

Plenco 01581 (Injection)

Thermoset Polyester

Plastics Engineering Co.

Message:

PLENCO 01581 is a glass and mineral reinforced pelletized polyester molding compound, exhibiting excellent dimensional stability, mechanical strength and also arc resistance, track resistance, and flammability ratings. UL recognized under component file E40654. 01581 is available in black and grey colors.

General Information			
UL YellowCard	E40654-231664		
Filler / Reinforcement	Glass fiber reinforced material Mineral filler		
Features	Good dimensional stability Anti-arc Good strength Track Resistance		
UL File Number	E40654		
Appearance	Black Grey		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.83	g/cm ³	ASTM D792
Apparent Density	0.83	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.37	%	ASTM D6289
Water Absorption (24 hr)	0.090	%	ASTM D570
Post Shrinkage - 72 hr (120°C)	0.010	%	ASTM D6289
Drop Ball Impact	267	J/m	Internal method
Heat Resistance	212	°C	ASTM D794
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	62		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11600	MPa	ASTM D638
Tensile Strength	66.0	MPa	ASTM D638
Tensile Elongation (Break)	1.1	%	ASTM D638
Flexural Modulus	10800	MPa	ASTM D790
Flexural Strength	107	MPa	ASTM D790
Compressive Strength	131	MPa	ASTM D695

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	31.2	J/m	ASTM D256
Notched Izod Impact	40	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	267	°C	ASTM D648
CLTE - Flow	6.7E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.91	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.7E+15	ohms·cm	ASTM D257
Dielectric Strength ¹	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.40		ASTM D150
Dissipation Factor (1 MHz)	0.021		ASTM D150
Arc Resistance	189	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	ASTM D3638
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.00 mm)	V-0		UL 94
Oxygen Index	47	%	ASTM D2863
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

1. 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

