

Di-Pak™ R-4545/30

Thermoplastic

Hapco Inc.

Message:

RIGID
DI-PAK R-4545 Series

A very low viscosity potting and encapsulating system with excellent flow and penetration into the most intricate electronic components, without voids or porosity. The R-4545 Series cure to a hard, shiny, high gloss, plastic finish that is free from "blushing" under all humidity conditions. The R-4545 Series is ideal for electrical applications where surface finish and appearance are critical.

General Information			
Features	Blush Resistant		
	Electrically Insulating		
	Good Processability		
	Good Toughness		
	High Flow		
	High Gloss		
	High Heat Resistance		
	Low Viscosity		
	Pleasing Surface Appearance		
Uses	Battery Cases		
	Electrical/Electronic Applications		
	Power Cable Shields		
	Switches		
Appearance	Black		
Forms	Liquid		
Processing Method	Encapsulating		
	Potting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.15 to 0.30	%	ASTM D2566
Weight - per cubic inch	18	g	
Service Temperature	168	°C	
Gel Time ¹ (25°C)	40.0	min	ASTM D2971
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	90		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3190	MPa	ASTM D638

Tensile Strength	68.9	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	3430	MPa	ASTM D790
Flexural Strength	80.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	28	J/m	ASTM D256
Unnotched Izod Impact	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	
Thermal Conductivity	0.22	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	8.2E+13	ohms·cm	ASTM D257
Dielectric Strength	22	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
1 kHz	4.50		
100 kHz	4.20		
Dissipation Factor (25°C, 100 kHz)	0.015		ASTM D150
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 27, Mix Ratio by Volume: 33		
Thermoset Mix Viscosity (25°C)	3600	cP	ASTM D4878
Demold Time			
57°C	120 to 240	min	
93°C	120 to 240	min	
NOTE			
1.	100 g		

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