

Plenco 05118 (Injection)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 05118 is a mineral and graphite filled phenolic molding compound, formulated for bearing seals. 05118 provides for a low coefficient of friction, abrasion resistance, minimal water absorption, and excellent dimensional stability under severe exposure. 05118 is available in gray. 05118 is not recommended for electrical insulating applications.

General Information			
Filler / Reinforcement	Mineral filler		
	Graphite powder		
Features	Good dimensional stability		
	Low friction coefficient		
	Good wear resistance		
	Low or no water absorption		
Uses	Insulating material		
	Seals		
Appearance	Grey		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.82	g/cm ³	ASTM D792
Apparent Density	0.89	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.35	%	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	58		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13300	MPa	ASTM D638
Tensile Strength	39.0	MPa	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	11100	MPa	ASTM D790
Flexural Strength	64.6	MPa	ASTM D790
Compressive Strength	128	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	16.1	J/m	ASTM D256
Notched Izod Impact	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	180	°C	ASTM D648
Continuous Use Temperature	202	°C	ASTM D794

Additional Information

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: 0.07% Drop Ball Impact, PLENCO Method: 59 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

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