

# Vyncolit® E 8353-706R

Epoxy; Epoxide

Vyncolit N.V.

## Message:

E 8353-706R is a fiberglass and mineral reinforced epoxy molding compound, with excellent dimensional stability good strength at elevated temperatures.

General Information	
Filler / Reinforcement	Glass \Mineral
Features	Good dimensional stability The degassing effect is low to no Low viscosity Solvent resistance Anti-salt water/fog Good thermal shock resistance Good strength Good chemical resistance alkali resistance acid resistance Non-corrosive
Uses	Electrical components Military application Connector
Agency Ratings	FDA not rated USDA Unspecified Approval
Appearance	Black
Forms	Particles
Processing Method	Resin transfer molding Compression molding Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.98	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, Compression Molded)	72.0	MPa	ASTM D638

Flexural Modulus (Compression Molded)	18000	MPa	ASTM D790
Flexural Strength (Break)	114	MPa	ASTM D790
Compressive Strength	235	MPa	ASTM D695
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (Compression Molded)	22	J/m	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (1.8 MPa, Unannealed, Compression Molded)	282	°C	ASTM D648
CLTE - Flow	2.5E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.60	W/m/K	ASTM C177
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Dielectric Strength			ASTM D149
-- <sup>1</sup>	16	kV/mm	ASTM D149
-- <sup>2</sup>	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.50		ASTM D150
Dissipation Factor (1 MHz)	0.010		ASTM D150
Arc Resistance	180	sec	ASTM D495
<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>	
Middle Temperature	60.0 - 82.2	°C	
Nozzle Temperature	82.2 - 93.3	°C	
Processing (Melt) Temp	93.3 - 116	°C	
Mold Temperature	149 - 177	°C	
Injection Pressure	34.5 - 68.9	MPa	
Holding Pressure	13.8 - 34.5	MPa	
Back Pressure	0.345	MPa	
<b>Injection instructions</b>			
<p>Gauge: 0.3The value listed as Thermal Conductivity, ASTM C177, was tested in accordance with ASTM C518. Water Absorption, ASTM D570, 48 hrs, 50°C: 0.14%DTUL @264psi - Unannealed, ASTM D648, Post Baked, Compression Molded: &gt;282°CDielectric Strength, ASTM D149, 60 Hz, Method B, wet: 14.2 kV/mmDielectric Strength, ASTM D149, 60 Hz, Method A, wet: 16.4 kV/mmDielectric Strength, ASTM D149, 60 Hz, Method B, dry: 15.2 kV/mmDielectric Strength, ASTM D149, 60 Hz, Method A, dry: 17.1 kV/mmDielectric Constant, ASTM D150, 1000000 Hz, wet: 4.5Dissipation Factor, ASTM D150, 1000000 Hz, wet: 0.01Compression and Transfer Molding Conditions:  Preheat Temperature: 180 to 225 °F  Mold Temperature: 325 to 370 °F  Compression Mold Pressure: 1000 to 5000 psi  Transfer Mold Pressure: 1500 to 8000 psi  Cure Time, 0.125 in: 60 to 90 sec</p>			
<b>NOTE</b>			
1.	Method A (short time)		
2.	Method B (step by step)		

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