Bakelite® PF 2137

Phenolic

Hexion Inc.

Message:

Product Description
Phenolic moulding compound, inorganically/organically filled, increased heat resistance, minimal distortion, dishwasher proof
Application Areas
Iron heat shield, fittings for ovens, dishwashers and toilet seats

General Information	
Filler / Reinforcement	Organic\Inorganic
Features	Good Surface Finish
Uses	Appliance Components Fittings
Processing Method	Compression Molding Injection Molding

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.43	g/cm³	ISO 1183
Apparent Density	0.65	g/cm³	ISO 60
Molding Shrinkage			ISO 2577
-- [1]	0.45	%	
-- [2]	0.80	%	
Water Absorption - 24h/23C	45.0	mg	ISO 62
Post Shrinkage			ISO 2577
-- [3]	0.55	%	
-- [4]	0.35	%	
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Ball Indentation Hardness (H 961/30)	350	MPa	ISO 2039-1
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Flexural Modulus	7500	MPa	ISO 178
Flexural Stress [5]	100	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	1.7	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	7.0	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**

Heat Deflection Temperature (8.0 MPa, Unannealed)	125	°C	ISO 75-2/C
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+11	ohms·cm	IEC 60093
Electric Strength [6] (1.00 mm)	27	kV/mm	IEC 60243-1
Relative Permittivity (100 Hz)	8.50		IEC 60250
Dissipation Factor (100 Hz)	0.25		IEC 60250
Comparative Tracking Index (Solution A)	125	V	IEC 60112
Injection	**Nominal Value**	**Unit**	
Rear Temperature	60.0 to 75.0	°C	
Nozzle Temperature	80.0 to 100	°C	
Processing (Melt) Temp	80.0 to 100	°C	
Mold Temperature	160 to 190	°C	
Injection Pressure	> 15.0	MPa	
Back Pressure	0.500 to 2.00	MPa	
NOTE			
1.	Compression		
2.	Injection		
3.	Injection		
4.	Compression		
5.	2.0 mm/min		
6.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

Recommended distributors for this material

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