

Vyncolit® X6952

Phenolic

Vyncolit N.V.

Message:

Vyncolit® X6952 is a glass fiber reinforced phenolic molding compound with superior mechanical properties: highest impact and excellent retention of mechanical properties at elevated temperatures.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 55% filler by weight		
Features	High tensile strength		
Agency Ratings	EU 2006/122/EC		
RoHS Compliance	RoHS compliance		
Appearance	Green		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PF-GF55		
Physical	Nominal Value	Unit	Test Method
Density	1.70	g/cm³	ISO 1183
Apparent Density	0.63	g/cm³	ISO 60
Molding Shrinkage	0.14	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.060	%	ISO 62
Post Shrinkage	0.010	%	ISO 2577
Flexural Strain at Break	1.6	%	ISO 178
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	18000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	132	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	1.0	%	ISO 527-2
Flexural Modulus (Injection Molded)	17000	MPa	ISO 178
Flexural Stress (Injection Molded)	255	MPa	ISO 178
Compressive Stress	300	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	4.9	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (Injection Molded)	21	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	224	°C	ISO 75-2/Af
Linear thermal expansion coefficient			TMA

Flow	1.0E-5	cm/cm/°C	TMA
Lateral	4.1E-5	cm/cm/°C	TMA
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	38	kV/mm	IEC 60243-1
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-1		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

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