

Plenco 02571 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02571 is a general purpose, organic filled phenolic molding compound offering optimum cure characteristics while maintaining excellent mechanical and electrical properties. UL recognized under component file E40654. 02571 is available in black or brown color.

General Information			
UL YellowCard	E40654-231591		
Filler / Reinforcement	Organic filler		
Features	Fast curing		
	Good electrical performance		
	General		
Uses	General		
UL File Number	E40654		
Appearance	Brown		
	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Apparent Density	0.64	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.89	%	ASTM D955
Water Absorption (24 hr)	0.28	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	86		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8740	MPa	ASTM D638
Tensile Strength	61.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	7650	MPa	ASTM D790
Flexural Strength	90.5	MPa	ASTM D790
Compressive Strength	191	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	18.9	J/m	ASTM D256
Notched Izod Impact	19	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	157	°C	ASTM D648

Continuous Use Temperature	200	°C	ASTM D794
CLTE - Flow	4.8E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.40	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+12	ohms·cm	ASTM D257
Dielectric Strength ¹	13	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.60		ASTM D150
Dissipation Factor (1 MHz)	0.046		ASTM D150
Arc Resistance	136	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	25	%	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. The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.28% Heat Resistance, ASTM D794: 200°C Drop Ball Impact, PLENCO Method: 107 J/m

Injection	Nominal Value	Unit
Suggested Shot Size	20 - 80	%
Rear Temperature	66.0 - 82.0	°C
Front Temperature	82.0 - 99.0	°C
Processing (Melt) Temp	104 - 115	°C
Mold Temperature	165 - 182	°C
Injection Pressure	6.20 - 11.0	MPa
Back Pressure	0.200	MPa
Screw Speed	< 60	rpm
Cushion	3.00	mm

Injection instructions

Injection Time: 3-8 sec

NOTE

- Method A (short time)

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