

Plenco 05350 (Injection)

Phenolic
Plastics Engineering Co.

Message:

PLENCO 05350 is a mineral and graphite filled phenolic molding compound, developed for seal applications. PLENCO 05350 offers excellent dimensional stability, lubricity, and low abrasion properties. 05350 is available in gray. 05350 is not recommended for electrical insulating applications.

General Information			
Filler / Reinforcement	Mineral filler		
	Graphite powder		
Features	Good dimensional stability		
Uses	Seals		
Appearance	Grey		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.74	g/cm ³	ASTM D792
Apparent Density	0.93	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.43	%	ASTM D955
Water Absorption (24 hr)	0.050	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15400	MPa	ASTM D638
Tensile Strength	43.0	MPa	ASTM D638
Tensile Elongation (Break)	0.30	%	ASTM D638
Flexural Modulus	12700	MPa	ASTM D790
Flexural Strength	72.4	MPa	ASTM D790
Compressive Strength	144	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	14.4	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)	180	°C	ASTM D648
Continuous Use Temperature	257	°C	ASTM D794
Additional Information			
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: 0.09%Drop Ball Impact, PLENCO Method: 37 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

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