

Plenco 06527 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 06527 is a woodflour and mineral filled resole phenolic molding compound. It is available in brown.

General Information			
Filler / Reinforcement	Mineral filler		
	Wood flour		
Appearance	Brown		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Apparent Density	0.58	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.46	%	ASTM D955
Water Absorption (24 hr)	0.37	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	48		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10700	MPa	ASTM D638
Tensile Strength	47.8	MPa	ASTM D638
Tensile Elongation (Break)	0.73	%	ASTM D638
Flexural Modulus	8250	MPa	ASTM D790
Flexural Strength	72.6	MPa	ASTM D790
Compressive Strength	127	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	21.5	J/m	ASTM D256
Notched Izod Impact	23	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	194	°C	ASTM D648
Continuous Use Temperature	188	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.8E+12	ohms · cm	ASTM D257
Dielectric Strength ¹	8.8	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	6.60		ASTM D150
Dissipation Factor (1 MHz)	0.083		ASTM D150
Arc Resistance	153	sec	ASTM D495

Comparative Tracking Index (CTI)	200	V	UL 746
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: 0.31%Drop Ball Impact, PLENCO Method: 173 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	0.300	MPa	
Screw Speed	< 60	rpm	
Cushion	3.00	mm	
Injection instructions			
Injection Time: 3-8 sec			
NOTE			
1. Method A (short time)			

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