NOVALAC RX®611V

Phenolic

Vyncolit N.V.

Message:

NOVALAC RX®611V is a phenolic (Phenolic) material, and its filler is glass fiber reinforced material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing methods are: resin transfer molding, compression molding or injection molding.
NOVALAC RX®The main features of 611V are:
chemical resistance
high strength
Creep resistance
Good dimensional stability
Good toughness
Typical application areas include:
Electrical/electronic applications
engineering/industrial accessories
electrical appliances
House
Tools

General Information	
Filler / Reinforcement	Glass fiber reinforced material
Features	Ultra high toughness Good dimensional stability Low smoke High strength Antibacterial property Solvent resistance Good creep resistance alkali resistance acid resistance
Uses	Membrane key switch Pump parts Gear Electrical/Electronic Applications Electrical appliances Power/other tools Connector Application in Automobile Field Shell
Forms	Particles
Processing Method	Resin transfer molding Compression molding

Physical	Nominal Value	Unit	Test Method
Density	1.67	g/cm³	ISO 1183
Molding Shrinkage - Flow	0.15	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.070	%	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)	115	MPa	ISO 527-2
Flexural Modulus	16000	MPa	ISO 178
Flexural Stress	130	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	2.5	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	195	°C	ISO 75-2/A
CLTE - Flow	1.2E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.47	W/m/K	ASTM C177
Electrical	**Nominal Value**	**Unit**	**Test Method**
Dielectric Strength	10	kV/mm	IEC 60243-1
Arc Resistance	125	sec	ASTM D495
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	
Back Pressure	0.207	MPa	

Injection instructions

Plastication: 50rpmInjection Pressure: Set to give 3 to 5 seconds injection timeHold Pressure: 50 to 100% of injection pressureHold Time: 10 sec minimumCure Time, 0.125 in: 30 to 35 secThe value listed as Thermal Conductivity, ASTM C177, was tested in accordance with ASTM C518.The value listed as Molding Shrinkage, ISO 294-4, was tested in accordance with ISO 2577 using compression molded specimens.Compressive Strength, ISO 604: 320 MPaDielectric Strength, IEC 243, Method A, wet: 10 V/milCompression and Transfer Molding Conditions:
Preforming Pressure: 8000 to 12000 psi
Preheat Temperature: 210 to 235 °F
Preheat Time: 45 sec
Mold Temperature: 330 to 360 °F
Compression Mold Pressure: 2500 to 5000 psi
Transfer Mold Pressure: 4000 to 6000 psi
Cure Time, 0.125 in: 40 to 50 sec

Recommended distributors for this material

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