Plenco 06401 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 06401 is a glass fiber and mineral filled two-stage phenolic molding compound. UL recognized under component file E40654. 06401 is available in black.

General Information			
UL YellowCard	E40654-231621		
Filler / Reinforcement	Glass fiber reinforced material Mineral filler		
UL File Number	E40654		
Appearance	Black		
Forms	Blank		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.74	g/cm³	ASTM D792
Apparent Density	0.70	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.10	%	ASTM D955
Water Absorption (24 hr)	0.070	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	98		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	17000	MPa	ASTM D638
Tensile Strength	118	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	16600	MPa	ASTM D790
Flexural Strength	197	MPa	ASTM D790
Compressive Strength	283	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	57.9	J/m	ASTM D256
Notched Izod Impact	58	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	274	°C	ASTM D648
Continuous Use Temperature	236	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	6.2E+11	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	13	kV/mm	ASTM D149

-- [2]	8.6	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.40		ASTM D150
Dissipation Factor (1 MHz)	0.035		ASTM D150
Arc Resistance	63.0	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

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: 0.05%Drop Ball Impact, PLENCO Method: 342 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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