Plenco 03557 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 03557 is a woodflour and mineral filled phenolic molding compound offering excellent dielectric strength values at elevated temperatures while maintaining mechanical strength properties. UL recognized under component file E40654. 03557 is available in black.

General Information			
UL YellowCard	E40654-100708442		
Filler / Reinforcement	Mineral filler Wood flour		
Features	Good electrical performance Good strength		
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	0.63	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.64	%	ASTM D955
Water Absorption (24 hr)	0.54	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	76		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	7490	MPa	ASTM D638
Tensile Strength	58.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	7130	MPa	ASTM D790
Flexural Strength	95.6	MPa	ASTM D790
Compressive Strength	198	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	19.6	J/m	ASTM D256
Notched Izod Impact	19	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	173	°C	ASTM D648
Continuous Use Temperature	182	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**

Volume Resistivity	8.0E+12	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	10	kV/mm	ASTM D149
-- [2]	7.5	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.80		ASTM D150
Dissipation Factor (1 MHz)	0.053		ASTM D150
Arc Resistance	131	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94

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: 0.43%Heat Resistance, ASTM D794: 182°CDrop Ball Impact, PLENCO Method: 92 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)
2.	Method B (step by step)

Recommended distributors for this material

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