Plenco 01501 (Transfer)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01501 is a general purpose, mineral filled granular polyester molding compound, offering excellent arc and track resistance properties, low post shrinkage, and improved mechanical strength values. UL recognized under component file E40654. 01501 is available in gray, blue, or tan color.

General Information			
UL YellowCard	E40654-231658		
Filler / Reinforcement	Mineral filler		
Features	Anti-arc Good strength Track Resistance Low shrinkage General		
Uses	General		
UL File Number	E40654		
Appearance	Grey Blue brownish yellow		
Forms	Blank		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.89	g/cm³	ASTM D792
Apparent Density	0.75	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.53	%	ASTM D955
Water Absorption (24 hr)	0.29	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	70		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	11700	MPa	ASTM D638
Tensile Strength	51.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	11300	MPa	ASTM D790
Flexural Strength	92.7	MPa	ASTM D790
Compressive Strength	162	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	25.4	J/m	ASTM D256

Notched Izod Impact	23	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	209	°C	ASTM D648
Continuous Use Temperature	171	°C	ASTM D794
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.5E+14	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	12	kV/mm	ASTM D149
-- [2]	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.20		ASTM D150
Dissipation Factor (1 MHz)	0.028		ASTM D150
Arc Resistance	190	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	25	%	ASTM D2863

Additional Information

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: 0.02%Heat Resistance, ASTM D794: 171°CDrop Ball Impact, PLENCO Method: 127 J/m

Injection	Nominal Value	Unit
Mold Temperature	163 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

Injection instructions

Transfer Time: 3-8 secTransfer Pressure: 5.5-6.9 MPaPreheating Temperature: 93-100°CNever breathe the mold.

NOTE

1.	Method A (short time)
2.	Method B (step by step)

Recommended distributors for this material

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