

Plenco 02311 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02311 is a versatile general purpose organic filled phenolic molding compound offering excellent mold processability and optimized cure cycles. PLENCO 02311 is also granulated to provide improved pourability characteristics for cold powder compression molding. UL recognized under component file E40654. 02311 is available in black or brown color.

General Information			
UL YellowCard	E40654-231585		
Filler / Reinforcement	Organic filler		
Features	Workability, good		
	Fast curing		
	General		
Uses	General		
UL File Number	E40654		
Appearance	Brown		
	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792
Apparent Density	0.62	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.74	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8350	MPa	ASTM D638
Tensile Strength	51.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	7510	MPa	ASTM D790
Flexural Strength	72.7	MPa	ASTM D790
Compressive Strength	203	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	19.6	J/m	ASTM D256
Notched Izod Impact	18	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	168	°C	ASTM D648
Continuous Use Temperature	199	°C	ASTM D794
CLTE - Flow	6.4E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	6.0E+11	ohms·cm	ASTM D257
Dielectric Strength ¹	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.50		ASTM D150
Dissipation Factor (1 MHz)	0.060		ASTM D150
Arc Resistance	142	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	27	%	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: 0.31% Heat Resistance, ASTM D794: 199°C Drop Ball Impact, PLENCO Method: 99 J/m

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

Injection instructions

Transfer Time: 3-8 sec Transfer Pressure: 5.5-6.9 MPa Preheating Temperature: 104-115°C

NOTE

- Method A (short time)

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