

Vyncolit® RX®842

Phenolic

Vyncolit N.V.

Message:

RX®842 is a fiberglass reinforced phenolic novolac compound, with good dimensional stability and good strength at elevated temperatures.

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Features	Good dimensional stability		
	Good strength		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.85	g/cm³	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.040	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.050	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, Compression Molded)	83.0	MPa	ASTM D638
Flexural Modulus (Compression Molded)	19000	MPa	ASTM D790
Flexural Strength (Break)	120	MPa	ASTM D790
Compressive Strength	240	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Compression Molded)	65	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow	2.8E-4	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ¹	14	kV/mm	ASTM D149
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 The value listed as CTLE Flow, ASTM D696, was tested in accordance with >282 Powder Density, ASTM D1895: 0.6 g/cm³ Dielectric Strength, ASTM D149, 60 Hz, Method A, wet: 13.8 kV/mm

NOTE

1. Method A (short time)

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

