

Vyncolit® X640

Phenolic

Vyncolit N.V.

Message:

Vyncolit® X640 is a glass fiber reinforced resol resin based molding material with excellent mechanical and thermal properties.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Resin transfer molding		
	Compression molding		
	Injection molding		
Part Marking Code (ISO 11469)	>PF-GF50		
Physical	Nominal Value	Unit	Test Method
Density	1.71	g/cm ³	ISO 1183
Apparent Density	0.64	g/cm ³	ISO 60
Molding Shrinkage - Flow	0.19	%	ISO 2577
Water Absorption (23°C, 24 hr)	0.10	%	ISO 62
Post Shrinkage	0.070	%	ISO 2577
Flexural Strain at Break	1.6	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	17000	MPa	ISO 527-2
Tensile Stress (Break, Injection Molded)	138	MPa	ISO 527-2
Tensile Strain (Break, Injection Molded)	1.0	%	ISO 527-2
Flexural Modulus (Injection Molded)	16000	MPa	ISO 178
Flexural Stress (Injection Molded)	254	MPa	ISO 178
Compressive Stress	308	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	5.4	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	21	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Linear thermal expansion coefficient			ISO 11359-2
Flow	8.0E-6	cm/cm/°C	ISO 11359-2
Lateral	4.6E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	34	kV/mm	IEC 60243-1

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/mm

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