Plenco 04504 (Injection)

Phenolic

Plastics Engineering Co.

Message:

Plenco 04504 is a renumber of Plaslok 504. Plenco 04504 is a two-stage, mineral and cellulose-filled phenolic molding compound having better impact and heat resistance than general purpose molding compounds. Since it also has good electrical properties, it has found use in a wide variety of wiring device applications. It is UL recognized under file E40654. 04504 is available in black.

General Information			
UL YellowCard	E40654-231612		
Filler / Reinforcement	Mineral filler Fiber filler		
Features	Impact resistance, good Good electrical performance Heat resistance, medium		
Uses	Wire and cable applications		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.55	g/cm³	ASTM D792
Apparent Density	0.64	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.69	%	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	79		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	9910	MPa	ASTM D638
Tensile Strength	52.2	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	8880	MPa	ASTM D790
Flexural Strength	79.0	MPa	ASTM D790
Compressive Strength	173	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	16.7	J/m	ASTM D256
Notched Izod Impact	17	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load (1.8 MPa, Unannealed)	178	°C	ASTM D648
Continuous Use Temperature	197	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	3.1E+11	ohms·cm	ASTM D257
Dielectric Strength [1]	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.60		ASTM D150
Dissipation Factor (1 MHz)	0.075		ASTM D150
Arc Resistance	177	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm)	V-0		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: 0.29%Drop Ball Impact, PLENCO Method: 99 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)		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China


WECHAT