



# Resinoid Engineering Corporation

Compound Number 2277
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7557 N. ST. LOUIS AVE . SKOKIE, IL 60076. PHONE (847) 673-1050 . FAX (847) 673-2160 . WWW.RESINOID.COM

Resinoid 2277 is a chopped fabric reinforced, two-step phenolic molding compound. It was specifically developed for molding applications where a lightweight, high strength material with good impact strength is needed. This material comes in pelletized form and is suitable for transfer or compression molding and can be used in injection molding systems with deep flight screws. Resinoid 2277 meets the requirements of ASTM D-5948 CFI-20 (Formerly MIL M14/1 CFI-20).

<u>MATERIAL PROPERTIES</u>	ASTM	ISO	US UNIT	SI UNIT
FORM			PELLET	PELLET
SHRINKAGE-MOLDED (POSITIVE MOLD)	D955	2577	0.002 in/in	0.2%
COLOR			BLACK	BLACK
<u>MECHANICAL AND PHYSICAL PROPERTIES</u>				
SPECIFIC GRAVITY	D792A	1183	1.41	1.41 <sub>23</sub> <sup>23</sup>
WATER ABSORPTION (24 HR. R.T.)	D570	62-1	0.8%	0.8%
TENSILE STRENGTH	D651	R527-3	6,000 psi	41 MPa
FLEXURAL STRENGTH	D790	178	13,100 psi	90 MPa
MODULUS IN FLEX	D790	178	1.3x10 <sup>6</sup> psi	0.9x10 <sup>4</sup> MPa
IMPACT (IZOD, NOTCHED)	D256A	180/2A	2.0 ft-lb/in	6.83 kJ/m <sup>2</sup>
COMPRESSIVE STRENGTH	D695	604	22,200 psi	153 MPa
<u>ELECTRICAL PROPERTIES</u>				
DIELECTRIC STRENGTH (S.T.) DRY	D149	IEC243	320 V/mil	12.6 kV/mm
ARC RESISTANCE	D495		125 sec	125 sec
<u>THERMAL PROPERTIES</u>				
FLAME RESISTANCE	UL94		94 V-0 (1/4")	

The above values are typical of standard procedures such as ASTM. No assurance is given that the above data will be duplicated. Results can be affected by many variables including part design, storage and mold design. NO GUARANTEE, WARRANTY or REPRESENTATION, express or implied, is made for the performance or stability of Resinoid molding materials. Each user must conduct their own tests to determine the suitability of Resinoid molding materials for their particular application.