

Starflam® 525H BK0771

polyamide 66

Starflam 525H BK0771 (formerly Vydyne® ECO525H BK0771) is a 25% glass reinforced PA66, heat stabilized, flame retardant that is halogen and red phosphorous free.

General

Regional Availability	• North America	• Europe	• Asia Pacific
Additive	• Flame Retarding Agent		
Features	• Corrosion Resistant	• Fast Molding Cycle	• Flame Retardant
	• Good Dimensional Stability	• Good Processability	• Heat Aging Resistant
	• High Flow	• High Strength	
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.40	-	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	0.9	*	%	
Flow : 23°C, 2.00 mm	0.6	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	9400	7000	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	123	91	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.5	3	%	ISO 527-2
Flexural Modulus (23°C)	9000	6000	MPa	ISO 178
Flexural Strength (23°C)	197	129	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	8.7	10	kJ/m ²	
-30°C	7.5	7.9	kJ/m ²	
-40°C	7.4	7.6	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	59	60	kJ/m ²	
-30°C	55	52	kJ/m ²	
-40°C	52	52	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
+23°C	7.9	9.5	kJ/m ²	
-30°C	7.4	7.6	kJ/m ²	

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-40°C	7.3	8	kJ/m²	
Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	237	226	°C	
0.45 MPa, Unannealed	255	253	°C	
Melting Temperature	260	*	°C	ISO 11357-3
RTI Elec				UL 746
0.200 mm	140		°C	
0.400 mm	150		°C	
0.750 mm	150		°C	
1.50 mm	150		°C	
3.00 mm	150		°C	
RTI Imp				UL 746
0.200 mm	110		°C	
0.400 mm	115		°C	
0.750 mm	130		°C	
1.50mm	140		°C	
3.00 mm	140		°C	
RTI Str				UL 746
0.200 mm	120		°C	
0.400 mm	125		°C	
0.750 mm	140		°C	
1.50 mm	150		°C	
3.00 mm	150		°C	
Electrical	dry	cond.	Unit	Test Standard
Dielectric Strength (1.00 mm)	31	19	kV/mm	IEC 60243
Comparative Tracking Index (3.00 mm)	575		V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.400 mm	PLC 0		-	
0.750 mm	PLC 0		-	
1.50 mm	PLC 0		-	
3.00 mm	PLC 0		-	
Hot-wire Ignition (HWI)				UL 746
0.400 mm	PLC 1		-	
0.750 mm	PLC 1		-	
1.50 mm	PLC 0		-	
3.00 mm	PLC 0		-	

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Flammability	Value	Unit	Test Standard
Flammability			UL 94
0.200 mm	V-0	-	
0.400 mm	V-0	-	
0.750 mm	V-0	-	
1.50 mm	V-0	-	
3.00 mm	V-0	-	
Flammability, 5V			UL 94
1.50 mm	5VA	-	
3.00 mm	5VA	-	
Glow Wire Flammability Index			IEC 60695-2-12
0.400 mm	960	°C	
0.750 mm	960	°C	
1.50 mm	960	°C	
3.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.400 mm	750	°C	
Injection	Value	Unit	
Drying Temperature	80	°C	
Drying Time	4 - 6	h	
Rear Temperature	275 - 300	°C	
Middle Temperature	275 - 300	°C	
Front Temperature	275 - 300	°C	
Processing (Melt) Temperature	275 - 300	°C	
Mold Temperature	60 - 120	°C	

