

Vyncolit® 2530W

Phenolic

Vyncolit N.V.

Message:

Vyncolit 2530W is a mineral and organic filled phenolic molding compound with excellent thermal properties.

General Information			
Filler / Reinforcement	Mineral filler		
	Organic filler		
Appearance	Black		
Forms	Particle		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Apparent Density	0.66	g/cm ³	ISO 60
Molding Shrinkage	0.50	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.25	%	ISO 62
Post Shrinkage	0.090	%	ISO 2577
Flexural Strain at Break - Injection Molded	1.3	%	ISO 178

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	9000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	50.0	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	0.73	%	ISO 527-2
Flexural Modulus (Injection Molded)	8000	MPa	ISO 178
Flexural Stress (Injection Molded)	95.0	MPa	ISO 178
Compressive Stress	222	MPa	ISO 604

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	2.1	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	6.5	kJ/m ²	ISO 179

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	181	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831
Flow	2.1E-5	cm/cm/°C	ASTM E831
Lateral	4.9E-5	cm/cm/°C	ASTM E831

Injection	Nominal Value	Unit
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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: 50rpm Injection Time: 2 to 8 sec Hold Time: 1 to 5 sec/mm Cure Time, 0.125 in: 5 to 12 sec/mm

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