

Vyncolit 3520CG

Phenolic

Vyncolit N.V.

Message:

Vyncolit® 3520CG is a graphite filled phenolic molding compound used for low friction applications where dimensional stability is required.

General Information			
Filler / Reinforcement	Graphite powder, 65% filler by weight		
Features	Good dimensional stability		
	Low friction coefficient		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PF-CD65		
Physical	Nominal Value	Unit	Test Method
Density	1.64	g/cm ³	ISO 1183
Apparent Density	0.86	g/cm ³	ISO 60
Molding Shrinkage - Flow	0.54	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.030	%	ISO 62
Post Shrinkage	0.11	%	ISO 2577
Flexural Strain at Break	0.68	%	ISO 178
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	16000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	54.0	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	0.39	%	ISO 527-2
Flexural Modulus (Injection Molded)	13000	MPa	ISO 178
Flexural Stress (Injection Molded)	83.0	MPa	ISO 178
Compressive Stress	161	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	1.3	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (Injection Molded)	3.1	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	70.6	°C	ISO 75-2/A

Linear thermal expansion coefficient			TMA
Flow	2.0E-5	cm/cm/°C	TMA
Lateral	3.1E-5	cm/cm/°C	TMA
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: 50rpmInjection Time: 2 to 8 secHold Time: 1 to 5 sec/mmCure Time, 0.125 in: 5 to 12 sec/mm

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