

Bakelite® PF 6506

Phenolic
Hexion Inc.

Message:

Product Description
Phenolic moulding compound, inorganically filled, glass fibre reinforced, high dimensional stability at raised temperature, good media resistance, heat-resistant, UL listed moulding compound 1.5 mm / V-0 (ALL)

Application Areas
Thermally and mechanically highly stressed parts in automotive field, insulating flanges, contact support power switch and switch covers

General Information			
Filler / Reinforcement	Glass Fiber Inorganic		
Features	Good Dimensional Stability High Heat Resistance Low Shrinkage		
Uses	Automotive Applications Switches		
Processing Method	Compression Molding Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.72	g/cm ³	ISO 1183
Apparent Density	0.73	g/cm ³	ISO 60
Molding Shrinkage ¹	0.30	%	ISO 2577
Water Absorption - 24h/23C	10.0	mg	ISO 62
Post Shrinkage ²	0.10	%	ISO 2577
Compression Molding Molding Pressure	> 15.0	MPa	
Compression Molding Temperature	160 to 190	°C	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	450	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress ³	140	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	9.5	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	190	°C	ISO 75-2/C
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+12	ohms·cm	IEC 60093
Electric Strength ⁴ (1.00 mm)	26	kV/mm	IEC 60243-1
Relative Permittivity (100 Hz)	7.00		IEC 60250
Dissipation Factor (100 Hz)	0.050		IEC 60250
Comparative Tracking Index (Solution A)	150	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, All)	V-0		UL 94
Injection	Nominal Value	Unit	
Rear Temperature	60.0 to 75.0	°C	
Nozzle Temperature	80.0 to 100	°C	
Processing (Melt) Temp	80.0 to 100	°C	
Mold Temperature	160 to 190	°C	
Injection Pressure	> 15.0	MPa	
Back Pressure	0.500 to 2.00	MPa	
NOTE			
1.	Injection		
2.	Injection		
3.	2.0 mm/min		
4.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

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