

RX® 613

Phenolic

Sumitomo Bakelite North America, Inc.

Message:

RX® 613 is a fiberglass reinforced phenolic molding compound, with good dimensional stability and good strength at elevated temperatures.

General Information	
Filler / Reinforcement	Glass Fiber
Features	Good Dimensional Stability
	High Temperature Strength
Appearance	Black
	Green
Forms	Granules
Processing Method	Compression Molding
	Injection Molding
	Resin Transfer Molding

Physical	Nominal Value	Unit	Test Method
Density	1.60	g/cm ³	ISO 1183
Apparent Density	0.75	g/cm ³	ISO 60
Molding Shrinkage	0.25	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.080	%	ISO 62

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	100		ISO 2039-2

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, Compression Molded)	85.0	MPa	ISO 527-2
Flexural Modulus (Compression Molded)	14000	MPa	ISO 178
Flexural Stress (Compression Molded)	175	MPa	ISO 178
Compressive Stress	350	MPa	ISO 604

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (Compression Molded)	3.0	kJ/m ²	ISO 180

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed	185	°C	
1.8 MPa, Annealed	> 282	°C	
CLTE - Flow	1.8E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.41	W/m/K	ASTM C518

RTI Elec	150	°C	UL 746
RTI Imp	150	°C	UL 746
RTI Str	150	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	14	kV/mm	ASTM D149
Arc Resistance	150	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-0		
3.20 mm	V-0		

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