

Plenco 01506 (Injection)

Thermoset Polyester
Plastics Engineering Co.

Message:

PLENCO 01506 is a mineral and cellulose filled granular polyester molding compound, with glass fiber reinforcement for improved mechanical strength properties. 01506 offers excellent electrical properties and resistance to chemical degradation from repeated detergent exposure. UL recognized under component file E40654. 01506 is available in beige.

General Information			
UL YellowCard	E40654-231660		
Filler / Reinforcement	Glass fiber reinforced material		
	Mineral filler		
	Fiber filler		
Features	Good electrical performance		
	Good strength		
	Good chemical resistance		
	Detergent resistance		
	Low shrinkage		
UL File Number	E40654		
Appearance	Beige		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.70	g/cm ³	ASTM D792
Apparent Density	0.70	g/cm ³	ASTM D1895
Molding Shrinkage - Flow			ASTM D6289
--	0.58	%	ASTM D6289
120°C, 72 hours	0.030	%	ASTM D6289
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	61		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9560	MPa	ASTM D638
Tensile Strength	52.0	MPa	ASTM D638
Tensile Elongation (Break)	1.1	%	ASTM D638
Flexural Modulus	9330	MPa	ASTM D790
Flexural Strength	95.0	MPa	ASTM D790
Compressive Strength	131	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength	25.3	J/m	ASTM D256
Notched Izod Impact	30	J/m	ASTM D256
Drop Ball Impact	204	J/m	Internal method
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	226	°C	ASTM D648
Continuous Use Temperature	191	°C	ASTM D794
CLTE - Flow	7.6E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	6.9E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.20		ASTM D150
Dissipation Factor (1 MHz)	0.019		ASTM D150
Arc Resistance	190	sec	ASTM D495
Comparative Tracking Index	600	V	ASTM D3638
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-1		UL 94
Oxygen Index	32	%	ASTM D2863
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)		

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