

Vyncolit® X6360

Phenolic

Vyncolit N.V.

Message:

Vyncolit X6360 is a glass fiber and mineral filled phenolic molding compound with excellent mechanical and thermal properties.

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

Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm³	ISO 1183
Molding Shrinkage - Flow	0.12 - 0.22	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	10000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	60.0	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	0.85	%	ISO 527-2
Flexural Modulus (Injection Molded)	8000	MPa	ISO 178
Flexural Stress (Injection Molded)	130	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	5.0	kJ/m²	ISO 179
Charpy Unnotched Impact Strength	14	kJ/m²	ISO 179

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	200	°C	ISO 75-2/A
8.0 MPa, not annealed	175	°C	ISO 75-2/C
Linear thermal expansion coefficient			ASTM E831
Flow	2.5E-5	cm/cm/°C	ASTM E831
Lateral	4.0E-5	cm/cm/°C	ASTM E831

Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	30	kV/mm	IEC 60243-1
Comparative Tracking Index	175	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Flame Rating (4.00 mm)	HB		UL 94

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
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 All ISO properties listed were tested in accordance with ISO 3167 The value listed as Molding Shrinkage, ISO 294-4, was tested in accordance with ISO 2577. ISO Type: PF 2 C3 Powder Density, ISO 60: 0.6 to 0.75 g/cm³ Post Shrinkage, ISO 2577: 0.01 to 0.08% HDT A (1.80 MPa) Unannealed, ISO 75A, Injection Molding: 190 to 210°C HDT A (8.0 MPa) Unannealed, ISO 75A, Injection Molding: 165 to 185°C CCLTE, Flow (TMA), ASTM E831, Injection Molding: 20 to 30 cm⁻⁶/cm°C CCLTE, Transverse (TMA), ASTM E831, Injection Molding: 35 to 45 cm⁻⁶/cm°C Flexural Strength, ISO 178, Injection Molding: 120 to 140 MPa Flexural Modulus, ISO 178, Injection Molding: 7 to 9 GPa Strain to failure in Flexure, ISO 178, Injection Molding: 1.5 to 1.6% Tensile Stress at Break, ISO 527-1,-2, Injection Molding: 50 to 70 MPa Tensile Modulus, ISO 527-1,-2, Injection Molding: 9 to 11 GPa Tensile Strain at Break, ISO 527-1,-2, Injection Molding: 0.8 to 0.9% Charpy Notched Impact Strength, ISO 179, Injection Molding: 4 to 6 kJ/m² Charpy Unnotched Impact Strength, ISO 179, Injection Molding: 13 to 15 kJ/m² Compressive Strength, ISO 604: 160 to 190 MPa

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