

# Plenco 00755 (Transfer)

Melamine Phenolic  
Plastics Engineering Co.

Message:

PLENCO 00755 is a melamine-phenolic copolymer molding compound offering excellent electrical and flame resistant properties. Type ASTM 5948 CMG, and UL recognized under component file E40654. 00755 is available only in brown.

General Information			
UL YellowCard	E40654-231580		
Features	Copolymer		
	Flame retardancy		
UL File Number	E40654		
Appearance	Brown		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.58	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.68	%	ASTM D955
Water Absorption (24 hr)	0.43	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	76		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10800	MPa	ASTM D638
Tensile Strength	56.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	8510	MPa	ASTM D790
Flexural Strength	84.6	MPa	ASTM D790
Compressive Strength	166	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	21.5	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)	186	°C	ASTM D648
Continuous Use Temperature	155	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.5E+12	ohms · cm	ASTM D257
Dielectric Strength			ASTM D149
-- <sup>1</sup>	7.7	kV/mm	ASTM D149

-- <sup>2</sup>	5.8	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	7.30		ASTM D150
Dissipation Factor (1 MHz)	0.073		ASTM D150
Arc Resistance	186	sec	ASTM D495
Comparative Tracking Index (CTI)	500	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, 240hr, 105°C: 0.96% Heat Resistance, ASTM D794: 155°C Drop Ball Impact, PLENCO Method: 101 J/m

Injection	Nominal Value	Unit
Mold Temperature	150 - 177	°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

1. Method A (short time)
2. Method B (step by step)

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### 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



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