

**TECHNICAL DATA SHEET**

# Bakelite® PF 7596

Bakelite Synthetics  
PF-(CF+X)

**Processing**

Injection molding, Transfer molding

**Product Text**
**Product Information**
**Product description:**

Phenolic moulding compound, inorganically/organically filled, modified with graphite, good heat conductivity, good sliding properties (Not suitable for use of higher voltage).

**Application areas:**

Modified with graphite, good heat conductivity, good sliding properties, high dimension stability, fuel pump impellers, bearing parts.

Property Name	Value	Unit	Standard No.
Apparent density (moulding compound)	0.73	g/cm <sup>3</sup>	ISO 60
Moulding shrinkage (injection moulding, longitudinal)	0.3	%	ISO 2577
Post shrinkage (injection moulding, 168h/110°C)	0.1	%	ISO 2577
Tensile strength (5mm/min)	60	MPa	ISO 5 27-1/2
Compr. strength (test spec. flat tested)	130	MPa	ISO 604
Flexural strength (2mm/min)	105	MPa	ISO 178
Flexural modulus	14500	MPa	ISO 178

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Water absorption (24h/23°C) 8 mg similar to ISO 62

Additional characteristics:

galvanize

## 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	0.3	%	ISO 294-4, 2577
Mechanical Properties	Value	Unit	Standard
Tensile modulus	16000	MPa	ISO 527
Poisson's ratio	0.35		ISO 527
Charpy impact strength, +23°C	5	kJ/m <sup>2</sup>	ISO 179/1eU
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 8.00 MPa	175	°C	ISO 75-1/-2
Other Properties	Value	Unit	Standard
Density	1630	kg/m <sup>3</sup>	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
Compression molding, cure time	1	min	ISO 295

## Processing Information

### Injection molding

VERARBEITUNG

Temperature of material: 80 - 100 °C

Mould temperature: 160 - 190 °C

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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