TECHNICAL DATA SHEET

Bakelite® PF 6507

Bakelite Synthetics
PF-(CF+X)

Processing	Injection molding, Transfer molding

Product Text

Product Information

Product description:

Phenolic moulding compound, inorganically filled, glass fibre reinforced, elastomer modified, galvanizable, heat resistant, good media resistance, high dimensional stability at raised temperature, high mechanical strength.

Application areas:

Thermally and mechanically highly stressed parts in automotive field, solenoid switch caps, electrical motor end shields.

Property Name	Value	Unit	Standard No.
Apparent density (moulding compound)	0.7	g/cm³	ISO 60
Moulding shrinkage (injection moulding, longitudinal)	0.2	%	ISO 2577
Post shrinkage (injection moulding, 168h/110°C)	0.1	%	ISO 2577
Tensile strength (5mm/min)	85	MPa	ISO 527-1/2
Compr. strength (test spec. flat tested)	180	MPa	ISO 604
Flexural strength (2mm/min)	135	MPa	ISO 178
Flexural modulus	10000	MPa	ISO 178
Ball indentation hardness (H 961/30)	250	MPa	ISO 2039/P1

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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)

Processing/Physical Characteristics	Value	Unit	Standard
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Standard
Tensile modulus	11000	MPa	ISO 527
Poisson's ratio	0.35		ISO 527
Charpy impact strength, +23°C	15	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	3.5	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 8.00 MPa	170	°C	ISO 75-1/-2

Electrical Properties	Value	Unit	Standard
Relative permittivity, 100Hz	6.5		IEC 62631-2-1
Dissipation factor, 100Hz	0.1	E-4	IEC 62631-2-1
Volume resistivity	1E10	Ohm*m	IEC 62631-3-1
Surface resistivity	1E11	Ohm	IEC 62631-3-2
Electric strength	22.5	kV/mm	IEC 60243-1
Comparative tracking index	150		IEC 60112

Other Properties	Value	Unit	Standard
Density	1600	kg/m³	ISO 1183

Test Specimen Production	Value	Unit	Standard
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

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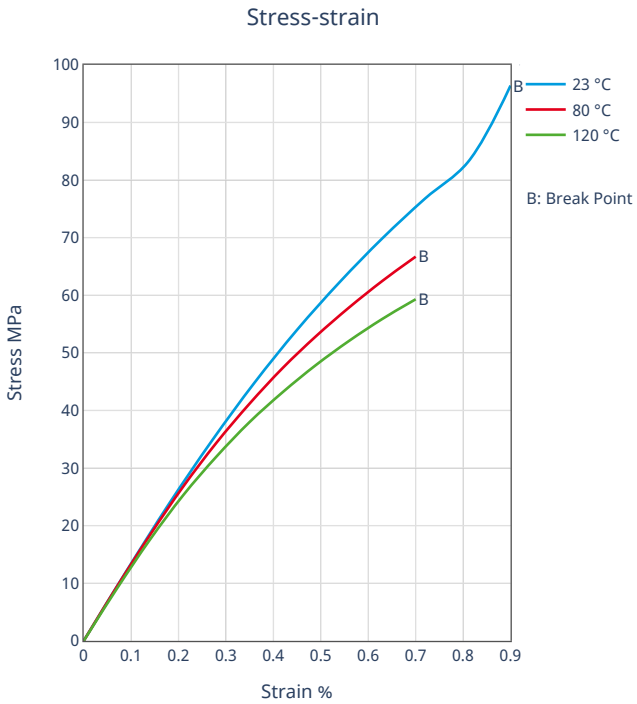
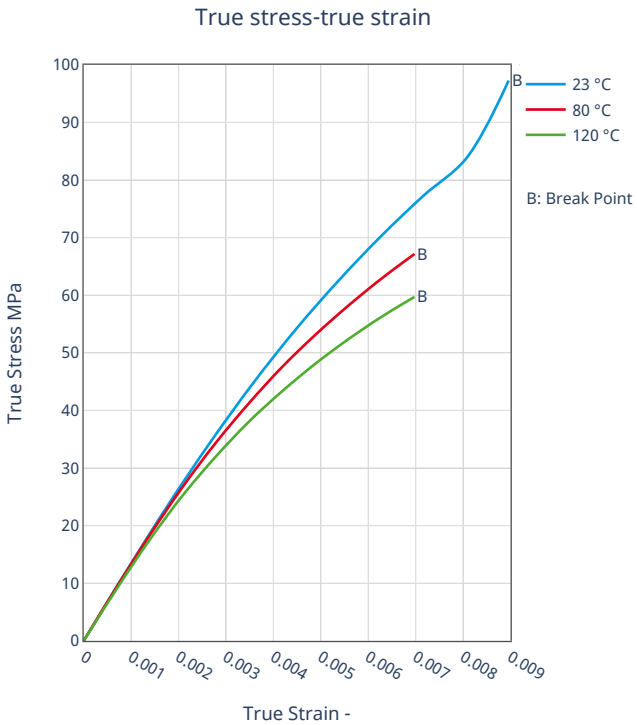
Test Specimen Production	Value	Unit	Standard
Compression molding, cure time	1	min	ISO 295

Diagrams





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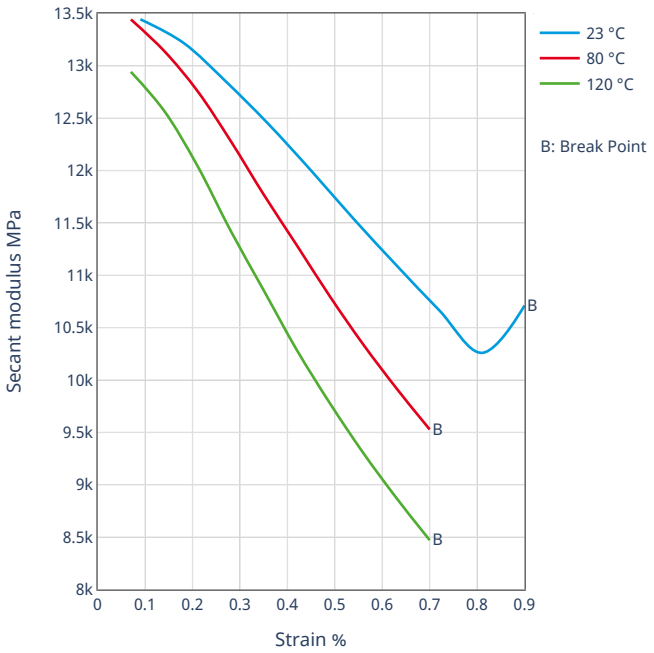
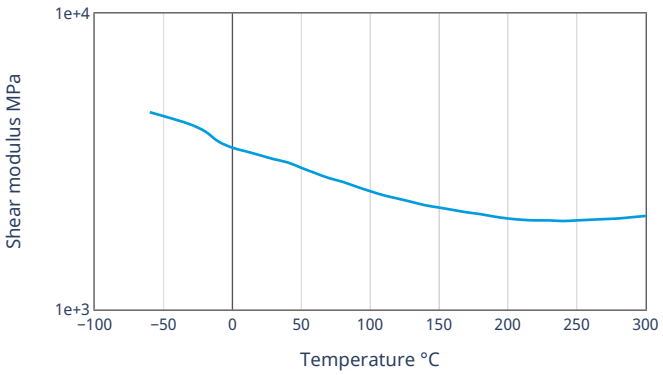
Secant modulus-strain



Dynamic shear modulus-temperature



Processing Information

Injection molding

VERARBEITUNG

Temperature of material:	80 - 100	°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:	>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