

NOVALAC RX®867G

Phenolic

Vyncolit N.V.

Message:

NOVALAC RX®867G is a phenolic (Phenolic) material, and the 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 867G are:

- flame retardant/rated flame
- chemical resistance
- high strength
- Creep resistance
- Good dimensional stability
- 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	Particle
Processing Method	Resin transfer molding
	Compression molding

Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.76	g/cm ³	ASTM D792, ISO 1183
Bulk Factor	3.2		ASTM D1895
Molding Shrinkage			
Flow: Molding	0.20	%	ASTM D955
Flow direction	0.20	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.090	%	ASTM D570
23°C, 24 hr	0.060	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
E scale	80		ASTM D785
E scale	85		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Fracture	60.0	MPa	ISO 527-2
--	48.3	MPa	ASTM D638
Flexural Modulus			
--	14500	MPa	ASTM D790
--	16000	MPa	ISO 178
Flexural Strength			
--	89.6	MPa	ASTM D790
--	100	MPa	ISO 178
Compressive Strength	197	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
--	43	J/m	ASTM D256A
--	3.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	182	°C	ASTM D648
1.8 MPa, not annealed	190	°C	ISO 75-2/A
Linear thermal expansion coefficient			
Flow	3.0E-5	cm/cm/°C	ASTM D696
Lateral	3.6E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.77	W/m/K	ASTM C177
RTI Elec	150	°C	UL 746
RTI Imp	150	°C	UL 746
RTI	150	°C	UL 746
Electrical	Nominal Value	Unit	Test Method

Dielectric Strength			
-- ¹	10	kV/mm	ASTM D149
-- ²	9.3	kV/mm	ASTM D149
--	11	kV/mm	IEC 60243-1
Arc Resistance	190	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.59 mm	V-1		UL 94
3.18 mm	V-0		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	
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 F433.The value listed as Molding Shrinkage, ISO 294-4, was tested in accordance with ISO 2577 using compression molded specimens.Water Absorption, ASTM D570, 48 hrs, 50°C: 0.25%Flexural Strain, ASTM D790: 0.61%DTUL @264psi - Unannealed, ASTM D648, Post Baked: 550°FDielectric Strength, ASTM D149, 60 Hz, Method A, dry: 260 V/milDielectric Strength, ASTM D149, 60 Hz, Method B, dry: 235 V/milCompressive Strength, ISO 604: 215 MPaDielectric Strength, IEC 243, Method A, wet: 10.5 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			
NOTE			
1.	Method A (short time)		
2.	Method B (step by step)		

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