



THE GUND COMPANY

MANUFACTURERS & FABRICATORS OF ENGINEERED MATERIAL SOLUTIONS

NEMA FR4 - Glass Epoxy Laminate

Item:	NEMA Grade FR4 Glass Epoxy Laminate			
Description:	NEMA Grade FR4 materials are glass fabric reinforced laminates, bonded with flame resistant epoxy resin. The material has the ability to maintain excellent mechanical, electrical and physical properties at elevated temperature to 130 °C. FR4 from The Gund Company is UL, RoHS, and REACH certified to ensure reliability, safety, and consistency (UL File No. E339275).			
Standards:	NEMA LI-1: Grade FR4 • MIL-I-24768/27 GEE-F • IEC 60893: EP GC 202 (sheet)			
Availability:	Laminate Sheets:		English Units (in)	SI Units (mm)
		Thickness:	0.010 - 5.0	0.125 - 127
	Sheet Size:	48 x 120	122 x 305	
	Convolute Tubing:	FR4 convolute tubes are available from The Gund Company in nearly any custom size of inside and outside diameter, per customer requirements.		
Fabricated Parts:	The Gund Company custom fabricates insulation materials to the exact specifications and drawings specified by our customers.			

Key Characteristics	Units - English (SI)	Typical Values
Standard Color	--	Green ¹
Density	lbs/in ³ (g/cc)	0.067 (1.85)

¹ Custom colors available upon request

NEMA LI-1 FR4 Required Properties

Key Characteristics	Test Method	Units - English (SI)	NEMA Required	Typical Values	
Breakdown Voltage (0.062")	Condition A	ASTM D-149	kV	45 min	66
	Condition D-48/50			40 min	65
Permittivity at 1 MHz (0.062")	Condition A	ASTM D-150	--	5.2 max	4.4
	Condition D-24/23			5.4 max	4.5
Dissipation Factor at 1 MHz (0.062")	Condition A	ASTM D-150	--	0.025 max	0.014
	Condition D-24/23			0.035 max	0.015
IZOD Strength (0.062")	Lengthwise	ASTM D-229	ft-lb/in Notched	7.0 min	13
	Crosswise			5.5 min	12
Flexural Strength (0.062")	Lengthwise	ASTM D-790	ksi (MPa)	60.0 (414) min	80 (552)
	Crosswise			50.0 (345) min	70 (483)
Bonding Strength (0.500")	Lengthwise	ASTM D-229	Lb (kg)	2000 (907) min	2,500 (1,133)
	Crosswise			1600 (725) min	1,900 (862)
Moisture Absorption (0.125")	ASTM D-570	%	0.15 max	0.10	
Flammability Rating	UL94	Class	V-I	V-0	



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IEC 60893-3-2 EPGC 202 Required Properties

Key Characteristics	Test Method	Units	IEC Requirement	Typical Values
Flexural Strength	ISO 178	MPa	340 min	560
Charpy Impact Strength	ISO 179	kJ/m ²	33 min	49
Perpendicular Electric Strength (90 °C in Oil, 1.5mm)	IEC 60243-1	kV/mm	13 min	25
Parallel Breakdown Voltage (Stepped, 90 °C in Oil, 3mm)	IEC 60243-1	kV	35 min	>45
Insulation Resistance (After Water Immersion)	--	MΩ	5(10) ⁴	>10 ⁷
Flammability Rating	UL94	Class	V-0	V-0
Moisture Absorption (1.5mm)	--	mg	19 max	13

Additional Engineering Properties

Key Characteristics	Test Method	Units - English (SI)	Typical Values
Tensile Strength (0.125"), Lengthwise	ASTM D-638	ksi (MPa)	62 (430)
Compressive Strength, Flatwise (0.50")	ASTM D-695	ksi (MPa)	66 (455)
Flexural Modulus (0.062")	--	Lengthwise	2,900 (20)
		Crosswise	2,600 (18)
Shear Strength (punch type, 0.062")	ASTM D-732	psi (MPa)	21,500 (148)
Coefficient of Thermal Expansion	ASTM E-228	" / °C x 10 ⁻⁶	15
Temperature Index	ASTM D-2304	°C	130
Glow Wire Flame Index & Ignition Temperature	IEC 60695-2-12	°C	960
Hot Wire Ignition	UL 746A	Sec	120
High Current Arc Ignition (3mm)	UL 746A	Arcs	120
Arc Resistance (0.125")	ASTM D-495	Sec	140
Comparative Tracking Index (0.125")	ASTM D-3638*	V	230
Dielectric Strength (Condition A)	ASTM D-149	V/mil	635
Volume Resistivity (0.062")	ASTM D-257	Ω - cm	3(10) ¹⁵
High Voltage Arc Resistance	UL 746A	Sec	300
High Voltage Arc Tracking Rate	UL 746A	mm/min	0

*ASTM D-3638 & IEC 112 are the same test method - IEC 60112 is slightly different, but the results are similar.

Data supplied above are typical values and are not to be considered specification values. All of the information, suggestions and recommendations pertaining to the properties and uses of the products herein are based upon tests and data believed to be accurate; however, the final determination regarding suitability of any material described herein for the contemplated application, the manner of such use, and whether the use infringes any patents is the sole responsibility of the user. There is no warranty, expressed or implied, including, without limitation warranty of merchantability or fitness for a particular purpose. Under no circumstances shall we be liable for incidental or consequential loss or damage.