

Bakelite® PF 2760

Phenolic

Hexion Inc.

Message:

Product Description

Inorganically and organically filled phenolic moulding compound; high heat resistance, good mechanical properties, reduced mould shrinkage and post-shrinkage, free of halogens and toxic heavy metals

Application Areas

Can be coated by galvanic processes, handles, cooking-stove fittings, casings

General Information	
Filler / Reinforcement	Organic\Inorganic
Features	Halogen Free
	High Heat Resistance
Uses	Fittings
	Handles
Processing Method	Compression Molding
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.48	g/cm ³	ISO 1183
Apparent Density	0.70	g/cm ³	ISO 60
Molding Shrinkage ¹	0.60	%	ISO 2577
Water Absorption - 24h/23C	15.0	mg	ISO 62
Post Shrinkage ²	0.25	%	ISO 2577
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	

Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	200	MPa	ISO 2039-1

Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	10000	MPa	ISO 178
Flexural Stress ³	80.0	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	4.5	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	140	°C	ISO 75-2/C

Injection	Nominal Value	Unit	
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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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