Plenco 02000 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02000 is a versatile general purpose, organic filled phenolic molding compound, offering optimum cure characteristics and an excellent balance of molding properties. UL recognized under component file E40654. 02000 is available in black.

General Information			
UL YellowCard	E40654-231583		
Filler / Reinforcement	Organic filler		
Features	Fast curing General		
Uses	General		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.39	g/cm³	ASTM D792
Apparent Density	0.60	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.65	%	ASTM D955
Water Absorption (24 hr)	0.32	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	91		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	7830	MPa	ASTM D638
Tensile Strength	54.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	7100	MPa	ASTM D790
Flexural Strength	80.8	MPa	ASTM D790
Compressive Strength	214	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	19.5	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)	177	°C	ASTM D648
Continuous Use Temperature	197	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.7E+11	ohms·cm	ASTM D257

Dielectric Strength [1]	8.6	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	6.10		ASTM D150
Dissipation Factor (1 MHz)	0.065		ASTM D150
Arc Resistance	117	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-1		UL 94
Oxygen Index	27	%	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: 0.21%Heat Resistance, ASTM D794: 197°CDrop Ball Impact, PLENCO Method: 98 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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