

PF-31

Resin : Phenol - Novolak
Shelf life : 20 months; under 25 °C, under dry conditions
Color : black

	Properties	Method	Unit	Value
General	Apparent density	DIN EN ISO 60	g/cm ³	0,6
	density	ISO 1183	g/cm ³	1,4
	Moulding shrinkage	DIN 53464	%	0,5
Mechanical	Flexural strength	ISO 178	N/mm ²	100
	Flexural modulus	ISO 178	kN/mm ²	7
	Tensile strength	ISO 527	N/mm ²	50
	Impact strength	ISO 179	kJ/m ²	7
	Impact strength notched	DIN 53453	kJ/m ²	1,4
	Ball indentation hardness	ISO 2039	N/mm ²	300
Thermal	Relative Thermal Index	UL 746 B	°C	150
	Thermal expansion	DIN 53752	10 ⁻⁶ /K	20– 30
	HDT-Dimensional stability after 16 h / 180 °C	OIS 75/C (8,0 MPa)	°C	120
Electrical	Surface resistance after 16 h / 180 °C	IEC 93	Ohm	>10 ⁹
	Dielectric strength	IEC 243	kV/mm	>10
	Tracking resistance	IEC 112 / VDE 303	CTI	125
	Volume resistivity	IEC 93	Ohm * cm	>10 ¹²
	After 16 h / 180 °C			

Test specimen in tool according to DIN 53470 – with preplastification

Temperature: 160 °C
 Pressing power: 350 bar
 Pressing time: Bars 10*15*120 mm 10 min
 Plates 4*120*120 mm 5 min

Processing notes:

Compression moulding: 160°C – 180°C Prewarming recommended
 Transfer moulding: 160°C – 180°C

Preplasticising/ Injection:

Feed zone: 60 – 80 °C
 Nozzle zone: 80 – 100 °C
 Back pressure: 5 – 20 bar

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