

# Zytel® HTN51G35HSLR BK420

## HIGH PERFORMANCE POLYAMIDE RESIN

Zytel® HTN51G35HSLR BK420 is a 35% glass reinforced, heat stabilised, lubricated, hydrolysis resistant high performance polyamide resin. It is also a PPA resin.

### General Information

Resin Identification ISO 1043

Density ISO 1183

PA6T/XT-GF35

12.3/- lb/gal

### Drying

Drying Recommended

Drying Temperature\*\*

Drying Time\*

Processing Moisture Content - Optimum\*\*

Processing Moisture Content

yes

212 °F

6 - 8 h

0.05 %

≤0.1 %

### Temperature settings

Melt Temperature Optimum

Min. melt temperature\*\*\*

Max. melt temperature

Mold Temperature Optimum

Min. mould temperature

Max. mould temperature

617 °F

608 °F

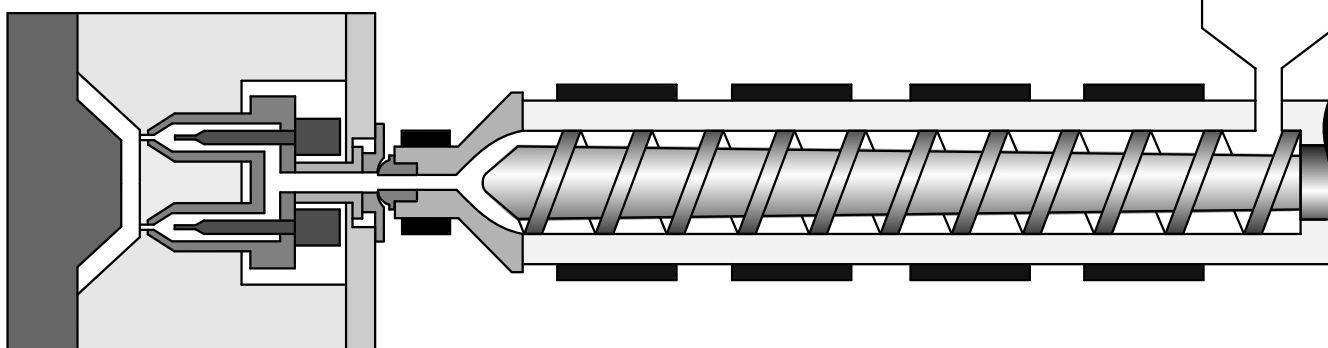
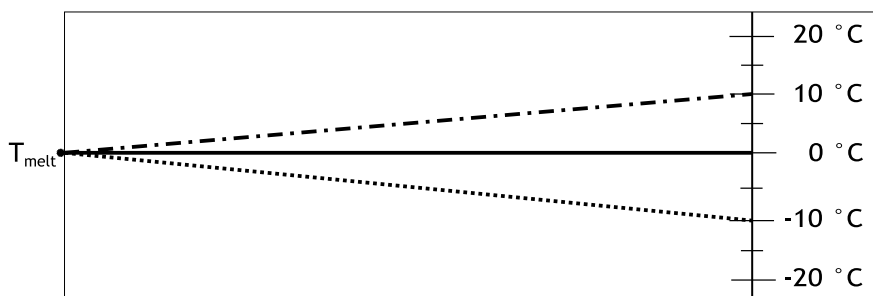
626 °F

302 °F

284 °F

356 °F

3 D (< 3 min)    - - - - -  
2 D (3-5 min)    —————  
1 D (> 5 min)    . . . . .



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### Recommended general settings

Residence time - optimum range	3 - 5 min
Residence time - maximum	10 min
Hold Pressure Time	$h^2+2$ s
(h is the max. wall thickness of the part in mm)	

$$\text{Residence time} = \frac{8 \cdot \text{screw } \varnothing [\text{mm}] \cdot \text{cycle time [s]}}{60 \cdot \text{dosing stroke [mm]}}$$

*Hot runner residence time not included in calculation*

### Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

### Links for further information

#### Trouble Shooting Guide

For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, Purging, please refer to the detailed Molding Guide.

#### Footnotes:

- \* Improper storage may lead to longer drying times
- \*\* Excessive drying may lead to viscosity increase during processing. A discoloration of natural colored materials is possible.
- \*\*\* Using melt temperature lower than recommended could create unmelt, leading to weak parts

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Page: 2 of 2

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