Plenco 03303 (Injection)

Phenolic

Plastics Engineering Co.

Message:

Plenco 03303 is a renumber of Plaslok 5303. Plenco 03303 is a two-stage, mineral and flock-filled phenolic molding compound offering excellent electrical insulating properties. It can be processed by compression, transfer or injection molding . It is UL recognized under file E40654.

General Information			
UL YellowCard	E40654-231593		
Filler / Reinforcement	Mineral filler Soft filling		
Features	Insulation		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.54	g/cm³	ASTM D792
Apparent Density	0.62	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.84	%	ASTM D955
Water Absorption (24 hr)	0.33	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	82		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10000	MPa	ASTM D638
Tensile Strength	57.0	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	8630	MPa	ASTM D790
Flexural Strength	82.9	MPa	ASTM D790
Compressive Strength	180	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	18.0	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)	168	°C	ASTM D648
Continuous Use Temperature	200	°C	ASTM D794
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	3.1E+11	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149

-- [1]	9.2	kV/mm	ASTM D149
-- [2]	6.0	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.60		ASTM D150
Dissipation Factor (1 MHz)	0.070		ASTM D150
Arc Resistance	180	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94

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, 72hr, 120°C: 0.35%Heat Resistance, ASTM D794: 200°CDrop Ball Impact, PLENCO Method: 112 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)
2.	Method B (step by step)

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

WECHAT