

Bakelite® PF 2874

Phenolic
Hexion Inc.

Message:

Product Description
Phenolic moulding compound, inorganically filled, glass fibre reinforced, increased mechanical strength, increased temperature stability, low water absorption, good dimensional stability, UL listed moulding compound 0.75 mm / V-0 (BK)

Application Areas
Insulating flanges, automotive engine parts, steering housings, end plates for electrical motors, carbon brush holders, clamp boards, iron heat shield, coffee machine bases, housings for domestic appliances, bobbins, cross bars, terminal boards, switches

General Information			
Filler / Reinforcement	Glass Fiber		
	Inorganic		
Features	Good Dimensional Stability		
	High Strength		
	Low Shrinkage		
	Low to No Water Absorption		
Uses	Appliance Components		
	Automotive Applications		
	Bobbins		
	Housings		
	Switches		
Processing Method	Compression Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.57	g/cm ³	ISO 1183
Apparent Density	0.70	g/cm ³	ISO 60
Molding Shrinkage			ISO 2577
-- 1	0.30	%	
-- 2	0.50	%	
Water Absorption - 24h/23C	30.0	mg	ISO 62
Post Shrinkage			ISO 2577
-- 3	0.25	%	
-- 4	0.20	%	
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)	350	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10500	MPa	ISO 527-2/1
Tensile Stress	65.0	MPa	ISO 527-2/5
Flexural Modulus	10500	MPa	ISO 178
Flexural Stress ⁵	125	MPa	ISO 178
Compressive Stress	250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.2	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	150	°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 ⁶ (1.00 mm)	26	kV/mm	IEC 60243-1
Relative Permittivity (100 Hz)	10.0		IEC 60250
Dissipation Factor (100 Hz)	0.25		IEC 60250
Comparative Tracking Index (Solution A)	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm, Black)	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.	Compression		
2.	Injection		
3.	Injection		
4.	Compression		
5.	2.0 mm/min		
6.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

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