

# Plenco 01508 (Injection)

Thermoset Polyester  
Plastics Engineering Co.

Message:

PLENCO 01508 is a mineral filled pelletized polyester molding compound, which offers excellent heat resistance and electrical properties. UL recognized under component file E40654. 01508 is available in gray.

General Information			
Filler / Reinforcement	Mineral filler		
Features	Good electrical performance		
	Heat resistance, high		
UL File Number	E40654		
Appearance	Grey		
Forms	Blank		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.07	g/cm <sup>3</sup>	ASTM D792
Apparent Density	0.94	g/cm <sup>3</sup>	ASTM D1895
Molding Shrinkage - Flow	0.52	%	ASTM D955
Water Absorption (24 hr)	0.11	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	67		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12100	MPa	ASTM D638
Tensile Strength	52.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	11700	MPa	ASTM D790
Flexural Strength	87.4	MPa	ASTM D790
Compressive Strength	139	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	25.5	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)	233	°C	ASTM D648
Continuous Use Temperature	218	°C	ASTM D794
CLTE - Flow	6.0E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.4E+15	ohms · cm	ASTM D257
Dielectric Strength			ASTM D149

-- 1	13	kV/mm	ASTM D149
-- 2	11	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.00		ASTM D150
Dissipation Factor (1 MHz)	0.014		ASTM D150
Arc Resistance	184	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94

#### 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: 0.01% Heat Resistance, ASTM D794: 218°C Drop Ball Impact, PLENCO Method: 172 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

- Method A (short time)
- Method B (step by step)

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