

Bakelite® PF 1141

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, inorganically/organically filled, glass fibre reinforced, increased heat resistance, hot steam and hot water resistant (not suitable for use of higher voltage)

Application Areas

Fittings for ovens and dishwashers, cookware fittings

General Information	
Filler / Reinforcement	Glass Fiber Organic\Inorganic
Features	Good Surface Finish High Heat Resistance Steam Resistant
Uses	Appliance Components Cookware Fittings
Processing Method	Compression Molding Injection Molding

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.52	g/cm ³	ISO 1183
Apparent Density	0.78	g/cm ³	ISO 60
Molding Shrinkage ¹	0.60	%	ISO 2577
Water Absorption - 24h/23C	20.0	mg	ISO 62
Post Shrinkage ²	0.30	%	ISO 2577
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)	350	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	8000	MPa	ISO 178
Flexural Stress ³	90.0	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.8	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength (23°C)	6.0	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+10	ohms	IEC 60093
Volume Resistivity	1.0E+11	ohms·cm	IEC 60093
Electric Strength ⁴ (1.00 mm)	5.0	kV/mm	IEC 60243-1
Dissipation Factor (100 Hz)	0.20		IEC 60250
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.	Injection		
2.	Injection		
3.	2.0 mm/min		
4.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

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