

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 385 J70 Technical Data

PMC T 385 J70

PMC T 385 J70 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 0,8 to 1,3 % 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 385 J70

Property	Value	Unit	Test Method ISO / ASTM
Spiral Flow	60 to 70	cm	CCP
Specific Gravity	1.41	'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	164	°C	75 – 2 / D648
--- 0,45 M Pa		°C	75 – 2 / D648
Heat Resistance (2h)	180	°C	IEC 60216-P1
Water Absorption (24h)	0.33	%	62 / D570
Flammability acc. To UL94, 6,34 mm	V –0	-	1210 / UL94
Tensile strength	41	M Pa	527 – 2 / D638
Elongation at braek	-	%	527 – 2 / D638
Flexural strength	95	M Pa	178 / D790
Flexural Modulus		M Pa	178 / D790
Charpy Impact	3,6	Kg cm / cm ²	JIS K7111
Izod Impact notched	-	kg.cm/cm	D256
Hardness Rockwell		M	2039 – 2 / D785
Dielectric strength, 2 mm	10,3	KV/mm	243 / D149
Volume resistivity	1 x10 ¹²	Ω-cm	IEC 167 / D257
Surface resistivity	2,4 x10 ¹⁰	Ω	IEC 93 / D257
Dielectric constant		60Hz	IEC 250 / D150
Dielectric loss factor		60Hz	IEC 250 / D150
Arc resistance		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

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