

Plenco 07203 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 07203 is an organic fiber reinforced phenolic molding compound, offering improved mechanical strength and an industrial finish. UL recognized under component file E40654. 07203 is available in black.

General Information			
UL YellowCard	E40654-231630		
Filler / Reinforcement	Organic filler		
Features	Good strength		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Apparent Density	0.58	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.74	%	ASTM D955
Water Absorption (24 hr)	0.42	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	81		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7670	MPa	ASTM D638
Tensile Strength	41.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	6460	MPa	ASTM D790
Flexural Strength	58.1	MPa	ASTM D790
Compressive Strength	181	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	25.4	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)	166	°C	ASTM D648
Continuous Use Temperature	188	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	4.7E+11	ohms · cm	ASTM D257
Dielectric Strength ¹	11	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.40		ASTM D150
Dissipation Factor (1 MHz)	0.058		ASTM D150

Arc Resistance	128	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (6.00 mm)	V-0		UL 94
Oxygen Index	28	%	ASTM D2863

Additional Information

The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638. The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.35% Drop Ball Impact, PLENCO Method: 145 J/m

Injection	Nominal Value	Unit
Mold Temperature	165 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

Injection instructions

Transfer Time: 3-8 sec Transfer Pressure: 5.5-6.9 MPa Preheating Temperature: 104-115°C

NOTE

1. Method A (short time)

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