

# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

**Product Information**

Zytel® HTN51G45HSL BK083 is a 45% glass reinforced, heat stabilized, lubricated, hydrolysis resistant high performance polyamide resin. It is also a PPA resin.

General information	Value	Unit	Test Standard
Resin Identification	PA6T/XT-GF45	-	ISO 1043
Part Marking Code	PA6T/XT-GF45	-	ISO 11469
Part Marking Code	>PPA-GF45<	-	SAE J1344
Rheological properties	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	0.1 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / -	%	ISO 294-4, 2577
Molding shrinkage, parallel, annealed	0.2 / *	%	ISO 294-4
Molding shrinkage, normal, annealed	0.7 / *	%	ISO 294-4
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	15000 / 15500	MPa	ISO 527-1/-2
Stress at break	240 / 230	MPa	ISO 527-1/-2
Strain at break	2.3 / 2	%	ISO 527-1/-2
Flexural Modulus	13200 / -	MPa	ISO 178
Charpy impact strength			ISO 179/1eU
73°F	85 / -	kJ/m <sup>2</sup>	
-22°F	80 / -	kJ/m <sup>2</sup>	
Charpy notched impact strength			ISO 179/1eA
73°F	12 / -	kJ/m <sup>2</sup>	
-22°F	12 / -	kJ/m <sup>2</sup>	
Izod notched impact strength			ISO 180/1A
73°F	12 / -	kJ/m <sup>2</sup>	
-40°F	13 / -	kJ/m <sup>2</sup>	
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, first heat	300 / *	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	265 / *	°C	
65 psi	285 / *	°C	
CLTE			ISO 11359-1/-2
Normal, -40-23°C	50 / *	E-6/K	
Normal, 55-160°C	65 / *	E-6/K	
Parallel, -40-23°C	15 / *	E-6/K	
Parallel, 55-160°C	13 / *	E-6/K	
RTI, electrical			UL 746B
30mil	150 / *	°C	
60mil	150 / *	°C	
120mil	150	°C	
RTI, impact			UL 746B
30mil	120	°C	
60mil	125 / *	°C	
120mil	150	°C	
RTI, strength			UL 746B
30mil	130	°C	
60mil	140 / *	°C	
120mil	150	°C	
Flammability	dry / cond	Unit	Test Standard
Burning Behav. at 60mil nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	yes / *	-	UL 94
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

Asia Pacific

Europe/Middle East/Africa

DONGGUAN FUMEI PLASTICS CO.,LTD.

TEL: +86 0769-82339888 / 87798999

EMAIL: fumei@foomx.com

Copyright 2017 DuPont. The DuPont Oval Logo is a trademark or registered trademark of E.I. du Pont de Nemours and Company or its affiliates. All rights reserved.



# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

Thickness tested	0.85 / *	mm	IEC 60695-11-10
UL recognition	yes / *	-	UL 94
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	29	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	dry / cond	Unit	Test Standard
Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
Other properties	dry / cond	Unit	Test Standard
Humidity absorption, 80mil	1 / *	%	Sim. to ISO 62
Water absorption, 80mil	3.6 / *	%	Sim. to ISO 62
Density	1570 / -	kg/m <sup>3</sup>	ISO 1183
Injection	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. mold temperature	140 <sup>[1]</sup>	°C	-
Max. mold temperature	180	°C	-

1: Higher temperature needed for thinner sections.

### Characteristics

Processing	• Injection Molding		
Special characteristics	• Heat stabilized or stable to heat		
Regional Availability	• North America • Europe	• Asia Pacific • South and Central America	• Near East/Africa • Global

