

Bakelite® PF 7596

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, inorganically/organically filled, modified with graphite, good heat conductivity, good sliding properties (not suitable for use of higher voltage)

Application Areas

Bearers for grinding disc centers, pump parts, sliding/guiding elements, glide bearing parts

General Information			
Filler / Reinforcement	Graphite Fiber Organic\Inorganic		
Features	Low Friction Thermally Conductive		
Uses	Bearings Pump Parts		
Processing Method	Compression Molding Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.64	g/cm ³	ISO 1183
Apparent Density	0.73	g/cm ³	ISO 60
Molding Shrinkage ¹	0.30	%	ISO 2577
Water Absorption - 24h/23C	8.0	mg	ISO 62
Post Shrinkage ²	0.10	%	ISO 2577
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	16000	MPa	ISO 527-2/1
Tensile Stress	60.0	MPa	ISO 527-2/5
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress ³	100	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	175	°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

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