

Bakelite® PF 8052

Phenolic

Hexion Inc.

Message:

Product Description

Phenolic moulding compound, glass fibre-reinforced and inorganically filled, excellent heat resistance with respect to surface finish and mechanical properties

Application Areas

Pan handles, heat-resistant up to 285°C, baking oven rollers

General Information			
Filler / Reinforcement	Glass Fiber		
	Inorganic		
Features	High Heat Resistance		
Uses	Cookware		
	Handles		
Processing Method	Compression Molding		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.50	g/cm ³	ISO 1183
Apparent Density	0.70	g/cm ³	ISO 60
Molding Shrinkage			ISO 2577
-- ¹	0.30	%	
-- ²	0.40	%	
Water Absorption - 24h/23C	13.0	mg	ISO 62
Post Shrinkage			ISO 2577
-- ³	0.10	%	
-- ⁴	0.10	%	
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	

Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	275	MPa	ISO 2039-1

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8000	MPa	ISO 527-2/1
Tensile Stress	55.0	MPa	ISO 527-2/5
Flexural Modulus	8500	MPa	ISO 178
Flexural Stress ⁵	90.0	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	150	°C	ISO 75-2/C
Injection	Nominal Value	Unit	
Rear Temperature	60.0 to 75.0	°C	
Nozzle Temperature	80.0 to 100	°C	
Processing (Melt) Temp	80.0 to 100	°C	
Mold Temperature	160 to 190	°C	
Injection Pressure	> 15.0	MPa	
Back Pressure	0.500 to 2.00	MPa	
NOTE			
1.	Compression		
2.	Injection		
3.	Injection		
4.	Compression		
5.	2.0 mm/min		

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