Plenco 07487 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 07487 is a rubber modified organic reinforced phenolic molding compound offering improved mechanical strength and lower modulus. Plenco 07487 is available in black.

General Information			
Filler / Reinforcement	Organic filler		
Features	Good strength		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.34	g/cm³	ASTM D792
Apparent Density	0.55	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.79	%	ASTM D955
Water Absorption (24 hr)	0.92	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	76		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	4490	MPa	ASTM D638
Tensile Strength	34.0	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	3570	MPa	ASTM D790
Flexural Strength	56.4	MPa	ASTM D790
Compressive Strength	82.0	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	28.1	J/m	ASTM D256
Notched Izod Impact	23	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	136	°C	ASTM D648
Continuous Use Temperature	217	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.0E+11	ohms·cm	ASTM D257
Dielectric Strength [1]	12	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.50		ASTM D150
Dissipation Factor (1 MHz)	0.081		ASTM D150
Arc Resistance	67.0	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Oxygen Index	25	%	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: 0.39%Drop Ball Impact, PLENCO Method: 262 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 secTransfer Pressure: 5.5-6.9 MPaPreheating Temperature: 104-115°C

NOTE	
1.	Method A (short time)

Recommended distributors for this material

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