

Plenco 01530 (Transfer)

Thermoset Polyester
Plastics Engineering Co.

Message:

PLENCO 01530 is a glass and mineral reinforced pelletized polyester molding compound, offering improved mechanical strength properties along with excellent electrical properties and dimensional stability. UL recognized under component file E40654. 01530 is available in black.

General Information			
UL YellowCard	E40654-231663		
Filler / Reinforcement	Glass fiber reinforced material Mineral filler		
Features	Good dimensional stability Good electrical performance Good strength		
UL File Number	E40654		
Appearance	Black		
Forms	Blank		
Processing Method	Resin transfer molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.99	g/cm ³	ASTM D792
Apparent Density	0.88	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.12	%	ASTM D955
Water Absorption (24 hr)	0.14	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	76		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	18200	MPa	ASTM D638
Tensile Strength	83.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	18300	MPa	ASTM D790
Flexural Strength	140	MPa	ASTM D790
Compressive Strength	202	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	37.7	J/m	ASTM D256
Notched Izod Impact	41	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	264	°C	ASTM D648
Continuous Use Temperature	223	°C	ASTM D794

CLTE - Flow	5.4E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.1E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- ¹	15	kV/mm	ASTM D149
-- ²	12	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.50		ASTM D150
Dissipation Factor (1 MHz)	0.014		ASTM D150
Arc Resistance	191	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	26	%	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. Post Shrinkage, ASTM D6289: 0.0% Heat Resistance, ASTM D794: 223°C Drop Ball Impact, PLENCO Method: 179 J/m

Injection	Nominal Value	Unit
Mold Temperature	163 - 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: 93-100°C

NOTE

1. Method A (short time)
2. Method B (step by step)

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