

Di-Pak™ E-4671

Thermoplastic

Hapco Inc.

Message:

DI-PAK E-4600 SERIES

Flexible, high strength, 50 to 71 shore D hardness potting and encapsulating systems. Available in flame retardant (FR), 3 minute (-3) gel time, and in black or unpigmented.

General Information	
Features	Electrically Insulating
	Fast Cure
	Good Flexibility
	Low Viscosity
	Shock Absorbent
Uses	Battery Cases
	Electrical/Electronic Applications
	Power Cable Shields
	Switches
Appearance	Clear Amber
Forms	Liquid
Processing Method	Encapsulating
	Potting

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
Weight - per cubic inch	17	g	
Service Temperature	150	°C	
Gel Time ¹ (25°C)	18.0	min	ASTM D2971
Thermal Shock Test	Pass		
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	69 to 73		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	376	MPa	ASTM D638
Tensile Strength	32.3	MPa	ASTM D638
Tensile Elongation (Break)	87	%	ASTM D638
Flexural Modulus	393	MPa	ASTM D790
Flexural Strength	25.6	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method

Tear Strength ²	116	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	120	J/m	ASTM D256
Unnotched Izod Impact	No Break		ASTM D256
Thermal	Nominal Value	Unit	
Thermal Conductivity	0.22	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	4.2E+13	ohms·cm	ASTM D257
Dielectric Strength	> 14	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
1 kHz	1.90		
100 kHz	2.30		
Dissipation Factor (25°C, 100 kHz)	0.038		ASTM D150
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 65, Mix Ratio by Volume: 60		
Thermoset Mix Viscosity (25°C)	2000	cP	ASTM D4878
Demold Time (21°C)	60 to 120	min	
NOTE			
1.	100 g		
2.	Die C		

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