

Bakelite® PF 2736

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, inorganically/organically filled, increased tracking resistance, UL listed moulding compound 0,46 mm / V-0 (BK, Suffix "H"), 0.81 mm / V-0 (NC, GN, BK), 1.5 mm/ V-0 (ALL)

Application Areas

Bobbins, relays, circuit prot. switches, MCB housings, pump parts, sealing flanges, insulating caps, electrical switch gears and lampholders

General Information			
Filler / Reinforcement	Organic\Inorganic		
Features	Good Dimensional Stability		
	Low Shrinkage		
Uses	Bobbins		
	Electrical Parts		
	Housings		
	Pump Parts		
	Switches		
Processing Method	Compression Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.57	g/cm ³	ISO 1183
Apparent Density	0.73	g/cm ³	ISO 60
Molding Shrinkage			ISO 2577
-- ¹	0.35	%	
-- ²	0.65	%	
Water Absorption - 24h/23C	55.0	mg	ISO 62
Post Shrinkage			ISO 2577
-- ³	0.45	%	
-- ⁴	0.45	%	
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)	325	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10000	MPa	ISO 527-2/1
Tensile Stress	50.0	MPa	ISO 527-2/5

Flexural Modulus	9000	MPa	ISO 178
Flexural Stress ⁵	95.0	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.3	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	135	°C	ISO 75-2/C
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+12	ohms·cm	IEC 60093
Electric Strength ⁶ (1.00 mm)	20	kV/mm	IEC 60243-1
Relative Permittivity (100 Hz)	14.0		IEC 60250
Dissipation Factor (100 Hz)	0.30		IEC 60250
Comparative Tracking Index (Solution A)	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.460 mm, Black	V-0		
0.810 mm, Natural, Green, Black	V-0		
1.50 mm, All	V-0		
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.	Compression		
2.	Injection		
3.	Injection		
4.	Compression		
5.	2.0 mm/min		
6.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

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