

# Plenco 07591 (Transfer)

Phenolic

Plastics Engineering Co.

## Message:

PLENCO 07591 is a mineral and flock cotton filled novolac phenolic molding compound. UL recognized under component file E40654. 075914 is available in black.

General Information			
UL YellowCard	E40654-231639		
Filler / Reinforcement	Mineral filler		
	Soft filling		
UL File Number	E40654		
Appearance	Black		
Forms	Particle		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.61	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.57	%	ASTM D955
Water Absorption (24 hr)	0.18	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	77		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8400	MPa	ASTM D638
Tensile Strength	37.0	MPa	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	7510	MPa	ASTM D790
Flexural Strength	74.5	MPa	ASTM D790
Compressive Strength	175	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	30.6	J/m	ASTM D256
Notched Izod Impact	31	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	178	°C	ASTM D648
Continuous Use Temperature	190	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.6E+10	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	6.3	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.90		ASTM D150

Dissipation Factor (1 MHz)	0.071		ASTM D150
Arc Resistance	179	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (4.30 mm)	V-0		UL 94
Oxygen Index	33	%	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: 0.29% Drop Ball Impact, PLENCO Method: 150 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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