

Plenco 02535 (Compression)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 02535 is a general purpose, organic filled phenolic molding compound offering optimized cure characteristics and excellent electrical properties. Type ASTM 5948 CFG, and UL recognized under component file E40654. 02535 is available in black.

General Information			
UL YellowCard	E40654-100708441		
Filler / Reinforcement	Organic filler		
Features	Fast curing		
	Good electrical performance		
	General		
Uses	General		
Agency Ratings	ASTM D 5948, Type CFG		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Apparent Density	0.60	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.36	%	ASTM D955
Water Absorption (24 hr)	0.45	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9010	MPa	ASTM D638
Tensile Strength	58.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	8770	MPa	ASTM D790
Flexural Strength	96.4	MPa	ASTM D790
Compressive Strength	215	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	19.2	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)	172	°C	ASTM D648
Continuous Use Temperature	196	°C	ASTM D794

CLTE - Flow	6.8E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.37	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.7E+12	ohms·cm	ASTM D257
Dielectric Strength ¹	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.60		ASTM D150
Dissipation Factor (1 MHz)	0.038		ASTM D150
Arc Resistance	103	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	25	%	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.The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard.Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.20%Heat Resistance, ASTM D794: 196°C Drop Ball Impact, PLENCO Method: 129 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			
1.	Method A (short time)		

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