### 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.

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

#### North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: fumei@foomx.com

#### Asia Pacific

TEL: +86 0769-82339888 / 87798999

#### Europe/Middle East/Africa

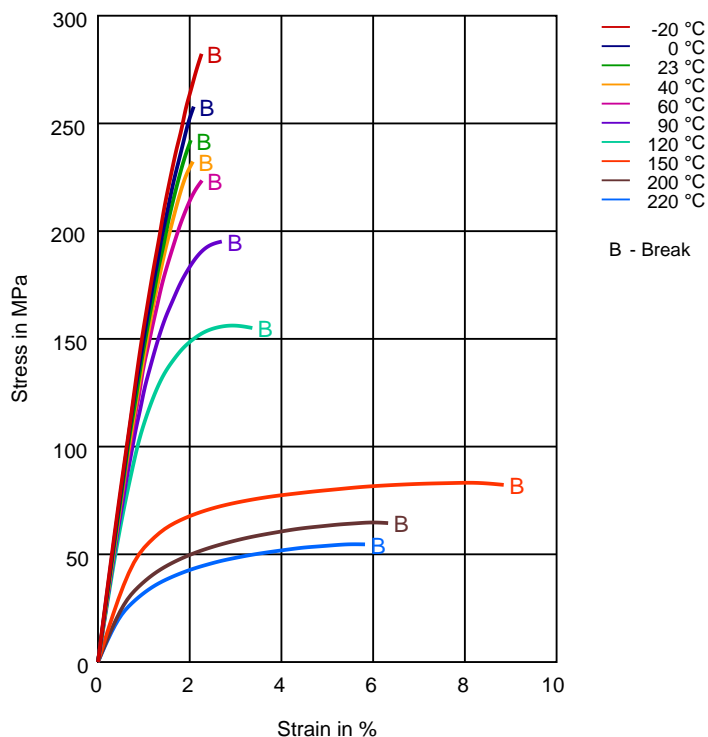


# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

Diagrams

Stress-strain (dry)



Revised: 2018-07-17

Page: 3 of 7

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: [fumei@foomx.com](mailto:fumei@foomx.com)

Asia Pacific

TEL: +86 0769-82339888 / 87798999

Europe/Middle East/Africa

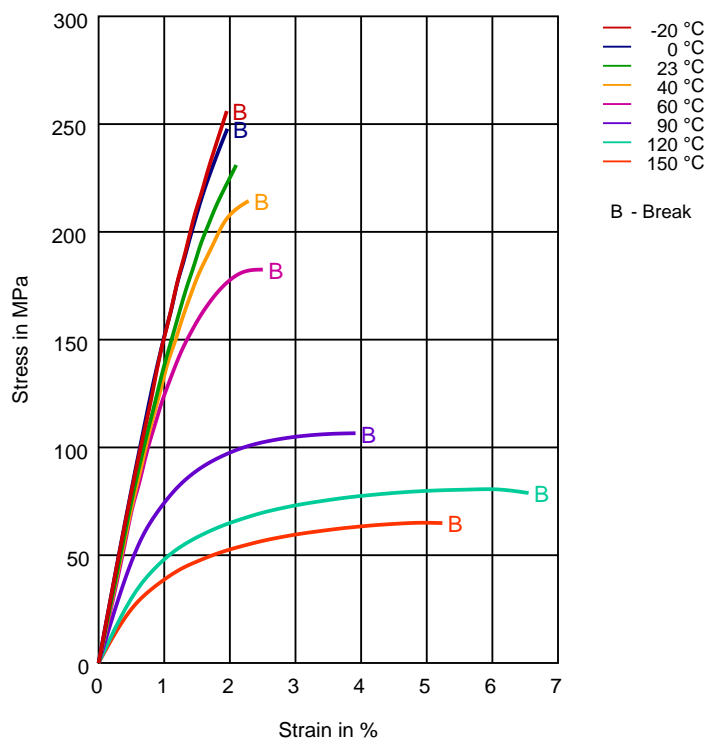
Copyright 2017 DuPont. The DuPont Oval Logo is a trademark or registered trademark of E.I. du Pont de Nemours and Company or its affiliates. All rights reserved.



# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

Stress-strain (cond.)



