

LONGLITE® PMC T 385 J70

Phenolic

CCP Group

Message:

PMC T 385 J70 is a wood flour- and mineral-reinforced phenolic injection moulding compound with improved heat resistance

General Information			
Filler / Reinforcement	Mineral filler		
	Wood flour		
Features	Solvent resistance		
	Good formability		
	Good electrical performance		
	Good chemical resistance		
	Good wear resistance		
	Good weather resistance		
	Fuel resistance		
	Heat resistance, high		
	Oil resistance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage	0.80 - 1.3	%	ISO 2577
Water Absorption			
24 hr	0.33	%	ASTM D570
23°C, 24 hr	0.33	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	41.0	MPa	ISO 527-2
--	41.0	MPa	ASTM D638
Flexural Strength	95.0	MPa	ASTM D790, ISO 178
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	164	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	2.4E+10	ohms	ASTM D257, IEC 60093
Volume Resistivity	1.0E+12	ohms · cm	ASTM D257, IEC 60093
Dielectric Strength (2.00 mm)	10	kV/mm	ASTM D149, IEC 60243-1

Flammability	Nominal Value	Unit	Test Method
Flame Rating (6.34 mm)	V-0		UL 94
Additional Information			
Spiral Flow, CCP: 60 to 70 cmHeat Resistance, IEC 60216-P1, 2 hr: 180°CCharpy Impact, JIS K7111: 3.6 kg cm/cm ²			
Injection	Nominal Value	Unit	
Rear Temperature	40.0 - 90.0	°C	
Middle Temperature	40.0 - 90.0	°C	
Front Temperature	40.0 - 90.0	°C	
Nozzle Temperature	85.0 - 105	°C	
Processing (Melt) Temp	110 - 120	°C	
Mold Temperature	165 - 195	°C	
Injection Rate	Moderate-Fast		
Back Pressure	< 1.00	MPa	
Screw Speed	30 - 50	rpm	
Injection instructions			
Injection Time: 5 ± 2 secHardening Time: 15 ± 5 sec			

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