer families and grades of Zytel® HTN are tailored to optimize performance as well as processability.

Typical applications with Zytel® HTN include demanding applications in the automotive, electrical and electronics, domestic appliances, and construction industries.

Zytel® HTN51G35HSLR BK420J is a 35% glass reinforced, heat stabilized, lubricated, hydrolysis resistant high performance polyamide resin with improved surface appearance. It is also a PPA resin.

Product information

Resin Identification	PA6T/XT-GF35	ISO 1043
Part Marking Code	>PA6T/XT-GF35<	ISO 11469
Part Marking Code	>PPA-GF35<	SAE J1344
ISO designation	ISO 16396-PA6T/XT,GF35,M1CGHRW,S10-110	

Rheological properties

	dry/cond.		
Moulding shrinkage, parallel	0.2/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.5/-	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	11500/-	MPa	ISO 527-1/-2
Stress at break	215/-	MPa	ISO 527-1/-2
Strain at break	2.6/-	%	ISO 527-1/-2
Flexural Modulus	10300/-	MPa	ISO 178
Charpy notched impact strength, 23°C	11/-	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33/-	-	

Thermal properties

	dry/cond.		
Glass transition temperature, 10°C/min	135/95	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.8 MPa	264/*	°C	ISO 75-1/-2

Flammability

FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	23 mm/min	ISO 3795 (FMVSS 302)



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Other properties

	dry/cond.		
Humidity absorption, 2mm	1.4/*	%	Sim. to ISO 62
Density	1460/-	kg/m ³	ISO 1183

VDA Properties

Odour	4 class	VDA 270
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Injection

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 ^[1] °C
Max. mould temperature	180 °C

[1]: Higher temperature needed for thinner sections.

Additional Information

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.

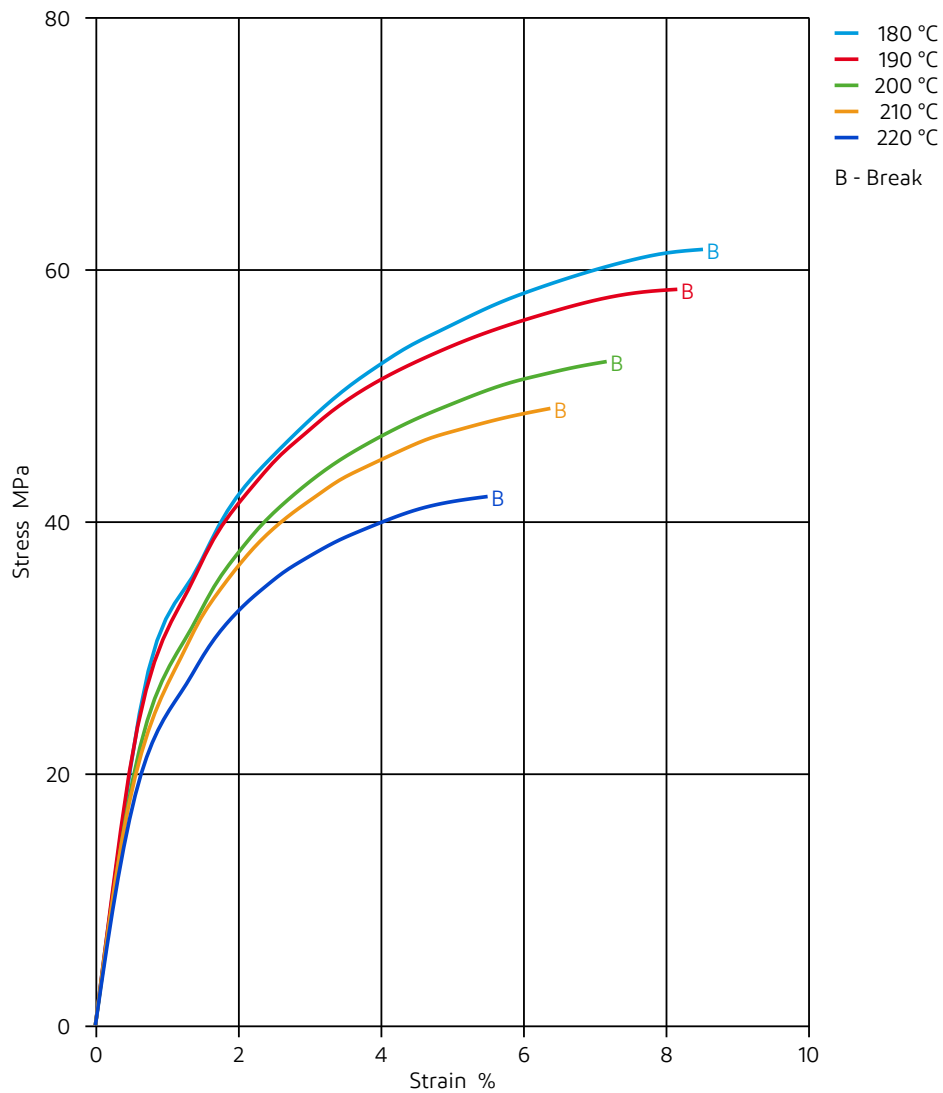
When lower mold temperatures are used, the initial warpage and shrinkage may be lower, but the surface appearance and chemical resistance may be reduced, and the dimensional change may be greater when parts are subsequently heated.



