

01-96 Alkyd Vinyl Mould Plate

Composition

01-96 mica moulding plate is a hot forming plate conforming to NEMA grade 2. Alkyd Vinyl resin binder in 01-96 is partially cured, it will soften under heat and facilitate good moulding. There are many different grades of 01-96 available depending on the type of mica used, binder content, surface characteristics etc.

Applications

For hot moulding of intricate parts, such as mica commutator cones, end bell insulation, slot cells, coil forms, tubes etc.

Processing

The layout consisting of the required number of layers of thin mica moulding plates (cut to definite shape), is set in a pre determined pattern. It is then heated uniformly to a temperature of 160°C – 200°C, till it becomes soft. It takes the required form when moulded under pressure. It retains its form when cooled under pressure. The duration, temperature and pressure will have to be determined by application. These moulded parts, if required, can be fully cured under heat and pressure for several more hours to develop their full properties.

Typical curing schedule for hot moulded parts:

Temperature	180°C – 220 °C
Pressure	14 - 35 kg/cm ²
Duration	4 to 8 hrs

Exact curing schedules are to be arrived at by the users, depending on the desired final properties of the moulded parts.

Product Data

Property	Unit	Value
Thermal Classification	°C	155
Thickness	mm	0.25 - 1.5
Thickness Tolerance	mm	Avg. - Upto 24 mil (0.6 mm) ± 0.025; Over 24 mil ± 0.050; Individual ± 0.075
Binder Content	%	07 - 20
Mouldability		When 2 inch wide strip is heated (135°C – 150 °C) & moulded over a mandrel of specified dia., no deflaking to be observed
Dielectric Strength	kV/mm	> 20

08/00



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Shelf Life

Six months at 20°C from the date of manufacturing.

Different Grades

Code No.	Type of Mica	Binder Content,%	Milled/Unmilled
01-96-02	5,5 ^{1/2} DL Ruby	12 - 16	Unmilled
01-96-04	6 DL /6 1st Ruby	08 - 12	Milled
01-96-05	6 DL/6 1st Ruby	07 - 10	Milled
01-96-06	6 1st Ruby	14 - 20	Unmilled
01-96-11	6 1st Ruby	12 - 18	Milled
01-96-12	6 1st Ruby	14 - 18	Milled

Available size of sheets

900 mm X 900 mm ± 10 mm and 1050 mm X 780 mm ± 10 mm
900 mm X 450 mm ± 10 mm and 780 mm X 525 mm ± 10 mm