

Plenco 02567 (Compression)

Phenolic

Plastics Engineering Co.

Message:

PLENCO 02567 is a general purpose, organic filled phenolic molding compound offering excellent cosmetic characteristics as typically required for vacuum metalized closures. UL recognized under component file E40654. 02567 is available in black or red color. 02567 Black is not intended for electrical insulating applications.

General Information			
UL YellowCard	E40654-231584		
Filler / Reinforcement	Organic filler		
Features	General		
Uses	General		
	Shell		
UL File Number	E40654		
Appearance	Black		
	Red		
Forms	Particles		
Processing Method	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Apparent Density	0.61	g/cm ³	ASTM D1895
Molding Shrinkage - Flow	0.41	%	ASTM D955
Water Absorption (24 hr)	0.48	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (E-Scale)	84		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7960	MPa	ASTM D638
Tensile Strength	62.0	MPa	ASTM D638
Tensile Elongation (Break)	0.90	%	ASTM D638
Flexural Modulus	7370	MPa	ASTM D790
Flexural Strength	90.8	MPa	ASTM D790
Compressive Strength	215	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	18.7	J/m	ASTM D256
Notched Izod Impact	15	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	185	°C	ASTM D648

Continuous Use Temperature	203	°C	ASTM D794
CLTE - Flow	6.3E-5	cm/cm/°C	ASTM E831
Thermal Conductivity (100°C)	0.37	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+13	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
-- ¹	13	kV/mm	ASTM D149
-- ²	9.5	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	5.40		ASTM D150
Dissipation Factor (1 MHz)	0.041		ASTM D150
Arc Resistance	87.0	sec	ASTM D495
Comparative Tracking Index (CTI)	175	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Oxygen Index	29	%	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. The value listed as Thermal Conductivity, ASTM C177 was tested according to the ASTM E1461 standard. Post Shrinkage, ASTM D6289, 72hr, 120°C: 0.40% Heat Resistance, ASTM D794: 203°C Drop Ball Impact, PLENCO Method: 102 J/m

Injection	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	0.50	hr
Mold Temperature	165 - 182	°C
Back Pressure	0.300	MPa
Screw Speed	< 60	rpm

Injection instructions

Mold Close Time: 3-8 sec

NOTE

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

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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



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