

Di-Pak™ R-4354

Thermoplastic

Hapco Inc.

Message:

RIGID
DI-PAK R-4354

A 100% solids, room temperature cure, dielectric insulating material used for sealing, coating, bonding and potting. R-4354 is a medium viscosity, slightly thixotropic system.

General Information			
Features	Electrically Insulating		
	Good Processability		
	Good Toughness		
	High Heat Resistance		
	Medium Viscosity		
	Thixotropic		
Uses	Battery Cases		
	Electrical/Electronic Applications		
	Power Cable Shields		
	Switches		
Appearance	Tan		
Forms	Liquid		
Processing Method	Encapsulating		
	Potting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.050 to 0.15	%	ASTM D2566
Weight - per cubic inch	18	g	
Service Temperature	80	°C	
Gel Time ¹ (25°C)	40.0 to 60.0	min	ASTM D2971
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2460	MPa	ASTM D638
Tensile Strength	48.3	MPa	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	2690	MPa	ASTM D790
Flexural Strength	53.1	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	27	J/m	ASTM D256
Unnotched Izod Impact	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	
Thermal Conductivity	0.22	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.4E+14	ohms·cm	ASTM D257
Dielectric Strength	18	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
1 kHz	3.40		
100 kHz	3.10		
Dissipation Factor (25°C, 100 kHz)	0.018		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: 96, Mix Ratio by Volume: 100		
Thermoset Mix Viscosity ² (25°C)	9500	cP	ASTM D4878
Demold Time (21°C)	720 to 1100	min	
NOTE			
1.	100 g		
2.	Range: 7000 to 12000		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

