

# Plenco 06582 (Transfer)

Phenolic

Plastics Engineering Co.

## Message:

PLENCO 06582 is a rubber modified phenolic molding compound, offering excellent heat resistant properties, along with improved mechanical strength at elevated temperatures. UL recognized under component file E40654. 06582 is available in black.

General Information			
UL YellowCard	E40654-231640		
Features	Good strength		
	Heat resistance, high		
UL File Number	E40654		
Appearance	Black		
Forms	Blank		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.66	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.11	%	ASTM D955
Water Absorption (24 hr)	0.16	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	44		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9230	MPa	ASTM D638
Tensile Strength	74.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	8910	MPa	ASTM D790
Flexural Strength	115	MPa	ASTM D790
Compressive Strength	157	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	45.5	J/m	ASTM D256
Notched Izod Impact	47	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	241	°C	ASTM D648
Continuous Use Temperature	230	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	6.2E+11	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	13	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.80		ASTM D150

Dissipation Factor (1 MHz)	0.077		ASTM D150
Arc Resistance	120	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (6.00 mm)	V-0		UL 94
Oxygen Index	37	%	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: 0.07% Drop Ball Impact, PLENCO Method: 276 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 sec Transfer Pressure: 5.5-6.9 MPa Preheating Temperature: 104-115°C

#### NOTE

- Method A (short time)

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