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Stress-strain (dry)

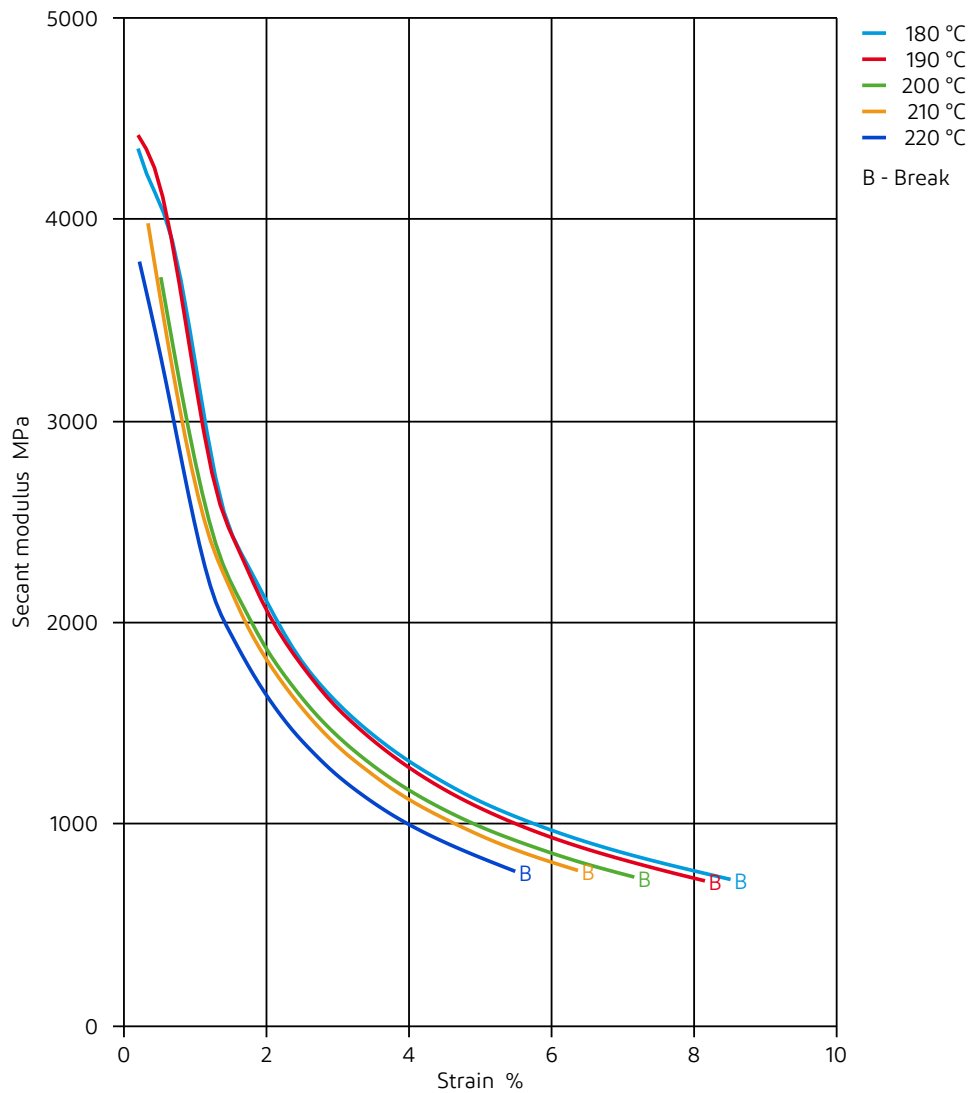




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Secant modulus-strain (dry)

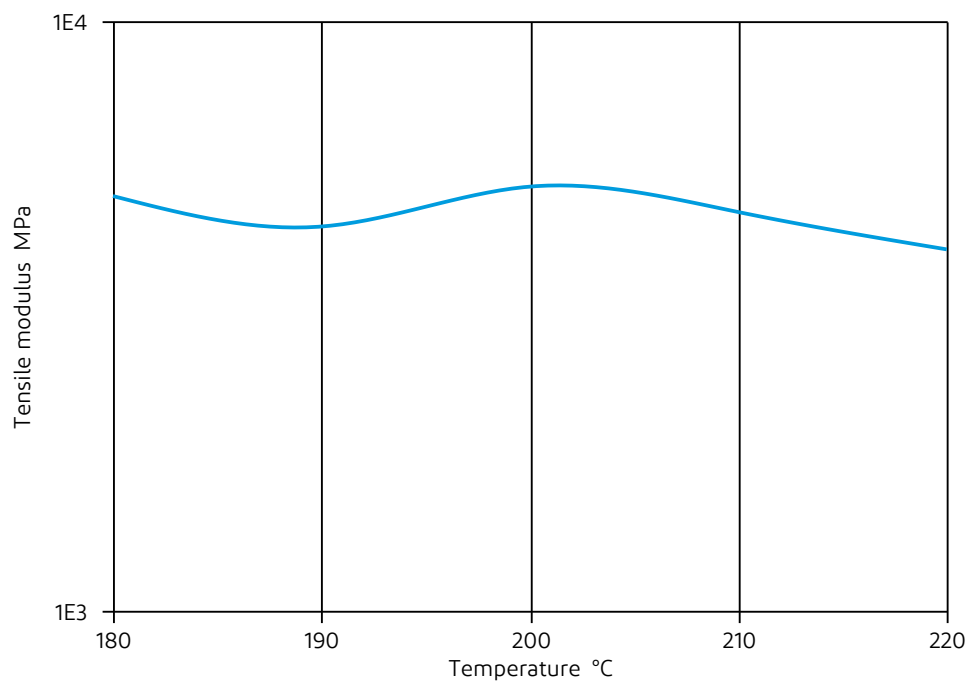




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Tensile modulus-temperature (dry)





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Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass), 23°C
- ✓ Citric Acid solution (10% by mass), 23°C
- ✓ Lactic Acid (10% by mass), 23°C

Other

- ✓ Ethylene Glycol (50% by mass) in water, 108°C
- ✓ Water, 23°C
- ✓ Water, 90°C
- ✓ Coolant Glysantin G48, 1:1 in water, 125°C

Symbols used:

- ✓ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).
- ✗ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

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