

Vydyne® R525H Nat

polyamide 66



Vydyne R525H NAT is a general purpose, 25% glass-filled, heat-stabilized, high viscosity PA66 based resin designed for injection molding applications. R525H NAT offers standard flow with a natural surface finish and maintains the excellent resistance typical of PA66 in chemicals, machine and motor oils, solvents, and gasoline.

General

Regional Availability	• North America	• Europe	• Asia Pacific
Additive	• Heat Stabilizer	• Lubricant	
Features	• Antifreeze Resistant • Gasoline Resistant • Lubricated	• Chemical Resistant • Heat Stabilized • Solvent Resistant	• Fatigue Resistant • High Flow
Agency Rating	• ASTM, D4066 PA012G25 • EU, 10/2011	• ASTM, D6779 PA012G25 • EU, 2023/2006	• EC, 1935/2004 • FDA, 21 CFR 177.1500
UL File Number	• E70062		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.32	-	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	0.4	*	%	
Water Absorption				ISO 62
23°C, 24 hr	0.9	*	%	
Equilibrium, 23°C, 50% RH	2	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	8600	5500	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	174	117	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3	7	%	ISO 527-2
Flexural Modulus (23°C)	7700	5700	MPa	ISO 178
Flexural Strength (23°C)	250	150	MPa	ISO 178
Poisson's Ratio (23°C)	0.4	-		ISO 527-2

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	11	12	kJ/m ²	
-30°C	10	10	kJ/m ²	

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Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	65	67	kJ/m ²	
-30°C	55	66	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A
+23°C	10	15	kJ/m ²	
-30°C	9	10	kJ/m ²	

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	245	-	°C	
0.45 MPa, Unannealed	258	-	°C	
Melting Temperature	260	*	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	25	*	E-6/K	
Transverse : 23 to 55°C, 2.00 mm	109	*	E-6/K	
RTI Elec				UL 746
0.750 mm	140		°C	
1.50 mm	140		°C	
3.00 mm	140		°C	
RTI Imp				UL 746
0.750 mm	120		°C	
1.50mm	120		°C	
3.00 mm	120		°C	
RTI Str				UL 746
0.750 mm	125		°C	
1.50 mm	140		°C	
3.00 mm	140		°C	

Electrical	dry	cond.	Unit	Test Standard
Volume Resistivity (1.00 mm)	1E11	-	Ohm*m	IEC 60093
Dielectric Strength (1.00 mm)	20	-	kV/mm	IEC 60243
Arc Resistance (3.00 mm)	6		-	ASTM D 495
Comparative Tracking Index (3.00 mm)	250 - 399		V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.750 mm	PLC 0		-	
1.50 mm	PLC 0		-	
3.00 mm	PLC 0		-	
High Voltage Arc Tracking Rate (HVTR), 3.00 mm	PLC 1		-	UL 746
Hot-wire Ignition (HWI)				UL 746

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0.400 mm	PLC 4	-
0.750 mm	PLC 3	-
1.50 mm	PLC 4	-

Flammability	Value	Unit	Test Standard
Burning Rate, 2.00 mm		mm/min	ISO 3795
Flammability			UL 94
0.750 mm	HB	-	
1.50 mm	HB	-	
3.00 mm	HB	-	
Glow Wire Flammability Index			IEC 60695-2-12
0.400 mm	675	°C	
0.750 mm	675	°C	
1.50 mm	675	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.400 mm	700	°C	
0.750 mm	700	°C	
1.50 mm	700	°C	

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Rear Temperature	280 - 310	°C
Middle Temperature	280 - 310	°C
Front Temperature	280 - 310	°C
Nozzle temperature	280 - 310	°C
Processing (Melt) Temperature	285 - 305	°C
Mold Temperature	65 - 95	°C

