


Bakelite® PF 6510

PF-(GF+X)

Momentive Specialty Chemicals

Product Texts

Property Name	Value	Unit	Standard No.
Apparent density (moulding compound)	0.71	g/cm ³	ISO 60
Moulding shrinkage (injection moulding, longitudinal)	0.25	%	ISO 2577
Post shrinkage (injection moulding, 168h/110°C)	0.05	%	ISO 2577

Tensile strength (5mm/min) 100 MPa ISO 527-1/2 Compr. strength (test spec. flat tested) 260 MPa ISO 604 Flexural strength (2mm/min) 200 MPa ISO 178 Flexural modulus 15500 MPa ISO 178 Water absorption (24h/23°C) 12 mg similar to ISO 62 Additi

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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
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	16000	MPa	ISO 527-1/-2
Charpy impact strength (+23°C)	14.5	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23°C)	4.5	kJ/m ²	ISO 179/1eA
Thermal properties			
ISO Data			
Temp. of deflection under load, 8.00 MPa	175	°C	ISO 75-1/-2
Electrical properties			
ISO Data			
Relative permittivity, 100Hz	6	-	IEC 60250
Dissipation factor, 100Hz	0.05	E-4	IEC 60250
Volume resistivity	1E10	Ohm*m	IEC 60093
Surface resistivity	1E11	Ohm	IEC 60093
Electric strength	32	kV/mm	IEC 60243-1
Other properties			
ISO Data			
Density	1700	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
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:	160-180	°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