

<b>Bakelite® PF 2736-9005-S 1</b>		<i>typical</i>	Reviewed on: 16.02.2006
<i>Property:</i>	<i>Standard</i>	<i>Value</i>	<i>Unit</i>
Density * (23 °C)	ISO 1183	1,57	g/cm <sup>3</sup>
Apparent density (moulding compounds)	ISO 60	0,73	g/cm <sup>3</sup>
Injection - Moulding shrinkage	ISO 2577	0,62	%
Injection - Post shrinkage	ISO 2577	0,49	%
Compression - Moulding shrinkage	ISO 2577	0,36	%
Compression - Post shrinkage	ISO 2577	0,43	%
Tensile strength * (5mm/min)	ISO 527 - 1/2		MPa
Tensile modulus * (1mm/min) ①	ISO 527 - 1/2		MPa
Compressive strength (test specimen flat tested)	ISO 604	230	MPa
Flexural strength (2mm/min)	ISO 178	95	MPa
Flexural modulus	ISO 178	9.000	MPa
Charpy impact strength * (23 °C)	ISO 179-1 eU	7,0	kJ/m <sup>2</sup>
Charpy notched impact strength * (23 °C)	ISO 179-1 eA	1,3	kJ/m <sup>2</sup>
Ball indentation hardness (H961/30)	ISO 2039/P1	300	MPa
Temp. of deflection under load. HDT C-8,0MPa	ISO 75-2	130	°C
Surface resistivity * ②		1E+11	Ohm
Volume resistivity * ②		1E+12	Ohm * cm
Dissipation factor * (100 Hz) ③		0,3	
Relative permittivity * (100 Hz) ③		13,5	
Electric strength * (1mm thickness) ④	IEC 60243-P1	20,0	kV/mm
Proof tracking index * (Test liquid A)	IEC 60112	175	PTI
Flammability UL 94 ⑤	UL 94	V-0 / 0,46mm (BK) V-0 / 0,81mm (NC, GN, BK)	Step/mm
Water absorption (24h / 23°C) ⑥		50	mg
Additional characteristics		.5, D, UL	
Product oriented characteristics:	# Optional Suffix "H"		
	Arc Resistance ASTM D-495	Step 5 / 120-180s	
	Comparative tracking index CTI (IEC 60112)		175

**Storage capability**  
 2 years  
 (relative humidity of 50 - 60 % and maximum storage temperature of approximate 20°C)

**Product description:**  
 Phenolic moulding compound, inorganically/organically filled, increased tracking resistance, UL listed moulding compound 0,46 mm / V-0 (BK, Suffix "H"), 0.81 mm / V-0 (NC, GN, BK), 1.5 mm/ V-0 (ALL).

**Application areas:**  
 Bobbins, relays, circuit prot. switches MCB housings, pump parts, sealing flanges, insulating caps, electrical switch gears and lamp holders.

This data sheet is valid until 16.02.2007 . Should this material be purchased after the validity date stated, please request an up-to-date data sheet.

<b>Moulding conditions:</b>		<b>Bakelite® PF 2736-9005-S 1</b>	Reviewed on: 16.02.2006
<b>Injection molding</b>		<b>Compression moldin</b>	
Temperature of material	80 - 100 °C	Mould temperature	160 - 190 °C
Mould temperature	160 - 190 °C	Curing time (per mm of wall thickness)	20 - 40 s
Curing time (per mm of wall thickness)	10 - 20 s	Cavity moulding pressure	>15 MPa
Barrel temperature - Feed zone	60 - 75 °C		
Barrel temperature - Nozzle zone	80 - 100 °C		
Cavity moulding pressure	>15 MPa		
Back pressure	0,5 - 2 MPa		
Holding pressure	ca. 60% of injection pressure		
<b>Technical Customer service:</b>			
Hexion		Postfach 7154	
Gennaer Str. 2 - 4		D- 58609 Iserlohn - Letmathe	
D- 58642 Iserlohn - Letmathe		Tel.: +49 (0) 2374/925-214	
e-mail: ATE-Formmassen@hexionchem.com		Fax : +49 (0) 2374/925-336	
Internet: www.hexionchem.com			
<b>Additional characteristics (see datasheet):</b>			
.5 - Improved electrical properties		HT - Resistant to high temperatures	
.7 - Allowed for contact with food		LB - High arc resistance	
.9 - Ammonia free		M - Dishwasher proof	
A - High surface quality		P - Prod. of test spec. only comp. moulding	
Cu - Copper adhesive		T - Low coefficient of friction	
D - Low shrinkage / good dimensional stability		Typ - Standardized moulding compounds	
E - Elastified		UL - UL listed moulding compound	
EL - For electrostatic coating		UV - Non fade	
ES - Acetic acid free		V - yellowing resistance	
G - galvanize		Z - Special presentation cyl. pellets	
HS - High mechanical strength		L - conductiv	
<b>Explanations:</b>			
① Elongatio $\epsilon_1$ 0,05% , $\epsilon_2$ 0,25%			
② Following IEC 60093			
③ Following IEC 60250			
④ Short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296.			
⑤ UL 94 colour designation:			
ALL = all colours, BG = beige, BK = black, BN = brown, BL = blue, GN = green,			
GY = grey, NC = natural, OR = orange, RD = red, WT = white, YL = yellow			
⑥ Following ISO 62			
	Properties marked with * are elements of the database CAMPUS (Computer Aided Material Preselection by Uniform Standards) and are based on the obliging introduced guide lines of the norm comitee of plastic. (CAMPUS: is a registered trademark of the CWFG)		
<b>Preparation of test specimens of thermosetting moulding compounds:</b>			
Compression to ISO 295 , Injection to ISO 10724		Page 2 of 2	