

Plenco 05482 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 05482 is an organic reinforced phenolic molding compound formulated with graphite to improve the abrasion resistance. 05482 is available in black and brown. 05482 is not recommended for electrical insulating applications.

General Information			
UL YellowCard	E40654-231618		
Filler / Reinforcement	Graphite powder		
	Organic filler		
Features	Good wear resistance		
Appearance	Brown		
	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Apparent Density	0.65	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.61	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	89		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8650	MPa	ASTM D638
Tensile Strength	55.0	MPa	ASTM D638
Tensile Elongation (Break)	0.40	%	ASTM D638
Flexural Modulus	8040	MPa	ASTM D790
Flexural Strength	85.7	MPa	ASTM D790
Compressive Strength	215	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	19.4	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)	186	°C	ASTM D648
Continuous Use Temperature	201	°C	ASTM D794
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	29	%	ASTM D2863

Additional Information

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: 0.25% Drop Ball Impact, PLENCO Method: 96 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

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