

Vyncolit® 3615CG

Phenolic

Vyncolit N.V.

Message:

Vyncolit 3615CF is a graphite filled phenolic molding compound with an excellent dimensional stability and a low coefficient of friction.

General Information			
Filler / Reinforcement	Graphite powder		
Additive	Lubricant		
Features	Good dimensional stability		
	Low friction coefficient		
	Self-lubricating		
Appearance	Black		
Forms	Particle		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.50 - 0.60	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.10	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, Injection Molded)	40.0	MPa	ISO 527-2
Flexural Modulus (Injection Molded)	14000	MPa	ISO 178
Flexural Stress (Injection Molded)	90.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	2.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	3.5	kJ/m ²	ISO 179

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	170	°C	ISO 75-2/A
8.0 MPa, not annealed	145	°C	ISO 75-2/C
Linear thermal expansion coefficient			ASTM E831
Flow	2.5E-5	cm/cm/°C	ASTM E831
Lateral	2.5E-5	cm/cm/°C	ASTM E831

Flammability	Nominal Value	Test Method
Flame Rating		UL 94

1.60 mm	V-1	UL 94
4.00 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
Injection instructions		

Plastication: 50rpmInjection Time: 2 to 8 secHold Time: 1 to 5 sec/mmCure Time, 0.125 in: 5 to 12 sec/mmAll ISO properties listed were tested in accordance with ISO 3167The value listed as Molding Shrinkage, ISO 294-4, was tested in accordance with ISO 2577.ISO Type: PF 2 C4Density, ISO 1183, Injection Molding: 1.65 to 1.7 g/cm³Powder Density, ISO 60: >0.85 g/cm³Post Shrinkage, ISO 2577: 0.05 to 0.2%HDT A (1.80 MPa) Unannealed, ISO 75A, Injection Molding: 160 to 180°CHDT A (8.0 MPa) Unannealed, ISO 75A, Injection Molding: 135 to 155°CCLTE, Flow (TMA), ASTM E831, Injection Molding: 20 to 30 cm⁻⁶/cm°CCLTE, Transverse (TMA), ASTM E831, Injection Molding: 20 to 30 cm⁻⁶/cm°CFlexural Strength, ISO 178, Injection Molding: 80 to 100 MPaFlexural Modulus, ISO 178, Injection Molding: 13 to 15 GPaStrain to failure in Flexure, ISO 178, Injection Molding: 0.5 to 0.7%Tensile Stress at Break, ISO 527-1,-2, Injection Molding: 30 to 50 MPaCharpy Notched Impact Strength, ISO 179, Injection Molding: 1.5 to 2.5 kJ/m²Charpy Unnotched Impact Strength, ISO 179, Injection Molding: 2.5 to 4.5 kJ/m²Compressive Strength, ISO 604: 120 to 140 MPa

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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



WECHAT