HEXION

Technical Data Sheet

Bakelite® PF 2736

Typical Physical Properties			
Property	**Standard**	**Typical Value**	**Unit**
* Density (23°C)	ISO 1183	1,57	g/cm3
Apparent density (moulding compound)	ISO 60	0,73	g/cm3
Injection - Moulding shrinkage	ISO 2577	0,65	%
Injection - Post shrinkage	ISO 2577	0,45	%
Compression - Moulding shrinkage	ISO 2577	0,35	%
Compression - Post shrinkage	ISO 2577	0,45	%
* Tensile strength * (5mm/min)	ISO 527 - 1/2	50	MPa
* Tensile modulus * (1mm/min) (Elongation$_{e1}$ 0,05%; $_{e2}$ 0,25%)	ISO 527 - 1/2	10.000	MPa
Compressive strength (test specimen flat tested)	ISO 604	250	MPa
Flexural strength (2mm/min)	ISO 178	95	MPa
Flexural modulus	ISO 178	9.000	MPa
* Charpy impact strength (23°C)	ISO 179-1 eU	7,0	kJ/m2
* Charpy notched impact strength (23°C)	ISO 179-1 eA	1,3	kJ/m2
Ball indentation hardness (H961/30)	ISO 2039/P1	325	MPa
* Temp. of deflection under load. HDT C-8,0 MPa	ISO 75-2	135	°C
* Surface resistivity (Following IEC 60093)		1E+11	Ohm
* Volume resistivity (Following IEC 60093)		1E+12	Ohm*cm
* Dissipation factor (100 Hz) (Following IEC 60250)		0,3	
* Relative permittivity (100 Hz) (Following IEC 60250)		14	
* Electric strength (1mm thickness) (short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296)	IEC 60243-P1	20,0	kV/mm
Proof tracking index (Test liquid A)	IEC 60112	175	PTI
Flammability UL 94 (ALL=all colours, BG=beige, BK=black, BN=brown, BL=blue, GN=green, GY=grey, NC=natural, OR=orange, RD=red, WT=white, YL=yellow)	UL 94	V-0 / 0,81mm (NC,GN,BK); V-0 / 1,5mm (ALL) V-0 / 0,46mm (BK, Suffix H)	Step/mm
Water absorption (24h / 23°C) (Following ISO 62)		55	mg
Additional Characteristic		.5, D, UL	

Explanation for Additional Characteristic:

.5 - Improved electric properties
.7 - Allowed for contact with food
.9 - Ammonia free
A - High surface quality moulding
Cu - Copper adhesive
D - Low shrinkage/good dimensional stability
E - Elastified
EL - For electrostatic coating
ES - Acetic acid free
G - Galvanize
HS - High mechanical strength
HT - Resistance to high temperatures
LB - High arc resistance
M - Dishwasher proof
P - Production of test spec. only comp.
T - Low coefficient of friction
Typ - Standardized moulding compound
UL - UL listed moulding compound
UV - Non fade
V - Yellowing resistance
Z - Special presentation cyl. pellets
L - Conductive

Product Description

Phenolic moulding compound, inorganically/organically filled, increased tracking resistance, UL listed moulding compound 0,46 mm / V-0 (BK, Suffix "H"), 0.81 mm / V-0 (NC, GN, BK), 1.5 mm/ V-0 (ALL)

Application Areas

Bobbins, relays, circuit prot. switches, MCB housings, pump parts, sealing flanges, insulating caps, electrical switch gears and lampholders

Preparation of Test Specimens of Thermosetting Moulding Compound
• Compression to ISO 295
• Injection to ISO 10724

Storage Capability
2 years (relative humidity of 50-60% and maximum storage temperature of approximately 20°C)

Moulding Conditions			
Injection Moulding		**Compression Moulding**	
Temperature of material	80 - 100°C	Mould temperature	160 - 190°C
Mould temperature	160 - 190°C	Curing time (per mm of wall thickness)	20 - 40 s
Curing time (per mm of wall thickness)	10 - 20 s	Cavity moulding pressure	>15 MPa
Barrel temperature - feed zone	60 - 75°C		
Barrel temperature - nozzle zone	80 - 100°C		
Cavity moulding pressure	>15 MPa		
Back pressure	0,5 - 2 MPa		
Holding pressure	ca. 60% of injection pressure		

Properties marked with * are elements of the database CAMPUS (Computer Aided Material Preselection by Uniform Standards) and based on the obliging introduced guidelines of the norm committee of plastic. (CAMPUS is a registered trademark of the CWFG.)

Contact Information

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