LONGLITE® PMC T385J70

Chang Chun Plastics Co., Ltd. (CCP Group) - *Phenolic*

General Information

Product Description

PMC T 385 J70 is a wood flour- and mineral-reinforced phenolic injection moulding compound with improved heat resistance

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Mineral	• Wood Flour	
Features	• Chemical Resistant • Fuel Resistant • Good Electrical Properties	• Good Moldability • Good Weather Resistance • High Heat Resistance	• Oil Resistant • Solvent Resistant • Wear Resistant
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Density	1.41	g/cm³	ISO 1183
Molding Shrinkage	0.80 to 1.3	%	ISO 2577
Water Absorption (24 hr)	0.33	%	ASTM D570
Water Absorption (24 hr, 73°F)	0.33	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	5950	psi	ASTM D638
Tensile Stress (Yield)	5950	psi	ISO 527-2
Flexural Strength	13800	psi	ASTM D790
Flexural Stress	13800	psi	ISO 178
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	327	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	327	°F	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	2.4E+10	ohms	ASTM D257
Surface Resistivity	2.4E+10	ohms	IEC 60093
Volume Resistivity	1.0E+12	ohms·cm	ASTM D257
Volume Resistivity	1.0E+12	ohms·cm	IEC 60093
Dielectric Strength (0.0787 in)	260	V/mil	ASTM D149
Electric Strength (0.0787 in)	260	V/mil	IEC 60243-1
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.25 in)	V-0		UL 94

Additional Information

Spiral Flow, CCP: 60 to 70 cm
Heat Resistance, IEC 60216-P1, 2 hr: 180°C
Charpy Impact, JIS K7111: 3.6 kg cm/cm²

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	104 to 194	°F
Middle Temperature	104 to 194	°F
Front Temperature	104 to 194	°F
Nozzle Temperature	185 to 221	°F
Processing (Melt) Temp	230 to 248	°F
Mold Temperature	329 to 383	°F

Injection Rate	Moderate-Fast
Back Pressure	< 145 psi
Screw Speed	30 to 50 rpm

Injection Notes

Injection Time: 5 ± 2 sec
Hardening Time: 15 ± 5 sec

Notes

[1] Typical properties: these are not to be construed as specifications.