

Plenco 04527 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 04527 is a heat resistant, mineral and flock filled phenolic molding compound, offering excellent mechanical strength, and resistance to cracking in a wet-dry environment. UL recognized under component file E40654. 04527 is available in black.

General Information			
UL YellowCard	E40654-231615		
Filler / Reinforcement	Mineral filler		
	Soft filling		
Features	Good cracking resistance		
	Good strength		
	Heat resistance, high		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.58	g/cm ³	ASTM D792
Apparent Density	0.62	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.52	%	ASTM D955
Water Absorption (24 hr)	0.39	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	58		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10200	MPa	ASTM D638
Tensile Strength	54.0	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	8630	MPa	ASTM D790
Flexural Strength	79.8	MPa	ASTM D790
Compressive Strength	140	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	20.5	J/m	ASTM D256
Notched Izod Impact	19	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	204	°C	ASTM D648
Continuous Use Temperature	203	°C	ASTM D794

CLTE - Flow	3.4E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.55	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.8E+12	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- ¹	9.5	kV/mm	ASTM D149
-- ²	7.3	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	6.60		ASTM D150
Dissipation Factor (1 MHz)	0.16		ASTM D150
Arc Resistance	181	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-1		UL 94
Oxygen Index	31	%	ASTM D2863

Additional Information

The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard. The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.33% Drop Ball Impact, PLENCO Method: 144 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

- Method A (short time)
- Method B (step by step)

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