

Di-Pak™ E-4650-3

Thermoplastic

Hapco Inc.

Message:

DI-PAK E-4600 SERIES

Flexible, high strength, 50 to 71 shore D hardness potting and encapsulating systems. Available in flame retardant (FR), 3 minute (-3) gel time, and in black or unpigmented.

General Information	
Features	Electrically Insulating
	Fast Cure
	Good Flexibility
	Low Viscosity
	Shock Absorbent
Uses	Battery Cases
	Electrical/Electronic Applications
	Power Cable Shields
	Switches
Appearance	Black
Forms	Liquid
Processing Method	Encapsulating
	Potting

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D2566
Weight - per cubic inch	17	g	
Service Temperature	125	°C	
Gel Time ¹ (25°C)	3.0	min	ASTM D2971
Thermal Shock Test	Pass		
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	47 to 50		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	131	MPa	ASTM D638
Tensile Strength	12.4	MPa	ASTM D638
Tensile Elongation (Break)	280	%	ASTM D638
Flexural Modulus	80.7	MPa	ASTM D790
Flexural Strength	5.79	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method

Tear Strength ²	62.3	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	75	J/m	ASTM D256
Unnotched Izod Impact	230	J/m	ASTM D256
Thermal	Nominal Value	Unit	
Thermal Conductivity	0.22	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	7.4E+15	ohms·cm	ASTM D257
Dielectric Strength	> 14	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
1 kHz	3.10		
100 kHz	2.90		
Dissipation Factor (25°C, 100 kHz)	0.031		ASTM D150
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 85, Mix Ratio by Volume: 80		
Thermoset Mix Viscosity (25°C)	870	cP	ASTM D4878
Demold Time (21°C)	20 to 35	min	
NOTE			
1.	100 g		
2.	Die C		

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