

Zytel® HTN FE350064 BK544

HIGH PERFORMANCE POLYAMIDE RESIN

DuPont Performance Polymers

Message:

Carbon Fiber Reinforced, Toughened, PPA, High Performance Polyamide

General Information				
Additive		Heat Stabilizer		
		Mold Release		
Features		Electrically Conductive		
		Heat Stabilized		
		Statically Conductive		
Forms		Pellets		
Processing Method		Injection Molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
		Secant Modulus vs. Strain (ISO 11403-1)		
Part Marking Code (ISO 11469)		>PA-ICF<		
Part Marking Code (SAE J1344)		>PPA-ICF<		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (325°C/2.16 kg)	5.0	--	g/10 min	ISO 1133
Molding Shrinkage				ISO 294-4
Across Flow	0.50	--	%	
Flow	0.20	--	%	
Viscosity Number	110	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	10400	11000	MPa	ISO 527-2
Tensile Stress (Break)	168	162	MPa	ISO 527-2
Tensile Strain (Break)	2.4	2.3	%	ISO 527-2
Flexural Modulus	8700	--	MPa	ISO 178
Flexural Stress	240	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-40°C	3.0	--	kJ/m ²	
23°C	6.0	--	kJ/m ²	

Charpy Unnotched Impact Strength (23°C)	48	--	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	258	--	°C	ISO 75-2/A
Melting Temperature ¹	300	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	1.4E-5	--	cm/cm/°C	
Flow : -40 to 23°C	1.7E-5	--	cm/cm/°C	
Flow : 55 to 160°C	1.5E-5	--	cm/cm/°C	
Transverse	8.3E-5	--	cm/cm/°C	
Transverse : -40 to 23°C	8.0E-5	--	cm/cm/°C	
Transverse : 55 to 160°C	8.5E-5	--	cm/cm/°C	
NOTE				
1.	First Heat			

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