

NOVALAC RX®655

Phenolic

Vyncolit N.V.

Message:

RX®655 is a fiberglass and mineral reinforced phenolic molding compound, with excellent dimensional stability and good strength at elevated temperatures.

General Information			
Filler / Reinforcement	Glass \Mineral		
Features	Ultra high toughness		
	Good dimensional stability		
	Low smoke		
	High strength		
	Antibacterial property		
	Solvent resistance		
	Good creep resistance		
	alkali resistance		
	acid resistance		
Uses	Membrane key switch		
	Pump parts		
	Gear		
	Electrical/Electronic Applications		
	Electrical appliances		
	Power/other tools		
	Connector		
	Application in Automobile Field		
	Shell		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	2.10	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.060	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.020	%	ISO 62
Hardness	Nominal Value	Unit	Test Method

Rockwell Hardness (E-Scale)	105		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, Compression Molded)	100	MPa	ISO 527-2
Flexural Modulus (Compression Molded)	27000	MPa	ISO 178
Flexural Stress	165	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	2.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	200	°C	ISO 75-2/A
CLTE - Flow	1.7E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.94	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.00 mm)	14	kV/mm	ASTM D149
Arc Resistance	180	sec	ASTM D495
Injection	Nominal Value	Unit	
Rear Temperature	60.0	°C	
Middle Temperature	73.9	°C	
Nozzle Temperature	87.8	°C	
Processing (Melt) Temp	98.9 - 116	°C	
Mold Temperature	166 - 188	°C	
Injection Pressure	100 - 248	MPa	
Holding Pressure	30.0 - 89.6	MPa	
Back Pressure	4.83 - 15.2	MPa	
Injection instructions			

Plastication: 50rpm Injection Time: 2 to 8 sec Hold Time: 1 to 5 sec/mm Cure Time, 0.125 in: 5 to 12 sec/mm All ISO properties listed were tested in accordance with ISO 3167. All ASTM properties listed were tested in accordance with ASTM D5948. The value listed as Thermal Conductivity, ASTM C177, was tested in accordance with ASTM C518. Powder Density, ISO 60: 0.95 g/cm³ HDT A (1.80 MPa) Unannealed, ISO 75A, Post Baked: >282°C Compressive Strength, ISO 604: 410 MPa

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