Zytel® HTN7520GF

HIGH PERFORMANCE POLYAMIDE RESIN

Zytel® HTN7520GF is a glass fiber 20%-reinforced PA.MXD6 grade, with strong mechanical properties, wear resistance and heat resistance. It is suitable for applications such as automotive, electrical & electronics, and industrial parts.

Product information

Resin Identification	PAMXD6-GF20	ISO 1043
Part Marking Code	>PAMXD6-GF20<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile stress at break, 5mm/min	20300 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.5 / -	%	ISO 527-1/-2
Flexural modulus	1.32E6 / -	psi	ISO 178
Flexural strength	26100 / -	psi	ISO 178
Charpy notched impact strength, 23 °C	2.38 / -	ftlb/in²	ISO 179/1eA

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	460 / *	°F	ISO 11357-1/-3

Flammability

	dry/cond.		
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.0315 / *	in	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Density	0.0495 / -	lb/in³	ISO 1183

Characteristics

Processing	Injection Molding
Special characteristics	Heat stabilized or stable to heat

Additional information

Injection molding

Preprocessing

The maximum humidity content allowed for the injection molding process is 0.10%. The drying time depends on the initial moisture content and the drying conditions used. Generally 8 hours at 90 °C at a dehumidifier dryer are sufficient.

Processing

The following conditions apply to the normal injection molding process of MAXIMID compounds. Machine temperatures: barrel 250-280 °C, nozzle and hot runners 280 °C. Mold temperatures: 120-140 °C. Back pressure: typically 5-10 bar (hydraulic pressure). In case of gas generation in the melt, please verify moisture content and processing temperatures. For further details, please contact our technical support team.

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Processing Notes

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Pre-Drying

It is recommended to dry material at 90ºC for 8h at dehumidified dryer.
suggested max. moisture = 0.10%

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