

# RX® 680

Phenolic

Sumitomo Bakelite North America, Inc.

## Message:

RX® 680 is a fiberglass and glass bead filled phenolic molding compound, with good dimensional stability and good strength at elevated temperatures.

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

Physical	Nominal Value	Unit	Test Method
Density	1.72	g/cm <sup>3</sup>	ISO 1183
Apparent Density	0.70	g/cm <sup>3</sup>	ISO 60
Molding Shrinkage	0.35	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.060	%	ISO 62

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	95		ISO 2039-2

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, Compression Molded)	75.0	MPa	ISO 527-2
Flexural Modulus (Compression Molded)	14000	MPa	ISO 178
Flexural Stress (Compression Molded)	165	MPa	ISO 178
Compressive Stress	310	MPa	ISO 604

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed	190	°C	
1.8 MPa, Annealed	> 282	°C	
CLTE			ASTM E831
Flow	1.2E-5	cm/cm/°C	
Transverse	3.3E-5	cm/cm/°C	

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