Plenco 01510 (Transfer)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01510 is a mineral filled, pelletized polyester molding compound, which offers an excellent combination of electrical properties and dimensional stability. UL recognized under component file E40654. 01510 is available in black.

General Information			
UL YellowCard	E40654-231662		
Features	Good dimensional stability Good electrical performance		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	2.02	g/cm³	ASTM D792
Apparent Density	0.91	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.19	%	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	79		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	20000	MPa	ASTM D638
Tensile Strength	76.0	MPa	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	19600	MPa	ASTM D790
Flexural Strength	117	MPa	ASTM D790
Compressive Strength	190	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	27.5	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)	253	°C	ASTM D648
Continuous Use Temperature	213	°C	ASTM D794
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.73	W/m/K	ASTM C177
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	4.2E+15	ohms·cm	ASTM D257

Dielectric Strength			ASTM D149
-- [1]	16	kV/mm	ASTM D149
-- [2]	12	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.70		ASTM D150
Dissipation Factor (1 MHz)	0.015		ASTM D150
Arc Resistance	192	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	26	%	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.The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.01%Heat Resistance, ASTM D794: 213°CDrop Ball Impact, PLENCO Method: 119 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°C

NOTE

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

Recommended distributors for this material

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