

# Vyncolit® 1904B

Epoxy; Epoxide

Vyncolit N.V.

## Message:

Vyncolit 1904B is an epoxy; Epoxy resin material, containing the filler is glass fiber reinforced material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing methods are: resin transfer molding, compression molding or injection molding.

The main features of Vyncolit 1904B are:

chemical resistance

low viscosity

Heat resistance

Typical application areas include:

Electrical/electronic applications

food contact applications

military applications

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Features	The degassing effect is low to no		
	Low viscosity		
	Solvent resistance		
	Anti-salt water/fog		
	Good thermal shock resistance		
	Good chemical resistance		
	alkali resistance		
	acid resistance		
Uses	Non-corrosive		
	Electrical components		
	Military application		
Agency Ratings	Connector		
	FDA not rated		
Forms	USDA Unspecified Approval		
	Particles		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.05	g/cm <sup>3</sup>	ASTM D792
Bulk Factor	2.5		ASTM D1895

Molding Shrinkage - Flow (Compression Molded)	0.10 - 0.30	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	72		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	68.9	MPa	ASTM D638
Flexural Modulus	17200	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Compressive Strength	221	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	35	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	288	°C	ASTM D648
CLTE - Flow	2.8E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.73	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength <sup>1</sup>	13	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.00		ASTM D150
Dissipation Factor (1 MHz)	0.019		ASTM D150
Arc Resistance	185	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	37	%	ASTM D2863
Injection	Nominal Value	Unit	
Middle Temperature	60.0 - 82.2	°C	
Nozzle Temperature	82.2 - 93.3	°C	
Processing (Melt) Temp	93.3 - 116	°C	
Mold Temperature	149 - 177	°C	
Injection Pressure	34.5 - 68.9	MPa	
Holding Pressure	13.8 - 34.5	MPa	
Back Pressure	0.345	MPa	
Injection instructions			
Gauge: 0.3The value listed as Thermal Conductivity, ASTM C177, was tested in accordance with ASTM F433.Water Absorption, ASTM D570, 48 hrs, 50°C: 0.15%Dielectric Strength, ASTM D149, 60 Hz, Method B, wet: 325 V/milDielectric Constant, ASTM D150, 1000000 Hz, wet: 4Dissipation Factor, ASTM D150, 1000000 Hz, wet: 0.019Bulk Factor, ASTM D1895: 2 to 3Compression and Transfer Molding Conditions: Preheat Temperature: 180 to 225 °F Mold Temperature: 325 to 370 °F Compression Mold Pressure: 1000 to 5000 psi Transfer Mold Pressure: 1500 to 8000 psi Cure Time, 0.125 in: 60 to 90 sec			
NOTE			
1.	Method B (step by step)		

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