

Di-Pak™ R-4525/7

Thermoplastic

Hapco Inc.

Message:

RIGID
DI-PAK R-4525 Series

A general purpose series of low viscosity, strong, potting and encapsulating compounds. DI-PAK R-4525 has excellent electrical insulating properties and bonds well to many substrates. By varying the curing agents, the desired cure and working life can be obtained.

General Information			
Features	Electrically Insulating		
	Good Processability		
	Good Toughness		
	High Heat Resistance		
	High Strength		
	Low Viscosity		
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	1.51	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.050 to 0.20	%	ASTM D2566
Weight - per cubic inch	25	g	
Service Temperature	155	°C	
Gel Time ¹ (25°C)	50.0	min	ASTM D2971
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	95		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2740	MPa	ASTM D638
Tensile Strength	62.4	MPa	ASTM D638
Tensile Elongation (Break)	1.1	%	ASTM D638
Flexural Modulus	2770	MPa	ASTM D790
Flexural Strength	69.6	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	24	J/m	ASTM D256
Unnotched Izod Impact	35	J/m	ASTM D256
Thermal	Nominal Value	Unit	
Thermal Conductivity	0.43	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.6E+13	ohms·cm	ASTM D257
Dielectric Strength	26	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
1 kHz	4.30		
100 kHz	4.20		
Dissipation Factor (25°C, 100 kHz)	7.0E-3		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: 13, Mix Ratio by Volume: 20		
Thermoset Mix Viscosity (25°C)	12500	cP	ASTM D4878
Demold Time			
21°C	960 to 1400	min	
66°C	120 to 240	min	
NOTE			
1.	100 g		

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