

CHANG CHUN PLASTICS CO., LTD.

NO. 301, SONGKIANG ROAD, 7TH FL., TAIPEI, 10477 TAIWAN
TEL : 886-2-2503-8131 (REF) FAX : 886-2-2501-8018

Engineering Plastics
Longlite Phenolic
MouldingCompound

PMC T 375 JX Technical Data

PMC T 375 JX

PMC T 375 JX is a wood flour and mineral reinforced phenolic injection moulding compound with improved heat resistance

Characteristics

- 1) excellent electrical property
- 2) excellent temperature resistance
- 3) excellent mechanical and chemical property
- 4) excellent weatherability
- 5) excellent wear property
- 6) excellent mouldability
- 7) High resistance to fuels, oils, fats and many solvents

Injection Moulding Condition

Cylinder temperatures	: 40 to 90 °C
Nozzle temperatur	: 95 + / - 10 °C
Mould temperatures	: 165 to 195°C, suitable temperature 180°C
Temperature of material	: 110 to 120 °C
Injection rate	: middle to fast
Screw speed	: 40 + / - 10 U / min. , to be chosen is such a way that plasticizing time is just within hardening time.
Times	Injection Time : 5 + / -2 Sek. Hardening Time : 15 + / - 5 Sek. Back pressure : below 10 bar
Shrinkage	Mould shrinkage is 0,5 to 1,0 % nach Test Methode ISO 2577

Packaging

25 kg paper Bags or 800 kg Big Bag

Product Handling

Moisture pick-up from ambient air should be avoided. Product has to be stored in a cold and dry place protected from direct sun light. Heating of the product on storage can lead to a hardening reaction.

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CCP PMC T 375 JX

Property	Value	Unit	Test Method ISO / ASTM
Spiral Flow	68	cm	CCP
Specific Gravity	1.51	'g / cm ³	1183 / D792
Melting Point	--	°C	DSC
Coeff. Of linear therm. expansion	--	10 ⁻⁵ cm/cm°C	D696
Heat deflection temperature under load			
--- 1,8 M Pa	181	°C	75 – 2 / D648
--- 0,45 M Pa		°C	75 – 2 / D648
Heat Resistance (2h)	200	°C	IEC 60216-P1
Water Absorption (24h)	0.16	%	62 / D570
Flammability acc. To UL94, 0,97 mm	V –0	-	1210 / UL94
Tensile strength	-	M Pa	527 – 2 / D638
Elongation at break	-	%	527 – 2 / D638
Flexural strength	90	M Pa	178 / D790
Flexural Modulus		M Pa	178 / D790
Charpy Impact	3,45	Kg cm / cm ²	JIS K7111
Izod Impact notched	-	kg.cm/cm	D256
Hardness Rockwell		M	2039 – 2 /D785
Dielectric strength, 2 mm	13,1	KV/mm	243 / D149
Volume resistivity	2,1 x10 ⁹	Ω-cm	IEC 167 / D257
Surface resistivity	-	Ω	IEC 93 / D257
Dielectric constant		60Hz	IEC 250 / D150
Dielectric loss factor		60Hz	IEC 250 / D150
Arc resistance	150	sec	D495

The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication. The information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such

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material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits nor used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Chang Chun Plastics cannot anticipate all variations in actual end uses conditions the Company makes no warranties and assumes no liability in connection with any use of this information. Nothing of this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.