

Plenco 00714 (Compression)

Melamine Phenolic
Plastics Engineering Co.

Message:

PLENCO 00714 is a melamine-phenolic copolymer molding compound, offering excellent arc resistance and comparative track index values. Type ASTM D 5948 CMG, and UL recognized under component file E40654. 00714 is available in brown.

General Information			
UL YellowCard	E40654-231580		
Features	Copolymer		
	Anti-arc		
UL File Number	E40654		
Appearance	Brown		
Forms	Particles		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.67	g/cm ³	ASTM D792
Apparent Density	0.70	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.36	%	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	74		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13300	MPa	ASTM D638
Tensile Strength	59.0	MPa	ASTM D638
Tensile Elongation (Break)	0.80	%	ASTM D638
Flexural Modulus	11200	MPa	ASTM D790
Flexural Strength	84.5	MPa	ASTM D790
Compressive Strength	167	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	21.8	J/m	ASTM D256
Notched Izod Impact	17	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	194	°C	ASTM D648
Continuous Use Temperature	155	°C	ASTM D794
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	7.5E+13	ohms · cm	ASTM D257
Dielectric Strength			ASTM D149
-- ¹	14	kV/mm	ASTM D149

-- ²	10	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	6.50		ASTM D150
Dissipation Factor (1 MHz)	0.047		ASTM D150
Arc Resistance	186	sec	ASTM D495
Comparative Tracking Index (CTI)	425	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94

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, 240hr, 105°C: 0.62% Heat Resistance, ASTM D794: 155°C Drop Ball Impact, PLENCO Method: 96 J/m

Injection	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	0.50	hr
Mold Temperature	150 - 177	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

Injection instructions

Mold Close Time: 3-8 sec Preheating Temperature: 104-115°C

NOTE

1. Method A (short time)
2. Method B (step by step)

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