

Plenco 04349 (Injection)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 04349 is a heat resistant, mineral filled phenolic molding compound offering optimized cure characteristics, and excellent heat resistant properties. PLENCO 04349 is also formulated to offer exceptional cosmetic characteristics in the molded product. UL recognized under component file E40654. 04349 is available in black.

General Information			
UL YellowCard	E40654-231608		
Filler / Reinforcement	Mineral filler		
Features	Fast curing		
	Heat resistance, high		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Apparent Density	0.62	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.67	%	ASTM D955
Water Absorption (24 hr)	0.099	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	84		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9440	MPa	ASTM D638
Tensile Strength	49.0	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	8550	MPa	ASTM D790
Flexural Strength	78.0	MPa	ASTM D790
Compressive Strength	186	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	15.8	J/m	ASTM D256
Notched Izod Impact	14	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	161	°C	ASTM D648
Continuous Use Temperature	216	°C	ASTM D794
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.47	W/m/K	ASTM C177

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	6.4E+11	ohms·cm	ASTM D257
Dielectric Strength ¹	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.60		ASTM D150
Dissipation Factor (1 MHz)	0.057		ASTM D150
Arc Resistance	166	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-1		UL 94
Oxygen Index	34	%	ASTM D2863

Additional Information

The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. 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: 0.17% Heat Resistance, ASTM D794: 216°C Drop Ball Impact, PLENCO Method: 75 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

- Method A (short time)

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