

Plenco 07321 (Transfer)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 07321 is an organic fiber reinforced phenolic molding compound, offering improved mechanical strength and excellent dimensional stability. Type ASTM 5948 CFI-5, and UL recognized under component file E40654. 07321 is available in black.

General Information			
UL YellowCard	E40654-231633		
Filler / Reinforcement	Organic filler		
Features	Good dimensional stability		
	Good strength		
Agency Ratings	ASTM D 5948, Type CFI-5		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Apparent Density	0.47	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.91	%	ASTM D955
Water Absorption (24 hr)	0.37	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	76		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6850	MPa	ASTM D638
Tensile Strength	43.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	6740	MPa	ASTM D790
Flexural Strength	67.0	MPa	ASTM D790
Compressive Strength	179	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	29.1	J/m	ASTM D256
Notched Izod Impact	28	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	163	°C	ASTM D648
Continuous Use Temperature	187	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.7E+11	ohms · cm	ASTM D257

Dielectric Strength ¹	8.3	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.30		ASTM D150
Dissipation Factor (1 MHz)	0.074		ASTM D150
Arc Resistance	133	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

Additional Information

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: 0.29% Drop Ball Impact, PLENCO Method: 312 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

NOTE

- Method A (short time)

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