Plenco 07321 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 07321 is an organic fiber reinforced phenolic molding compound, offering improved mechanical strength and excellent dimensional stability. Type ASTM 5948 CFI-5, and UL recognized under component file E40654. 07321 is available in black.

General Information			
UL YellowCard	E40654-231633		
Filler / Reinforcement	Organic filler		
Features	Good dimensional stability Good strength		
Agency Ratings	ASTM D 5948, Type CFI-5		
UL File Number	E40654		
Appearance	Black		
Forms	Tumor		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.39	g/cm³	ASTM D792
Apparent Density	0.57	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.70	%	ASTM D955
Water Absorption (24 hr)	0.41	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	69		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	7260	MPa	ASTM D638
Tensile Strength	36.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	6190	MPa	ASTM D790
Flexural Strength	60.6	MPa	ASTM D790
Compressive Strength	139	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	28.9	J/m	ASTM D256
Notched Izod Impact	28	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	175	°C	ASTM D648
Continuous Use Temperature	190	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	6.4E+10	ohms·cm	ASTM D257

Dielectric Strength [1]	9.8	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.80		ASTM D150
Dissipation Factor (1 MHz)	0.059		ASTM D150
Arc Resistance	26.0	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 Comparative Tracking Index, UL 746 was tested according to ASTM D3638.The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.22%Drop Ball Impact, PLENCO Method: 224 J/m

Injection	Nominal Value	Unit
Suggested Shot Size	20 - 80	%
Rear Temperature	66.0 - 82.0	°C
Front Temperature	82.0 - 99.0	°C
Processing (Melt) Temp	104 - 115	°C
Mold Temperature	165 - 182	°C
Injection Pressure	6.20 - 11.0	MPa
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm
Cushion	3.00	mm

Injection instructions
Injection Time: 3-8 sec

NOTE	
1.	Method A (short time)

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