Plenco 01508 (Transfer)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01508 is a mineral filled pelletized polyester molding compound, which offers excellent heat resistance and electrical properties. UL recognized under component file E40654. 01508 is available in gray.

General Information			
Filler / Reinforcement	Mineral filler		
Features	Good electrical performance Heat resistance, high		
UL File Number	E40654		
Appearance	Grey		
Forms	Blank		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	2.08	g/cm³	ASTM D792
Apparent Density	0.94	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.34	%	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	77		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	13200	MPa	ASTM D638
Tensile Strength	49.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	13900	MPa	ASTM D790
Flexural Strength	84.0	MPa	ASTM D790
Compressive Strength	161	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	27.6	J/m	ASTM D256
Notched Izod Impact	24	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	231	°C	ASTM D648
Continuous Use Temperature	208	°C	ASTM D794
CLTE - Flow	5.3E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.3E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149

-- [1]	12	kV/mm	ASTM D149
-- [2]	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.80		ASTM D150
Dissipation Factor (1 MHz)	0.015		ASTM D150
Arc Resistance	188	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
Oxygen Index	47	%	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: 0.01%Heat Resistance, ASTM D794: 208°CDrop Ball Impact, PLENCO Method: 115 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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