Plenco 06343 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 06343 is a mica reinforced phenolic molding compound, offering for a low power factor, low electrical losses, and good electrical properties after long exposures to high humidity. UL recognized under component file E40654. 06343 is available in natural color.

General Information			
UL YellowCard	E40654-231620		
Filler / Reinforcement	Mica filler		
Features	Good electrical performance		
UL File Number	E40654		
Appearance	Natural color		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.73	g/cm³	ASTM D792
Apparent Density	0.81	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.33	%	ASTM D955
Water Absorption (24 hr)	0.040	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	77		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	15000	MPa	ASTM D638
Tensile Strength	42.0	MPa	ASTM D638
Tensile Elongation (Break)	0.30	%	ASTM D638
Flexural Modulus	14100	MPa	ASTM D790
Flexural Strength	87.4	MPa	ASTM D790
Compressive Strength	173	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	21.3	J/m	ASTM D256
Notched Izod Impact	18	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	185	°C	ASTM D648
Continuous Use Temperature	216	°C	ASTM D794
CLTE - Flow	2.1E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	5.8E+12	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	19	kV/mm	ASTM D149

-- [2]	16	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.90		ASTM D150
Dissipation Factor (1 MHz)	0.034		ASTM D150
Arc Resistance	180	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
Oxygen Index	43	%	ASTM D2863

Additional Information
The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638.The value listed as Mold Shrink, Linear-Flow, ASTM D955 was tested according to the ASTM D6289 standard.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.04%Drop Ball Impact, PLENCO Method: 85 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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