

Hexion Bakelite™ PF 2535 Phenolic Formaldehyde Resin, High Surface Quality, Dishwasher Proof (discontinued **

Category : Polymer , Thermoset , Filled/Reinforced Thermoset , Phenolic

Material Notes:

Phenolic molding compound, inorganically/organically filled, average heat resistant, steam resistant, dish washer proof, high surface quality. Application areas: Fittings for ovens and dishwashers, tableware/cutlery handles, cookware fittings. Information provided by Bakelite AGBakelite AG became a part of Hexion in 2005.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Hexion-Bakelite-PF-2535-Phenolic-Formaldehyde-Resin-High-Surface-Quality-Dishwasher-Proof-nbspdiscontinued-.php

Physical Properties	Metric	English	Comments
Density	1.50 g/cc	0.0542 lb/in ³	ISO 1183
Apparent Bulk Density	0.700 g/cc	0.0253 lb/in ³	ISO 60
Linear Mold Shrinkage, Flow	0.0075 cm/cm	0.0075 in/in	Injection molding; ISO 2577

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	55.0 MPa	7980 psi	5 mm/min; ISO 527 - 1/2
Tensile Modulus	8.50 GPa	1230 ksi	1 mm/min; ISO 527 - 1/2
Flexural Strength	90.0 MPa	13100 psi	2 mm/min; ISO 178
Flexural Modulus	8.00 GPa	1160 ksi	ISO 178
Compressive Strength	225 MPa	32600 psi	Test specimen flat tested; ISO 604
Charpy Impact Unnotched	0.550 J/cm ²	2.62 ft-lb/in ²	ISO 179-1/2 eU
	@Temperature 23.0 °C	@Temperature 73.4 °F	
Charpy Impact, Notched	0.150 J/cm ²	0.714 ft-lb/in ²	ISO 179-1/2 eA
	@Temperature 23.0 °C	@Temperature 73.4 °F	

Thermal Properties	Metric	English	Comments
Maximum Service Temperature, Air	150 °C	302 °F	<20000 hours; IEC 60216-P1
	230 °C	446 °F	< 50 hours; IEC 60216-P1
Deflection Temperature at 8.0 MPa	115 °C	239 °F	ISO 75-2
Shrinkage	0.500 %	0.500 %	Injection molding; ISO 2577
	@Temperature 110 °C,	@Temperature 230 °F,	

Thermal Properties	Time 605000 sec Metric	Time 168 hour English	Comments
Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+12 ohm-cm	1.00e+12 ohm-cm	IEC 60093
Surface Resistance	1.00e+11 ohm	1.00e+11 ohm	IEC 60093
Dielectric Constant	11	11	IEC 60250
	@Frequency 100 Hz	@Frequency 100 Hz	
Dissipation Factor	0.25	0.25	IEC 60250
	@Frequency 100 Hz	@Frequency 100 Hz	

Processing Properties	Metric	English	Comments
Feed Temperature	60.0 - 75.0 °C	140 - 167 °F	Injection molding
Nozzle Temperature	80.0 - 100 °C	176 - 212 °F	Injection molding
Melt Temperature	80.0 - 100 °C	176 - 212 °F	Injection molding
Mold Temperature	160 - 190 °C	320 - 374 °F	Injection molding
	160 - 190 °C	320 - 374 °F	Compression molding
Injection Pressure	>= 15.0 MPa	>= 2180 psi	Compression and injection cavity mold pressure
Back Pressure	0.500 - 2.00 MPa	72.5 - 290 psi	Injection molding
Cure Time	0.167 - 0.333 min	0.00278 - 0.00556 hour	Per 1 mm of wall thickness, injection molding
	0.333 - 0.667 min	0.00556 - 0.0111 hour	Per 1 mm of wall thickness, compression molding

Descriptive Properties	Value	Comments
Chromatic Spectrum	All Colors	
Creep Rupture Strength	Very Good	
Holding Pressure	Approximately 40-60% of injection pressure	
Media Resistance	Very Good	
Moisture Absorption	30 mg	ISO 62, 24 hours at 23°C
Reserves by Peak Temperature	Very High	
Thermal Expansion	Very Slight	

Contact Songhan Plastic Technology Co.,Ltd.

Website : www.lookpolymers.com

Email : sales@lookpolymers.com

Tel : +86 021-51131842

Mobile : +86 13061808058

Skype : lookpolymers

Address : United North Road 215,Fengxian District, Shanghai City,China