

Plenco 04485 (Injection)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 04485 is a mineral filled phenolic molding compound offering excellent heat resistance, electrical resistance, and dimensional stability. UL recognized under component file E40654. 04485 is available in black.

General Information			
UL YellowCard	E40654-231611		
Filler / Reinforcement	Mineral filler		
Features	Good dimensional stability		
	Heat resistance, high		
UL File Number	E40654		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm ³	ASTM D792
Apparent Density	0.63	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.79	%	ASTM D955
Water Absorption (24 hr)	0.21	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	84		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8450	MPa	ASTM D638
Tensile Strength	56.0	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	7650	MPa	ASTM D790
Flexural Strength	84.7	MPa	ASTM D790
Compressive Strength	196	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	17.2	J/m	ASTM D256
Notched Izod Impact	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	165	°C	ASTM D648
Continuous Use Temperature	204	°C	ASTM D794
CLTE - Flow	5.0E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.2E+11	ohms · cm	ASTM D257

Dielectric Strength ¹	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.30		ASTM D150
Dissipation Factor (1 MHz)	0.067		ASTM D150
Arc Resistance	145	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-1		UL 94
Oxygen Index	31	%	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: 0.33% Drop Ball Impact, PLENCO Method: 98 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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