Plenco 02000 (Transfer)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02000 is a versatile general purpose, organic filled phenolic molding compound, offering optimum cure characteristics and an excellent balance of molding properties. UL recognized under component file E40654. 02000 is available in black.

Dit FellowCard E40654-231883 Filler Reinforcement Organic filler	General Information			
Features Fast curing General USes General UL File Number E40654 Appearance Black Forms Particles Processing Method Resin transfer molding Physical Nominal Value Unit Test Method Specific Gravity 1.39 g/cm² ASTM D792 Apparent Density 0.60 % ASTM D895 Molding Shrinkage - Flow 0.65 % ASTM D955 Water Absorption (24 hr) 0.32 % ASTM D570 Hardness Nominal Value Unit Test Method Rockwell Hardness (F-Scale) 91 Test Method ASTM D570 Mechanical Nominal Value Unit Test Method Tensile Modulus 7830 MPa ASTM D638 Tensile Elongation (Break) 0.70 MPa ASTM D638 Flexural Modulus 7100 MPa ASTM D638 Flexural Strength 80.8 MPa ASTM D638 Flexural Strength 90.	UL YellowCard	E40654-231583		
Uses General UL File Number £40654 Appearance Black Forms Particles Processing Method Resist transfer molding Physical Nominal Value Unit Test Method Specific Gravity 1,39 g/cm² ASTM D792 Apparent Density 0,60 g/cm² ASTM D895 Molding Shrinkage - Flow 0,65 % ASTM D950 Mater Absorption (24 hr) 0,32 % ASTM D770 Hardness Nominal Value Unit Test Method Rockwell Hardness (E-Scale) 91 ASTM D785 Mechanical Nominal Value Unit Test Method Tensile Modulus 7830 MPa ASTM D638 Tensile Strength 54,0 MPa ASTM D638 Flexural Modulus 7100 MPa ASTM D693 Flexural Strength 80.8 MPa ASTM D695 Impact Nominal Value Unit Test Method Charpy Notched Impact Strengt	Filler / Reinforcement	Organic filler		
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Hardness Nominal Value Unit Test Method Rockwell Hardness (E-Scale) 91	Molding Shrinkage - Flow	0.65	%	ASTM D955
Rockwell Hardness (E-Scale)91ASTM D785MechanicalNominal ValueUnitTest MethodTensile Modulus7830MPaASTM D638Tensile Strength54.0MPaASTM D638Tensile Elongation (Break)0.70%ASTM D638Flexural Modulus7100MPaASTM D790Flexural Strength80.8MPaASTM D790Compressive Strength214MPaASTM D695ImpactNominal ValueUnitTest MethodCharpy Notched Impact Strength19.5J/mASTM D256Notched Izod Impact18J/mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed)Nominal ValueUnitTest MethodContinuous Use Temperature197°CASTM D648ElectricalNominal ValueUnitTest Method	Water Absorption (24 hr)	0.32	%	ASTM D570
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Deflection Temperature Under Load (1.8 MPa, Unannealed) 177 °C ASTM D648 Continuous Use Temperature 197 °C ASTM D794 Electrical Nominal Value Unit Test Method	Notched Izod Impact	18	J/m	ASTM D256
MPa, Unannealed) 177 °C ASTM D648 Continuous Use Temperature 197 °C ASTM D794 Electrical Nominal Value Unit Test Method	Thermal	Nominal Value	Unit	Test Method
Electrical Nominal Value Unit Test Method	•	177	°C	ASTM D648
	Continuous Use Temperature	197	°C	ASTM D794
Volume Resistivity 2.7E+11 ohms·cm ASTM D257	Electrical	Nominal Value	Unit	Test Method
	Volume Resistivity	2.7E+11	ohms·cm	ASTM D257

Dielectric Strength ¹	8.6	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	6.10		ASTM D150
Dissipation Factor (1 MHz)	0.065		ASTM D150
Arc Resistance	117	sec	ASTM D495
Comparative Tracking Index (CTI)	150	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-1		UL 94
Oxygen Index	27	%	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: 0.21% Heat Resistance, ASTM D794: 197°CDrop Ball Impact, PLENCO Method: 98 J/m

Injection	Nominal Value	Unit
Mold Temperature	165 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm
Injection instructions		

Transfer Time: 3-8 secTransfer Pressure: 5.5-6.9 MPaPreheating Temperature: 104-115°C

NOTE

1. Method A (short time)

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