Plenco 01586 (Transfer)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01586 is a glass and mineral reinforced pelletized polyester molding compound offering excellent heat resistance and mechanical strength properties. This product is typically used for injection molded electrical appliance components. UL recognized under component file E40654. 01586 is available in white, yellow, or grey colors.

General Information			
UL YellowCard	E40654-231664		
Filler / Reinforcement	Glass fiber reinforced material Mineral filler		
Features	Good strength Heat resistance, high		
Uses	Electrical/Electronic Applications Home appliance components		
UL File Number	E40654		
Appearance	White		
Forms	Particle		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.92	g/cm³	ASTM D792
Apparent Density	0.95	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.19	%	ASTM D955
Water Absorption (24 hr)	0.070	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	51		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10800	MPa	ASTM D638
Tensile Strength	76.0	MPa	ASTM D638
Tensile Elongation (Break)	1.3	%	ASTM D638
Flexural Modulus	10200	MPa	ASTM D790
Flexural Strength	119	MPa	ASTM D790
Compressive Strength	157	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	72.4	J/m	ASTM D256
Notched Izod Impact	77	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load (1.8 MPa, Unannealed)	267	°C	ASTM D648
Continuous Use Temperature	211	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.2E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	12	kV/mm	ASTM D149
-- [2]	11	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.20		ASTM D150
Dissipation Factor (1 MHz)	0.013		ASTM D150
Arc Resistance	187	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.00 mm)	V-0		UL 94
Oxygen Index	36	%	ASTM D2863
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: 0.01%Heat Resistance, ASTM D794: 211°C			
Injection	**Nominal Value**	**Unit**	
Mold Temperature	163 - 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: 93-100°C			
NOTE			
1.	Method A (short time)		
2.	Method B (step by step)		

Recommended distributors for this material

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