


Bakelite® PF 13591

PF-X

Momentive Specialty Chemicals

Product Texts
Product description:

Phenolic moulding compound, mainly organically filled, very soft flow for large moulds, UL listed moulding compound 1.5 mm/ V-1 (BK), 3.0 mm/ V-0 (BK).

Application areas:

Pan handles, various applications in electrical- and automotive area.

| Property Name | Value | Unit | Standard No. |
|---|-------|-------------------|-------------------|
| Apparent density (moulding compound) | 0.63 | g/cm ³ | ISO 60 |
| Moulding shrinkage (compression moulding, longitudinal) | 0.65 | % | ISO 2577 |
| Post shrinkage (compression moulding, 168h/110°C) | 0.65 | % | ISO 2577 |
| Flexural strength (2mm/min) | 90 | MPa | ISO 178 |
| Flexural modulus | 7000 | MPa | ISO 178 |
| Water absorption (24h/23°C) | 75 | mg | similar to ISO 62 |

Additional characteristics:

A, UL

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)

| Mechanical properties | Value | Unit | Test Standard |
|--|-------|-------------------|---------------|
| ISO Data | | | |
| Charpy impact strength (+23°C) | 6 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength (+23°C) | 1.3 | kJ/m ² | ISO 179/1eA |
| Thermal properties | | | |
| ISO Data | | | |
| Temp. of deflection under load, 8.00 MPa | 110 | °C | ISO 75-1/-2 |
| Electrical properties | | | |
| ISO Data | | | |
| Relative permittivity, 100Hz | 15 | - | IEC 60250 |
| Dissipation factor, 100Hz | 0.3 | E-4 | IEC 60250 |
| Volume resistivity | 1E9 | Ohm*m | IEC 60093 |
| Surface resistivity | 1E10 | Ohm | IEC 60093 |
| Electric strength | 16 | kV/mm | IEC 60243-1 |
| Other properties | | | |
| ISO Data | | | |
| Density | 1410 | kg/m ³ | ISO 1183 |
| Test specimen production | | | |
| ISO Data | | | |
| Injection Molding, injection temperature | 115 | °C | ISO 10724 |
| Injection Molding, injection velocity | 170 | mm/s | ISO 10724 |
| Injection Molding, hold pressure | 100 | MPa | ISO 10724 |