To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: fumei@foomx.com

Asia Pacific

TEL: +86 0769-82339888 / 87798999

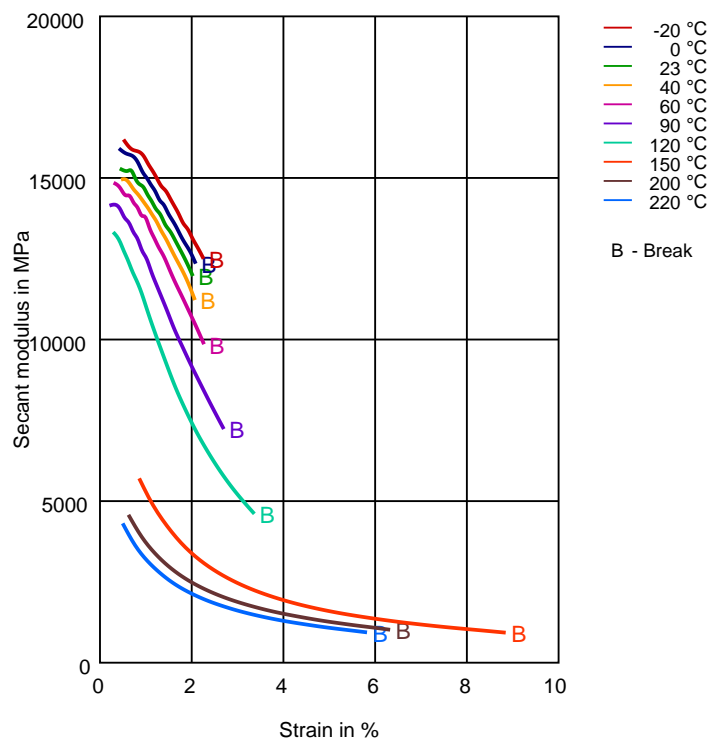
Europe/Middle East/Africa



# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

Secant modulus-strain (dry)



To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: fumei@foomx.com

Asia Pacific

TEL: +86 0769-82339888 / 87798999

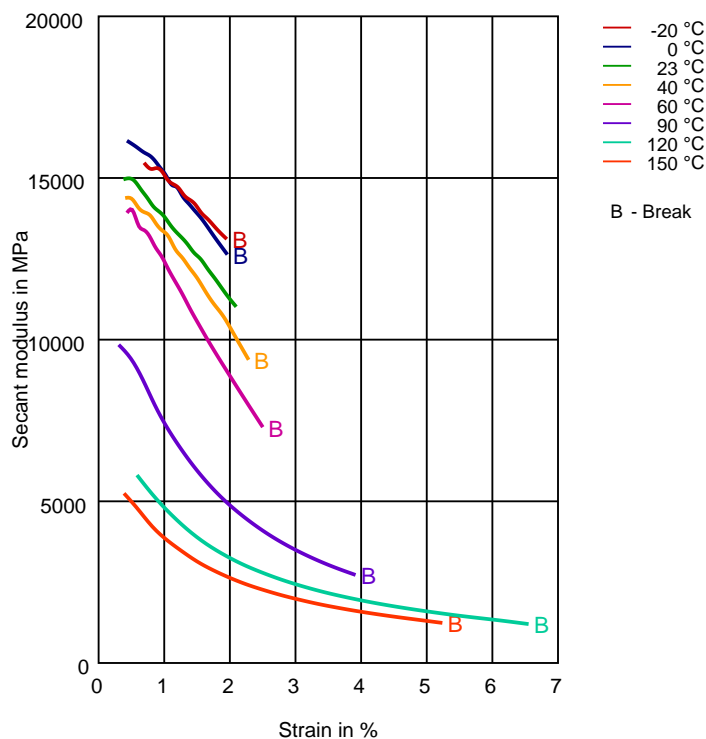
Europe/Middle East/Africa



# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

Secant modulus-strain (cond.)



To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: fumei@foomx.com

Asia Pacific

TEL: +86 0769-82339888 / 87798999

Europe/Middle East/Africa



# DuPont™ Zytel® HTN51G45HSL BK083

## HIGH PERFORMANCE POLYAMIDE RESIN

### Chemical Media Resistance

#### 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).

- X 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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

The information set forth herein is furnished free of charge and is based on technical data that DuPont believes to be reliable and falls within the normal range of properties. It is intended for use by persons having technical skill, at their own discretion and risk. This data should not be used to establish specification limits nor used alone as the basis of design. Handling precaution information is given with the understanding that those using it will satisfy themselves that their particular conditions of use present no health or safety hazards. Since conditions of product use and disposal are outside our control, we make no warranties, express or implied, and assume no liability in connection with any use of this information. As with any product, evaluation under end-use conditions prior to specification is essential. Nothing herein is to be taken as a license to operate or a recommendation to infringe on patents. Caution: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, discuss with your DuPont customer representative and read Medical Caution H-50103-5.

Copyright © 2017 DuPont or its affiliates. All Rights Reserved. The DuPont Oval Logo, DuPont™, The miracles of science™ and all products denoted with ® or ™ are registered trademarks or trademarks of E.I. du Pont de Nemours and Company or its affiliates.

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

#### North America

DONGGUAN FUMEI PLASTICS CO.,LTD.

EMAIL: fumei@foomx.com

#### Asia Pacific

TEL: +86 0769-82339888 / 87798999

#### Europe/Middle East/Africa

