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 399J
Technical Data

PMC T 399J

PMC T 399J is a glass fiber- and mineral-reinforced phenolic injection moulding compound

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	: 60 to 95 ℃	
Nozzle temperatur	: 90 + / - 5 ℃	
Mould temperatures	: 175 to 200℃	
Temperature of material	: 110 to 120 °C	
Times	Hardening Time	: 45 Sek.
	Back pressure	: 8 to 10 bar
Shrinkage	Mould shrinkage is 0,5 % nach Test Methode JIS K6915	

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 399J

Property	Value	Unit	Test Method ISO / ASTM
Spiral Flow	65	cm	CCP
Specific Gravity	1.71	‘g / cm ³	1183 / D792
Melting Point	--	℃	DSC
Coeff. Of linear therm. expansion	--	10^{-5}cm/cm℃	D696
Heat deflection temperature under load			
--- 1,8 M Pa	194	℃	75 – 2 / D648
--- 0,45 M Pa		℃	75 – 2 / D648
Heat Resistance (2h)	210	°C	D648
Water Absorption (24h)	0.04	%	62 / D570
Flammability acc. To UL94,	-	-	1210 / UL94
Tensile strength	-	M Pa	527 – 2 / D638
Elongation at braek	-	%	527 – 2 / D638
Flexural strength	160	M Pa	178 / D790
Flexural Modulus	-	M Pa	178 / D790
Charpy Impact	5,1	Kg cm / cm²	JIS K7111
Izod Impact notched	-	kg.cm/cm	D256
Hardness Rockwell	-	M	2039 – 2 /D785
Dielectric strength, 2 ㎜	17	KV/㎜	243 / D149
Volume resistivity	-	Ω-cm	IEC 167 / D257
Surface resistivity	19,5 x10^{10}	Ω	IEC 93 / D257
Dielectric constant	-	60Hz	IEC 250 / D150
Dielectric loss factor	-	60Hz	IEC 250 / D150
Arc resistance	-	sec	D495

material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits nor used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Chang Chun Plastics cannot anticipate all variations in actual endues conditions the Company makes no warranties and assumes no liability in connection with any use of this information. Nothing of this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.