Plenco 02535 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02535 is a general purpose, organic filled phenolic molding compound offering optimized cure characteristics and excellent electrical properties. Type ASTM 5948 CFG, and UL recognized under component file E40654. 02535 is available in black.

General Information			
UL YellowCard	E40654-100708441		
Filler / Reinforcement	Organic filler		
Features	Fast curing Good electrical performance General		
Uses	General		
Agency Ratings	ASTM D 5948, Type CFG		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.38	g/cm³	ASTM D792
Apparent Density	0.61	g/cm³	ASTM D1895
Molding Shrinkage - Flow	1.1	%	ASTM D955
Water Absorption (24 hr)	0.41	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	86		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	7880	MPa	ASTM D638
Tensile Strength	56.0	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	6930	MPa	ASTM D790
Flexural Strength	80.4	MPa	ASTM D790
Compressive Strength	202	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	18.5	J/m	ASTM D256
Notched Izod Impact	18	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	160	°C	ASTM D648
Continuous Use Temperature	196	°C	ASTM D794

CLTE - Flow	4.3E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.2E+11	ohms·cm	ASTM D257
Dielectric Strength [1]	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.80		ASTM D150
Dissipation Factor (1 MHz)	0.057		ASTM D150
Arc Resistance	128	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	26	%	ASTM D2863
Additional Information			
The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard.The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.44%Heat Resistance, ASTM D794: 196°CDrop Ball Impact, PLENCO Method: 103 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)		

Recommended distributors for this material

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