RESOLE FM 4008

Phenolic

Vyncolit N.V.

Message:

FM 4008 is a fiberglass and mineral reinforced phenolic resole compound, with excellent dimensional stability and good strength at elevated temperatures.

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.80	g/cm³	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.20	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method

Rockwell Hardness (E-Scale)	80		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, Compression Molded)	50.0	MPa	ASTM D638
Flexural Modulus (Compression Molded)	14000	MPa	ASTM D790
Flexural Strength (Break)	140	MPa	ASTM D790
Compressive Strength	240	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (Compression Molded)	27	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed, Compression Molded)	265	°C	ASTM D648
CLTE - Flow	1.9E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Arc Resistance	180	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	
Injection Pressure	100 - 248	MPa	
Holding Pressure	30.0 - 89.6	MPa	
Back Pressure	4.83 - 15.2	MPa	

Injection instructions

Plastication: 50rpmInjection Time: 2 to 8 secHold Time: 1 to 5 sec/mmCure Time, 0.125 in: 5 to 12 sec/mmAll ASTM properties listed were tested in accordance with ASTM D5948.Powder Density, ASTM D1895: 0.8 g/cm^{3}Water Absorption, ASTM D570, 48 hrs, 50°C: 0.35%DTUL @264psi - Unannealed, ASTM D648, Post Baked, Compression Molded: >282°C

Recommended distributors for this material

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