

Vydyne® R540H

polyamide 66



Vydyne R540H is general-purpose, heat-stabilized, hydrolysis-resistant, 40% glass-fiber reinforced PA66 resin. Available in natural, it is specifically designed to maximize the retention of physical properties when exposed to anti-freeze solutions at elevated temperatures. This product is also lubricated for improved flow and offers superior surface appearance.

Glass-reinforced Vydyne resins provide higher heat distortion temperature, resistance to creep and better dimensional stability when compared with unreinforced PA66. These products have good chemical resistance to a broad range of chemicals including gasoline, hydraulic fluids and most solvents.

Vydyne R540H is heat-stabilized to minimize oxidative degradation of the polymer when exposed to elevated temperatures in service.

This product provides improved retention of physical properties under exposure to long term heat. Also, Vydyne R540H has excellent knit-line strength and fatigue resistance, which is essential for cycle testing with anti-freeze solutions.

Typical Applications/End Uses:

Vydyne R540H is successfully used in a wide range of injection-molding engineering applications. Typical parts include automotive clips, radiator end tanks, parts of the air-conditioning and fuel distribution systems; electrical connectors, housings and bobbins; and industrial applications such as gears, bearing shells, covers and housings.

General				
Material Status	• Commercial: Active			
Availability	• Asia Pacific	• Europe	• North America	
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight			
Additive	• Heat Stabilizer	• Lubricant		
Features	• Antifreeze Resistant	• Good Chemical Resistance	• Hydrolysis Resistant	
	• Fatigue Resistant	• Good Flow	• Lubricated	
	• Gasoline Resistance	• Heat Stabilized	• Solvent Resistant	
Uses	• Automotive Under the Hood			
Agency Ratings	• ASTM D 4066 PA012G40	• ASTM D 6779 PA012G40		
Automotive Specifications	• CHRYSLER MS-DB-41 CPN4018	• FORD WSK-M4D752-A	• OPEL QK 003013 HW	
	• DAEWOO EDS-M-5164-11	• GM GMP.PA66.040	• TagAZ TAMS-8723-01	
	• FORD WSK-M4D642-A	• GM		
	• FORD WSK-M4D642-A2	• GMW3038P-PA66-GF30H		
UL File Number	• E70062			
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			

Physical	Dry	Conditioned	Unit	Test Method
Density (73°F)	1.46	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 73°F, 0.0787 in	0.90	--	%	
Flow : 73°F, 0.0787 in	0.40	--	%	
Water Absorption (73°F, 24 hr)	0.60	--	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	1.5	--	%	ISO 62

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Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	2.05E+6	1.61E+6	psi	ISO 527-2
Tensile Stress (Break, 73°F)	31900	23900	psi	ISO 527-2
Tensile Strain (Break, 73°F)	3.0	4.0	%	ISO 527-2
Flexural Modulus (73°F)	1.78E+6	1.35E+6	psi	ISO 178
Flexural Stress (73°F)	48600	36300	psi	ISO 178
Poisson's Ratio	0.40	--		ISO 527
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
-22°F	5.7	5.2	ft·lb/in ²	
73°F	5.7	9.0	ft·lb/in ²	
Charpy Unnotched Impact Strength				ISO 179
-22°F	38	41	ft·lb/in ²	
73°F	43	44	ft·lb/in ²	
Notched Izod Impact Strength				ISO 180
-22°F	6.2	6.2	ft·lb/in ²	
73°F	6.7	9.0	ft·lb/in ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	500	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	486	--	°F	
Melting Temperature	500	--	°F	ISO 11357-3
CLTE - Flow (73 to 131°F, 0.0787 in)	9.4E-6	--	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F, 0.0787 in)	5.7E-5	--	in/in/°F	ISO 11359-2
RTI Elec				UL 746
0.0295 in	284	--	°F	
0.0591 in	284	--	°F	
0.118 in	284	--	°F	
RTI Imp				UL 746
0.0295 in	257	--	°F	
0.0591 in	257	--	°F	
0.118 in	257	--	°F	
RTI Str				UL 746
0.0295 in	284	--	°F	
0.0591 in	284	--	°F	
0.118 in	284	--	°F	

Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity (0.118 in)	1.0E+13	--	ohm-cm	IEC 60093
Dielectric Strength (0.0394 in)	510	--	V/mil	IEC 60243
Arc Resistance (0.118 in)	PLC 6	--		ASTM D495
Comparative Tracking Index (0.118 in)	250 to 399	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.0295 in	PLC 0	--		
0.0591 in	PLC 0	--		
0.118 in	PLC 0	--		
High Voltage Arc Tracking Rate (HVTR)	PLC 1	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.0295 in	PLC 4	--		
0.0591 in	PLC 3	--		
0.118 in	PLC 4	--		
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.0295 in	HB	--		
0.0591 in	HB	--		
0.118 in	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.0295 in	1250	--	°F	
0.0591 in	1250	--	°F	
0.118 in	1250	--	°F	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.0295 in	1290	--	°F	
0.0591 in	1290	--	°F	
0.118 in	1290	--	°F	
Additional Information	Dry	Conditioned	Unit	Test Method
Automotive Materials - (thickness d = 1mm)	+	--		FMVSS 302

Injection	Dry Unit
Drying Temperature	176 °F
Drying Time	4.0 hr
Suggested Max Regrind	25 %
Rear Temperature	536 to 590 °F
Middle Temperature	536 to 590 °F
Front Temperature	536 to 590 °F
Nozzle Temperature	536 to 590 °F
Processing (Melt) Temp	545 to 581 °F
Mold Temperature	149 to 203 °F

Notes

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North America
+1 888 927 2363

Europe
+32 10 608 600

Asia
+86 21 6340 3300

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