Plenco 01501 (Injection)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01501 is a general purpose, mineral filled granular polyester molding compound, offering excellent arc and track resistance properties, low post shrinkage, and improved mechanical strength values. UL recognized under component file E40654. 01501 is available in gray, blue, or tan color.

General Information			
UL YellowCard	E40654-231658		
Filler / Reinforcement	Mineral filler		
Features	Anti-arc Track Resistance Low shrinkage General		
Uses	General		
UL File Number	E40654		
Appearance	Grey Blue brownish yellow		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.87	g/cm³	ASTM D792
Apparent Density	0.82	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.91	%	ASTM D955
Water Absorption (24 hr)	0.24	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	65		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10300	MPa	ASTM D638
Tensile Strength	47.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	9730	MPa	ASTM D790
Flexural Strength	82.9	MPa	ASTM D790
Compressive Strength	150	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	21.8	J/m	ASTM D256
Notched Izod Impact	20	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	182	°C	ASTM D648
Continuous Use Temperature	170	°C	ASTM D794
CLTE - Flow	4.6E-5	cm/cm/°C	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	6.6E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- [1]	12	kV/mm	ASTM D149
-- [2]	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.90		ASTM D150
Dissipation Factor (1 MHz)	0.027		ASTM D150
Arc Resistance	187	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	24	%	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, 72hr, 120°C: 0.04%Heat Resistance, ASTM D794: 170°CDrop Ball Impact, PLENCO Method: 133 J/m			
Injection	**Nominal Value**	**Unit**	
Suggested Shot Size	20 - 80	%	
Rear Temperature	49.0 - 71.0	°C	
Front Temperature	85.0 - 93.0	°C	
Processing (Melt) Temp	93.0 - 100	°C	
Mold Temperature	163 - 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: 3-6 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

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