

Plenco 06310 (Compression)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 06310 is a glass and mineral filled phenolic molding compound offering excellent heat resistance and dimensional stability. 06310 is available in black.

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
	Mineral filler		
Features	Good dimensional stability		
	Heat resistance, high		
Appearance	Black		
Forms	Particles		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.86	g/cm ³	ASTM D792
Apparent Density	0.97	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.30	%	ASTM D955
Water Absorption (24 hr)	0.080	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13600	MPa	ASTM D638
Tensile Strength	32.0	MPa	ASTM D638
Tensile Elongation (Break)	0.30	%	ASTM D638
Flexural Modulus	11700	MPa	ASTM D790
Flexural Strength	62.2	MPa	ASTM D790
Compressive Strength	165	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	19.8	J/m	ASTM D256
Notched Izod Impact	17	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	188	°C	ASTM D648
Continuous Use Temperature	215	°C	ASTM D794
CLTE - Flow	7.5E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.9E+13	ohms · cm	ASTM D257

Dielectric Strength ¹	12	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.10		ASTM D150
Dissipation Factor (1 MHz)	0.016		ASTM D150
Arc Resistance	48.0	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: 0.14% Drop Ball Impact, PLENCO Method: 71 J/m

Injection	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	0.50	hr
Mold Temperature	165 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

Injection instructions

Mold Close Time: 3-8 sec

NOTE

- Method A (short time)

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