Vyncolit® X655

Phenolic

Vyncolit N.V.

Message:

Vyncolit® X655 is a glass fiber and mineral filled phenolic molding compound with excellent dimensional stability and high electrical insulation properties. UL94-listed.

General Information			
UL YellowCard	E167521-225078		
Filler / Reinforcement	Glass \mineral, 80% filler by weight		
Agency Ratings	EU 2002/96/EC (WEEE) 3 EU 2006/122/EC		
RoHS Compliance	RoHS compliance		
Appearance	Dark Green		
Processing Method	Resin transfer molding Compression molding Injection molding		
Part Marking Code (ISO 11469)	>PF-(MD+GF)80		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	2.08	g/cm³	ISO 1183
Apparent Density	1.04	g/cm³	ISO 60
Molding Shrinkage - Flow	0.15	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.060	%	ISO 62
Post Shrinkage	0.030	%	ISO 2577
Flexural Strain at Break	0.75	%	ISO 178
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (Injection Molded)	30000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	95.0	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	0.45	%	ISO 527-2
Flexural Modulus (Injection Molded)	25000	MPa	ISO 178
Flexural Stress (Injection Molded)	185	MPa	ISO 178
Compressive Stress	360	MPa	ISO 604
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (Injection Molded)	2.7	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (Injection Molded)	8.5	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			

1.8 MPa, not annealed [1]	> 250	°C	ISO 75-2/A
1.8 MPa, not annealed	211	°C	ISO 75-2/A
8.0 MPa, not annealed [2]	> 250	°C	ISO 75-2/C
8.0 MPa, not annealed	160	°C	ISO 75-2/C
Linear thermal expansion coefficient			ASTM E831
Flow	1.2E-5	cm/cm/°C	ASTM E831
Lateral	2.2E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.79	W/m/K	ASTM E1461
RTI Elec	150	°C	UL 746
RTI Imp	150	°C	UL 746
RTI	150	°C	UL 746
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	2.1E+13	ohms	IEC 60093
Volume Resistivity	5.1E+14	ohms·cm	IEC 60093
Dielectric Strength	25	kV/mm	IEC 60243-1
Comparative Tracking Index	300	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.50 mm	V-0		UL 94
3.00 mm	V-0		UL 94
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	
Screw Speed	50	rpm	
Injection instructions			
Injection Time: 2 to 8 secHold Time: 1 to 5 sec/mmCure Time: 5 to 12 sec/mm			
NOTE			
1.	Postcured up to 210 °C		
2.	Postcured up to 210 °C		

Recommended distributors for this material

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