

DuPont™ Zytel® HTNLT51G35HSLR BL661A

HIGH PERFORMANCE POLYAMIDE RESIN

Product Information

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® HTNLT51G35HSLR is a 35% glass reinforced, heat stabilized, lubricated high performance polyamide resin developed for laser welding applications. It is also a PPA resin.

General information	Value	Unit	Test Standard
Resin Identification	PA6T/XT-GF35	-	ISO 1043
Part Marking Code	PA6T/XT-GF35	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / -	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	11800 / -	MPa	ISO 527-1/-2
Stress at break	235 / -	MPa	ISO 527-1/-2
Strain at break	2.4 / -	%	ISO 527-1/-2
Charpy notched impact strength, 73°F	11 / -	kJ/m ²	ISO 179/1eA
Thermal properties	dry / cond	Unit	Test Standard
Temp. of deflection under load, 260 psi	262 / *	°C	ISO 75-1/-2
Flammability	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	dry / cond	Unit	Test Standard
Density	1470 / -	kg/m ³	ISO 1183
VDA Properties	Value	Unit	Test Standard
Odor test	4	class	VDA 270
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	°C	-
Max. mold temperature	180	°C	-

Characteristics

Processing	• Injection Molding
Delivery form	• Pellets
Additives	• Release agent
Special characteristics	• Heat stabilized or stable to heat
Regional Availability	• Asia Pacific

Processing Texts

Injection molding

During molding, use proper protective equipment and adequate ventilation. Avoid exposure to fumes and limit the hold up time and



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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.

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.

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