

**Bakelite® PF 2760**

PF-X

Momentive Specialty Chemicals

**Product Texts****Product description:**

Inorganically and organically filled phenolic moulding compound; High heat resistance, good mechanical properties, reduced mould shrinkage and post-shrinkage, free of halogens and toxic heavy metals.

**Application areas:**

May to be coated by galvanic processes, handles, cooking-stove fittings, casings.

Property Name	Value	Unit	Standard No.
Apparent density (moulding compound)	0.7	g/cm <sup>3</sup>	ISO 60
Moulding shrinkage (injection moulding, longitudinal)	0.6	%	ISO 2577
Post shrinkage (injection moulding, 168h/110°C)	0.3	%	ISO 2577
Flexural strength (2mm/min)	80	MPa	ISO 178
Flexural modulus	9500	MPa	ISO 178
Ball indentation hardness (H 961/30)	200	MPa	ISO 2039/P1
Water absorption (24h/23°C)	15	mg	similar to ISO 62

**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)

Rheological properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Charpy impact strength (+23°C)	4.5	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	1.5	kJ/m <sup>2</sup>	ISO 179/1eA
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 8.00 MPa	140	°C	ISO 75-1-2
<b>Other properties</b>			
<b>ISO Data</b>			
Density	1480	kg/m <sup>3</sup>	ISO 1183
<b>Test specimen production</b>			
<b>ISO Data</b>			
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
Injection Molding, cure time	25	min	ISO 10724
Compression Molding, mold temperature	160	°C	ISO 295
Compression Molding, cure time	1	min	ISO 295

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**Characteristics****Processing**

Injection Molding, Transfer Molding

**Other text information****Injection Molding**

VERARBEITUNG Temperature of material:	105-115	°C
Mould temperature:	160-190	°C
Curing time:	10-20	sec
 Further Information:		
Barrel temperature		
- Feed zone:	60-75	°C
- Nozzle zone:	80-100	°C
Cavity moulding pressure: d>	>15	MPa
Back pressure:	0.5-2	MPa
Holding pressure:	60% of injection pressure	

**Compression molding**

PROCESSING	Mould temperature:	160-190	°C
	Curing time:	20-40	sec
	Cavity moulding pressure:	>15	MPa