

MATERIALS ENGINEERING LABORATORY
 DATA REPORT
PLENCO 06404
 Two-Stage Phenolic
 transfer molded

PLENCO 06404 is a glass fiber and mineral filled two-stage phenolic molding compound offering superior molded mechanical properties, especially tensile strength. PLENCO 06404 is available in black. PLENCO 06404 is UL recognized under component file E40654.

PROPERTY	metric	english	ASTM Test Method
Form	Briquette		
Apparent Density	0.66 g/cm ³	41.3 lb/ft ³	D1895
Specific Gravity	1.72		D792
Mold Shrinkage*	0.0012 m/m	0.0012 in/in	D6289
Post Shrinkage 72hr 120°C	0.03 %		D6289
Izod Impact Notched	55.8 J/m	1.05 ft·lb/in	D256
Charpy Impact Notched	48.0 J/m	0.90 ft·lb/in	D256
Drop Ball Impact	386 J/m	7.2 ft·lb/in	Plenco
Tensile Strength	148 MPa	21,528 psi	D638
Tensile Modulus	16,850 MPa	2,444,000 psi	D638
Tensile Elongation	1.1 %		D638
Flexural Strength	218.7 MPa	31,720 psi	D790
Flexural Modulus	16,960 MPa	2,460,000 psi	D790
Compressive Strength	300 MPa	43,476 psi	D695
Heat Resistance	240 °C	464 °F	D794
Deflection Temperature 1.82MPa	270 °C	518 °F	D648
Water Absorption	0.15 %		D570
Rockwell Hardness	100 E scale		D785
Dielectric Strength short time	13.2 kV/mm	334 V/mil	D149
Dissipation Factor, 1MHz	0.039		D150
Permittivity, 1MHz	5.3		D150
Volume Resistivity	5.2E+11 ohm·cm	2.0E+11 ohm·in	D257
ASTM Arc Resistance	120 sec		D495
Comparative Tracking Index	185 V		D3638
UL Flammability	V-0, 5V-A @1.50mm		UL 94
Oxygen Index	%		D2863
Coefficient of Thermal Expansion	3.8E-05 /°C	2.1E-05 /°F	E831
Thermal Conductivity 100°C	W/m/°C	Btu/hr/ft/°F	E1461

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Store in cool dry place.

The Typical Values listed are results obtained from the testing of standard specimens using the stated test procedures, with said specimens molded under controlled laboratory conditions from representative samplings of the product. Although Plastics Engineering Company at all times reserves the right to make changes in the materials, suppliers and processing, the values listed as typical are those to be expected at the time of our manufacture. The final determination of the accuracy or completeness of any information, the suitability of the product for the use contemplated, the manner of its use, and the matter of any infringement of patents in use, are all the sole responsibility of the user. PLASTICS ENGINEERING COMPANY MAKES NO WARRANTY, EXPRESS OR IMPLIED, WITH RESPECT TO THIS PRODUCT, INCLUDING NO WARRANTY OF THE MERCHANTABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE. Plastics Engineering Company reserves at all times the right to discontinue the production of any or all of its products. This is an uncontrolled copy and not subject to updates.

**Mold Shrinkage obtained under controlled laboratory conditions with relatively simple mold geometry and should be used for comparison purposes only and not for actual tool design.*