Plenco 00714 (Injection)

Melamine Phenolic

Plastics Engineering Co.

Message:

PLENCO 00714 is a melamine-phenolic copolymer molding compound, offering excellent arc resistance and comparative track index values. Type ASTM D 5948 CMG, and UL recognized under component file E40654. 00714 is available in brown.

General Information			
UL YellowCard	E40654-231580		
Features	Copolymer Anti-arc		
UL File Number	E40654		
Appearance	Brown		
Forms	Particles		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.66	g/cm³	ASTM D792
Apparent Density	0.72	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.68	%	ASTM D955
Water Absorption (24 hr)	0.28	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	71		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	11000	MPa	ASTM D638
Tensile Strength	62.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	9920	MPa	ASTM D790
Flexural Strength	95.5	MPa	ASTM D790
Compressive Strength	152	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	16.5	J/m	ASTM D256
Notched Izod Impact	16	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	180	°C	ASTM D648
Continuous Use Temperature	143	°C	ASTM D794
CLTE - Flow	5.2E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	4.3E+12	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149

-- [1]	9.5	kV/mm	ASTM D149
-- [2]	6.4	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	7.00		ASTM D150
Dissipation Factor (1 MHz)	0.068		ASTM D150
Arc Resistance	186	sec	ASTM D495
Comparative Tracking Index (CTI)	575	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94

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, 240hr, 105°C: 0.88%Heat Resistance, ASTM D794: 143°CDrop Ball Impact, PLENCO Method: 85 J/m

Injection	Nominal Value	Unit
Suggested Shot Size	20 - 80	%
Rear Temperature	66.0 - 82.0	°C
Front Temperature	82.0 - 99.0	°C
Processing (Melt) Temp	104 - 115	°C
Mold Temperature	150 - 177	°C
Injection Pressure	6.20 - 11.0	MPa
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm
Cushion	3.00	mm

Injection instructions

Injection Time: 3 to 8 seconds

NOTE

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

Recommended distributors for this material

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