

# Plenco 06500 (Transfer)

Phenolic  
Plastics Engineering Co.

Message:

PLENCO 06500 is a glass reinforced phenolic molding compound offering improved strength, dimensional stability, and excellent electrical properties. UL recognized under component file E40654. 06500 is available in black.

General Information			
UL YellowCard	E40654-231622		
Filler / Reinforcement	Glass fiber reinforced material		
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	1.76	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.70	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.12	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	99		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14300	MPa	ASTM D638
Tensile Strength	92.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	14500	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Compressive Strength	243	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	37.0	J/m	ASTM D256
Notched Izod Impact	38	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	224	°C	ASTM D648
Continuous Use Temperature	196	°C	ASTM D794
CLTE - Flow	3.5E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	6.6E+11	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	17	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.10		ASTM D150
Dissipation Factor (1 MHz)	0.033		ASTM D150
Arc Resistance	136	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94
Oxygen Index	35	%	ASTM D2863

#### 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: 0.04% Drop Ball Impact, PLENCO Method: 230 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 sec Transfer Pressure: 5.5-6.9 MPa Preheating Temperature: 104-115°C

#### NOTE

- Method A (short time)

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#### Recommended distributors for this material

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