

# Plenco 03557 (Compression)

Phenolic  
Plastics Engineering Co.

Message:

PLENCO 03557 is a woodflour and mineral filled phenolic molding compound offering excellent dielectric strength values at elevated temperatures while maintaining mechanical strength properties. UL recognized under component file E40654. 03557 is available in black.

General Information			
UL YellowCard	E40654-100708442		
Filler / Reinforcement	Mineral filler		
	Wood flour		
Features	Good electrical performance		
	Good strength		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.64	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.53	%	ASTM D955
Water Absorption (24 hr)	0.53	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	78		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8490	MPa	ASTM D638
Tensile Strength	50.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	7690	MPa	ASTM D790
Flexural Strength	84.8	MPa	ASTM D790
Compressive Strength	184	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	18.7	J/m	ASTM D256
Notched Izod Impact	17	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	176	°C	ASTM D648
Continuous Use Temperature	194	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	2.4E+13	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- <sup>1</sup>	14	kV/mm	ASTM D149
-- <sup>2</sup>	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.10		ASTM D150
Dissipation Factor (1 MHz)	0.042		ASTM D150
Arc Resistance	141	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	26	%	ASTM D2863

#### Additional Information

The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard. The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.36% Heat Resistance, ASTM D794: 194°C Drop Ball Impact, PLENCO Method: 111 J/m

Injection	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	0.50	hr
Mold Temperature	165 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

#### Injection instructions

Mold Close Time: 3-8 sec

#### NOTE

1. Method A (short time)
2. Method B (step by step)

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