

Plenco 07591 (Injection)

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	Blank		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Apparent Density	0.56	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.72	%	ASTM D955
Water Absorption (24 hr)	0.29	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	82		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8550	MPa	ASTM D638
Tensile Strength	56.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	7400	MPa	ASTM D790
Flexural Strength	79.4	MPa	ASTM D790
Compressive Strength	196	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	25.6	J/m	ASTM D256
Notched Izod Impact	26	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	197	°C	ASTM D794
Thermal Conductivity (100°C)	0.42	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.5E+11	ohms · cm	ASTM D257
Dielectric Strength ¹	10	kV/mm	ASTM D149

Dielectric Constant (1 MHz)	5.30		ASTM D150
Dissipation Factor (1 MHz)	0.065		ASTM D150
Arc Resistance	155	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

Additional Information

The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. 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: 0.34% Drop Ball Impact, PLENCO Method: 193 J/m

Injection	Nominal Value	Unit
Suggested Shot Size	20 - 80	%
Rear Temperature	66.0 - 82.0	°C
Front Temperature	82.0 - 99.0	°C
Processing (Melt) Temp	104 - 115	°C
Mold Temperature	165 - 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: 3-8 sec

NOTE

1. Method A (short time)

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