

Plenco 08235 (Compression)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 08235 is a renumber of PlasGlas 20315. PLENCO 08235 is a 15% glass-filled polyester bulk molding compound characterized as a flame-retardant, medium strength electrical grade. It is suitable for a broad range of applications such as capacitor cans, electrical enclosures, etc. It is available in bulk or extruded form, natural and black. Other colors available upon request. It is UL recognized under file E40654.

General Information			
UL YellowCard	E40654-231643		
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Good electrical performance		
	Medium strength		
	Flame retardancy		
Uses	Electrical/Electronic Applications		
UL File Number	E40654		
Appearance	Black		
	Available colors		
	Natural color		
Forms	BMC-Block Molding Compound		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.86	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.33	%	ASTM D955
Water Absorption (24 hr)	0.080	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	48		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14400	MPa	ASTM D638
Tensile Strength	41.0	MPa	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	12900	MPa	ASTM D790
Flexural Strength	113	MPa	ASTM D790
Compressive Strength	133	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	373	J/m	ASTM D256
Notched Izod Impact	370	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	272	°C	ASTM D648
Continuous Use Temperature	222	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.2E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- ¹	14	kV/mm	ASTM D149
-- ²	11	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.30		ASTM D150
Dissipation Factor (1 MHz)	0.016		ASTM D150
Arc Resistance	194	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Additional Information			
The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638.The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.00%			
Injection	Nominal Value	Unit	
Mold Temperature	160	°C	
Back Pressure	0.300	MPa	
Screw Speed	< 60	rpm	
Injection instructions			
Mold Close Time: 3-8 sec			
NOTE			
1.	Method A (short time)		
2.	Method B (step by step)		

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