Zytel® HTN7530CFS

HIGH PERFORMANCE POLYAMIDE RESIN

- Zytel® HTN7530CFS is a carbon fiber 30%-reinforced, impact modified and conductive PA.MXD6 grade.
- It is suitable for applications such as automotive, electrical & electronics, and industrial parts requiring conductivity, high stiffness and good surface performance.

Product information

Resin Identification	PAMXD6-CF30	ISO 1043
Part Marking Code	>PAMXD6-CF30<	ISO 11469

Rheological properties

Molding shrinkage range, parallel	0 - 0.1	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile stress at break, 5mm/min	38400 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.5 / -	%	ISO 527-1/-2
Flexural modulus	3.23E6 / -	psi	ISO 178
Flexural strength	55800 / -	psi	ISO 178
Charpy notched impact strength, 23 °C	3.71 / -	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

Electrical properties

	dry/cond.		
Volume resistivity	60 / -	Ohm.m	IEC 62631-3-1
Surface resistivity	* / 20	Ohm	IEC 62631-3-2

Physical/Other properties

	dry/cond.		
Density	0.0462 / -	lb/in³	ISO 1183

Characteristics

Processing	Injection Molding

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 5-12 hours at 80 °C at a dehumidifier dryer are sufficient.

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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.

Processing Notes

Pre-Drying

It is recommended to dry material at 80ºC for 5-12h at dehumidified dryer. suggested max. moisture = 0.10%

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