



Hysol MG27F-0521 LF

September 2018

PRODUCT DESCRIPTION

Hysol MG27F-0521 LF is a specially formulated product designed for use in high volume molding of ceramic capacitors. MG27F-0521 LF was developed to provide optimum moldability in conventional transfer molding applications. It features good moisture resistance and low ionics. It's gold color provides excellent contrast in lasermark applications.

TYPICAL UNCURED PROPERTIES

Color	Gold
Spiral Flow, inches @ 149°C, as produced	20
Hot Plate Gel Time @ 160°C, seconds	25
Flash, mm	2
2 mil channel	2
1 mil channel	1
½ mil channel	1.5
¼ mil channel	1.5
Shelf Life @ 50°F, months from date of manufacture	6

TYPICAL CURED PROPERTIES

All measurements taken at 21°C unless otherwise noted. All physical, electrical and analytical measurements taken on specimens cured for five minutes at 149°C with no post cure, unless otherwise specified.

Glass Transition Temperature, °C	167
Coefficient of Thermal Expansion, in/in/°C	
25° - 125°C, x 10 ⁻⁶	21
150° - 220°C, x 10 ⁻⁶	67
Linear Shrinkage, as molded, in/in	0.004
Specific Gravity	1.91
Flammability Rating @ 1/8" thickness	V-0
Oxygen Index	33
Flexural Strength, psi	18,200
Flexural Modulus, psi, x 10 ⁶	2.7
Shore D Hardness, 90 seconds	@ 160°C 90
	@ 25°C 95
Water extract data, 20 hour water boil,	
Chloride content, ppm	3
Sodium content	4
Conductivity, micromhos	48
pH	8

TYPICAL CURED ELECTRICAL PROPERTIES

Dielectric Strength, volts per mil	1130
Dielectric Constant	
100 Hz	5.0
100 kHz	4.0
Dissipation Factor	
100 Hz	0.008
100 kHz	0.017
Volume Resistivity, ohm/cm, x 10 ¹⁵	8.9
Surface Resistivity, ohms, x 10 ¹⁶	5.5

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	145-177
Molding Pressure, psi	500-1500
Cure, 1/8" section, @ 149°C, seconds	75
Post Cure Time, hours @ 149°C	2-4

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

STORAGE

Powder Storage – Powder or performs should be stored at 5°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 for a standard 22 Kg pail is 24 hours.

DATA RANGES

The data contained herein may be reported as a typical value and/or range values based on actual test data and are verified on a periodic basis.

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Hysol Huawei is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

TRADEMARK USAGE

Except as otherwise noted, all trademarks in this document are trademarks of Hysol Huawei in P.R.C and elsewhere.

NOT FOR PRODUCT SPECIFICATIONS
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT HYSOL HUAWEI QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.