Plenco 04527 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 04527 is a heat resistant, mineral and flock filled phenolic molding compound, offering excellent mechanical strength, and resistance to cracking in a wet-dry environment. UL recognized under component file E40654. 04527 is available in black.

General Information			
UL YellowCard	E40654-231615		
Filler / Reinforcement	Mineral filler Soft filling		
Features	Good cracking resistance Good strength Heat resistance, high		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Resin transfer molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.59	g/cm³	ASTM D792
Apparent Density	0.62	g/cm³	ASTM D1895
Molding Shrinkage - Flow	0.36	%	ASTM D955
Water Absorption (24 hr)	0.47	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (E-Scale)	70		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10000	MPa	ASTM D638
Tensile Strength	60.0	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	9440	MPa	ASTM D790
Flexural Strength	86.8	MPa	ASTM D790
Compressive Strength	168	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	25.1	J/m	ASTM D256
Notched Izod Impact	27	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	236	°C	ASTM D648
Continuous Use Temperature	205	°C	ASTM D794

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.5E+12	ohms·cm	ASTM D257
Dielectric Strength [1]	8.3	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	7.60		ASTM D150
Dissipation Factor (1 MHz)	0.11		ASTM D150
Arc Resistance	183	sec	ASTM D495
Comparative Tracking Index (CTI)	200	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm)	V-1		UL 94
Oxygen Index	35	%	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: 0.34%Drop Ball Impact, PLENCO Method: 149 J/m

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

Injection instructions
Transfer Time: 3-8 secTransfer Pressure: 5.5-6.9 MPaPreheating Temperature: 104-115°C

NOTE	
1.	Method A (short time)

Recommended distributors for this material

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