

Vyncolit® X611

Phenolic

Vyncolit N.V.

Message:

Vyncolit® X611 is a glass fiber reinforced phenolic molding compound with excellent mechanical and electrical properties, good dimensional stability, heat and chemical resistance.

General Information			
UL YellowCard	E167521-100061673		
Filler / Reinforcement	Glass fiber reinforced material, 55% filler by weight		
Agency Ratings	EU 2002/96/EC (WEEE) 3		
	EU 2006/122/EC		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Green		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PF-(GF+MD)55		
Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Apparent Density	0.68	g/cm ³	ISO 60
Molding Shrinkage	0.30	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.10	%	ISO 62
Post Shrinkage	0.070	%	ISO 2577
Flexural Strain at Break	1.4	%	ISO 178
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14000	MPa	ISO 527-2
Tensile Stress (Break)	85.0	MPa	ISO 527-2
Tensile Strain (Break)	0.60	%	ISO 527-2
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress	195	MPa	ISO 178
Compressive Stress	270	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	3.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	12	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (1.8 MPa, Unannealed)	208	°C	ISO 75-2/A
Linear thermal expansion coefficient			ASTM E831
Flow	1.4E-5	cm/cm/°C	ASTM E831
Lateral	5.2E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.9E+13	ohms	IEC 60093
Volume Resistivity	7.0E+14	ohms·cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Rear Temperature	60.0	°C	
Middle Temperature	75.0	°C	
Nozzle Temperature	90.0	°C	
Processing (Melt) Temp	100 - 115	°C	
Mold Temperature	165 - 190	°C	
Injection Pressure	100 - 250	MPa	
Holding Pressure	30.0 - 90.0	MPa	
Back Pressure	5.00 - 15.0	MPa	
Screw Speed	50	rpm	
Injection instructions			

Hold Time: 1 to 5 sec/mmCure Time: 5 to 12 sec/mm

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