

Bakelite® PF 2535

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, inorganically/organically filled, average heat resistant, steam resistant, dishwasher proof, high surface quality

Application Areas

Fittings for ovens and dishwashers, tableware/cutlery handles, cookware fittings

General Information			
Filler / Reinforcement	Organic\Inorganic		
Features	Good Surface Finish		
	Steam Resistant		
Uses	Cookware		
	Fittings		
	Handles		
Processing Method	Compression Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.50	g/cm ³	ISO 1183
Apparent Density	0.70	g/cm ³	ISO 60
Molding Shrinkage ¹	0.80	%	ISO 2577
Water Absorption - 24h/23C	45.0	mg	ISO 62
Post Shrinkage ²	0.45	%	ISO 2577
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8500	MPa	ISO 527-2/1
Tensile Stress	55.0	MPa	ISO 527-2/5
Flexural Modulus	8500	MPa	ISO 178
Flexural Stress ³	90.0	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.7	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	6.5	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	115	°C	ISO 75-2/C

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+12	ohms·cm	IEC 60093
Relative Permittivity (100 Hz)	12.5		IEC 60250
Dissipation Factor (100 Hz)	0.30		IEC 60250

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	

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