

# Plenco 02308 (Compression)

Phenolic  
Plastics Engineering Co.

Message:

PLENCO 02308 is a general purpose organic filled phenolic molding compound, offering improved heat resistance and optimized cure properties. UL recognized under component file E40654. 02308 is available in black or brown color.

General Information			
UL YellowCard	E40654-231584		
Filler / Reinforcement	Organic filler		
Features	Fast curing		
	Heat resistance, high		
	General		
Uses	General		
UL File Number	E40654		
Appearance	Brown		
	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	0.61	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.48	%	ASTM D955
Water Absorption (24 hr)	0.39	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	89		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8530	MPa	ASTM D638
Tensile Strength	52.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	8220	MPa	ASTM D790
Flexural Strength	93.5	MPa	ASTM D790
Compressive Strength	212	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	19.2	J/m	ASTM D256
Notched Izod Impact	19	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	200	°C	ASTM D794
CLTE - Flow	7.4E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.41	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	9.8E+11	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.80		ASTM D150
Dissipation Factor (1 MHz)	0.041		ASTM D150
Arc Resistance	122	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

#### 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. The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.25% Heat Resistance, ASTM D794: 200°C Drop Ball Impact, PLENCO Method: 115 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

- Method A (short time)

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#### Recommended distributors for this material

### Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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