

Hexion Bakelite™ PF 7595 Phenolic Formaldehyde Resin, Low Coefficient of Friction, Galvanized, Conductive (di

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

Material Notes:

Phenolic molding compound, inorganically/organically filled, modified with graphite, good heat conductivity, good sliding properties, conductive in electrical properties. Application areas: Bearers for grinding disc centers, gas meter parts, pump parts, sliding/gliding elements, glide bearing parts. 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-7595-Phenolic-Formaldehyde-Resin-Low-Coefficient-of-Friction-Galvanized-Conductive-nbspdi.php

Physical Properties	Metric	English	Comments
Density	1.57 g/cc	0.0567 lb/in ³	ISO 1183
Apparent Bulk Density	0.880 g/cc	0.0318 lb/in ³	ISO 60
Linear Mold Shrinkage, Flow	0.00050 cm/cm	0.00050 in/in	Compression molding; ISO 2577
	0.0020 cm/cm	0.0020 in/in	Injection molding; ISO 2577

Mechanical Properties	Metric	English	Comments
Ball Indentation Hardness	450 MPa	65300 psi	H 961/30; ISO 2039/P1
Tensile Strength at Break	45.0 MPa	6530 psi	5 mm/min; ISO 527 - 1/2
Tensile Modulus	12.0 GPa	1740 ksi	1 mm/min; ISO 527 - 1/2
Flexural Strength	85.0 MPa	12300 psi	2 mm/min; ISO 178
Flexural Modulus	12.0 GPa	1740 ksi	ISO 178
Compressive Strength	150 MPa	21800 psi	Test specimen flat tested; ISO 604
Charpy Impact Unnotched	0.350 J/cm ²	1.67 ft-lb/in ²	ISO 179-1/2 eU
	@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
	200 °C	392 °F	< 50 hours; IEC 60216-P1
Deflection Temperature at 8.0 MPa	175 °C	347 °F	ISO 75-2
Shrinkage	0.100 %	0.100 %	Compression molding; ISO 2577
	@Temperature 110 °C	@Temperature 230 °F	

Thermal Properties	Metric	English	Comments
	@Temperature 110 °C, Time 605000 sec	@Temperature 230 °F, Time 168 hour	Injection molding; ISO 2577

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	6 mg	ISO 62, 24 hours at 23°C
Reserves by Peak Temperature	Very High	
Thermal Expansion	Very Slight	

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