



Formerly Dexter

Technical Data Sheet

HYSOL MG36F-0540

Epoxy Molding Compound

Description

Hysol MG36F-0540 is an epoxy based molding compound designed for high volume molding of resistor networks. It has been developed to provide optimum moisture protection and resistance to “popcorning”. MG36F-0540 is especially recommended for conventional transfer molding and plate molding applications. It’s gold color provides excellent contrast for laser mark applications.

Typical Uncured Properties

	MG36F-0540	Test Method
Color	Gold	Visual
Hot Plate Gel Time @ 127°C, seconds	21	STP 10S
Spiral Flow, inches @ 177°C, as produced	26	STP10P
Shelf Life @ 10°C, months from date of manufacture	8	STP 10P
Flash, mm	2	STP 86A
2 mil channel		
1 mil channel	1	
.5 mil channel	1	
.25 mil channel	1	

Typical Cured Properties

All measurements taken at 21°C unless otherwise noted. All physical, electrical and analytical measurements taken on specimens cured for two minutes at 177°C and post cure for 6 hours at 177°C, unless otherwise specified.

	MG36F-0540	Test Method
Glass Transition Temperature, °C	162	STP 65B
Coefficient of Thermal Expansion, in/in/°C		STP 65B
(80-100°C)	15 x 10 ⁻⁶	
(200-240°C)	60 x 10 ⁻⁶	
Specific Gravity	1.91	RTP 549A
Flammability Rating	pass	STP 95A
Linear Shrinkage, as molded, in/in	0.004	STP 56C
Hot Hardness, Shore D, minimum	85	STP 11C
Tensile Strength, psi	12,800	STP 38B

	MG36F-0540	Test Method
Flexural Strength, psi	19,100	STP 39A
Flexural Modulus, psi	2.6 x 10 ⁶	STP 39A
Water Extract Data, 20 hour water boil,		STP 72A
chloride content, ppm	13	
sodium content, ppm	2	
pH	4.2	

Handling

Although molding and curing conditions will vary from situation to situation, recommended starting ranges are shown below.

Preheat Temperature, °C	75 - 95
Molding Temperature, °C	160 - 180
Molding Pressure, psi	500 - 1500
Curing Time, 1/8 inch section, seconds, @ 177°C	90 - 120
Post Cure Time (if needed), hours @ 177°C	4 - 6

Storage

Powder or Preforms should be stored at 10°C, or below, in closed containers. After removal from cold storage, the material **MUST** be allowed to come to room temperature, in the sealed container, to avoid moisture contamination. The suggested waiting time is 24 hours.

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Users should review the Material Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and label are available upon request
