Plenco 01530 (Injection)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01530 is a glass and mineral reinforced pelletized polyester molding compound, offering improved mechanical strength properties along with excellent electrical properties and dimensional stability. UL recognized under component file E40654. 01530 is available in black.

General Information			
UL YellowCard	E40654-231663		
Filler / Reinforcement	Mineral filler		
Features	Good dimensional stability Good electrical performance Good strength		
UL File Number	E40654		
Appearance	Black		
Forms	Blank		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.99	g/cm³	ASTM D792
Apparent Density	0.87	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.31	%	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	78		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	20100	MPa	ASTM D638
Tensile Strength	82.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	17600	MPa	ASTM D790
Flexural Strength	135	MPa	ASTM D790
Compressive Strength	166	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	26.9	J/m	ASTM D256
Notched Izod Impact	34	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	262	°C	ASTM D648
Continuous Use Temperature	221	°C	ASTM D794
CLTE - Flow	4.3E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.72	W/m/K	ASTM C177

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	15	kV/mm	ASTM D149
-- [2]	12	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.60		ASTM D150
Dissipation Factor (1 MHz)	0.016		ASTM D150
Arc Resistance	190	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	25	%	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: 221°CDrop Ball Impact, PLENCO Method: 200 J/m

Injection	Nominal Value	Unit
Suggested Shot Size	20 - 80	%
Rear Temperature	49.0 - 71.0	°C
Front Temperature	85.0 - 93.0	°C
Processing (Melt) Temp	93.0 - 100	°C
Mold Temperature	163 - 182	°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: 3-6 sec

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

Recommended distributors for this material

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