

Bakelite® PF 6680

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, filled with glass fibre and glass beads, low abrasion, good chemical resistance

Application Areas

Piston elements, guidance elements

General Information			
Filler / Reinforcement	Glass Bead		
	Glass Fiber		
Features	Good Abrasion Resistance		
	Good Chemical Resistance		
	Good Dimensional Stability		
	High Heat Resistance		
	High Strength		
	Low Shrinkage		
Uses	Automotive Applications		
Processing Method	Compression Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.73	g/cm ³	ISO 1183
Apparent Density	0.75	g/cm ³	ISO 60
Molding Shrinkage ¹	0.25	%	ISO 2577
Water Absorption - 24h/23C	9.0	mg	ISO 62
Post Shrinkage ²	0.050	%	ISO 2577
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	450	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	20000	MPa	ISO 527-2/1
Tensile Stress	115	MPa	ISO 527-2/5
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress ³	180	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	14	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	165	°C	ISO 75-2/C
Injection	Nominal Value	Unit	
Rear Temperature	60.0 to 75.0	°C	
Nozzle Temperature	80.0 to 100	°C	
Processing (Melt) Temp	80.0 to 100	°C	
Mold Temperature	160 to 190	°C	
Injection Pressure	> 15.0	MPa	
Back Pressure	0.500 to 2.00	MPa	
NOTE			
1.	Injection		
2.	Injection		
3.	2.0 mm/min		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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

