

Plenco 07202 (Injection)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 07202 is an organic fiber reinforced phenolic molding compound, formulated to offer improved mechanical strength properties with an industrial finish. UL recognized under component file E40654. 07202 is available in black and brown.

General Information			
UL YellowCard	E40654-231629		
Filler / Reinforcement	Organic filler		
Features	Good strength		
UL File Number	E40654		
Appearance	Brown		
	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792
Apparent Density	0.48	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.98	%	ASTM D955
Water Absorption (24 hr)	0.58	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	81		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7710	MPa	ASTM D638
Tensile Strength	50.0	MPa	ASTM D638
Tensile Elongation (Break)	0.70	%	ASTM D638
Flexural Modulus	6090	MPa	ASTM D790
Flexural Strength	67.8	MPa	ASTM D790
Compressive Strength	182	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	22.0	J/m	ASTM D256
Notched Izod Impact	25	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	148	°C	ASTM D648
Continuous Use Temperature	180	°C	ASTM D794
CLTE - Flow	5.2E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.6E+11	ohms · cm	ASTM D257

Dielectric Strength ¹	7.4	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.10		ASTM D150
Dissipation Factor (1 MHz)	0.064		ASTM D150
Arc Resistance	110	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (6.00 mm)	V-0		UL 94
Oxygen Index	26	%	ASTM D2863

Additional Information

The value listed as Comparative Tracking Index, UL 746 was tested according to ASTM D3638. 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: 0.46% Drop Ball Impact, PLENCO Method: 192 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

NOTE

- Method A (short time)

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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