

Hexion Bakelite™ X22 Phenolic Formaldehyde Resin, UL Listed (discontinued **)

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

Material Notes:

Phenolic molding compound, mainly organically filled, UL listed molding compound 3.0 mm/V-0 (BN, BK). Application areas: Pot handles, operating controls, electrical isolators, housing parts. Information provided by Bakelite AG. Bakelite AG became a part of Hexion in 2005.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Hexion-Bakelite-X22-Phenolic-Formaldehyde-Resin-UL-Listed-nbspdiscontinued-.php

Physical Properties	Metric	English	Comments
Density	1.39 g/cc	0.0502 lb/in ³	ISO 1183
Apparent Bulk Density	0.600 g/cc	0.0217 lb/in ³	ISO 60
Linear Mold Shrinkage, Flow	0.0061 cm/cm	0.0061 in/in	Compression molding; ISO 2577
	0.0095 cm/cm	0.0095 in/in	Injection molding; ISO 2577

Mechanical Properties	Metric	English	Comments
Ball Indentation Hardness	275 MPa	39900 psi	H 961/30; ISO 2039/P1
Tensile Strength at Break	55.0 MPa	7980 psi	5 mm/min; ISO 527 - 1/2
Tensile Modulus	7.50 GPa	1090 ksi	1 mm/min; ISO 527 - 1/2
Flexural Strength	90.0 MPa	13100 psi	2 mm/min; ISO 178
Flexural Modulus	7.50 GPa	1090 ksi	ISO 178
Compressive Strength	225 MPa	32600 psi	Test specimen flat tested; ISO 604
Charpy Impact Unnotched	0.650 J/cm ²	3.09 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
Deflection Temperature at 8.0 MPa	105 °C	221 °F	ISO 75-2
UL RTI, Electrical	150 °C	302 °F	(BN, BK)
	@Thickness 1.50 mm	@Thickness 0.0591 in	
UL RTI, Mechanical with Impact	150 °C	302 °F	(BN, BK)

Thermal Properties	@Thickness 1.50 mm Metric	@Thickness 0.0591 in English	Comments
UL RTI, Mechanical without Impact	150 °C @Thickness 1.50 mm	302 °F @Thickness 0.0591 in	(BN, BK)
Flammability, UL94	HB @Thickness 1.50 mm	HB @Thickness 0.0591 in	(BN, BK)
	V-0 @Thickness 3.00 mm	V-0 @Thickness 0.118 in	BK, BN
Shrinkage	0.450 % @Temperature 110 °C	0.450 % @Temperature 230 °F	Compression molding; ISO 2577
	0.550 % @Temperature 110 °C, Time 605000 sec	0.550 % @Temperature 230 °F, Time 168 hour	Injection molding; ISO 2577

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+11 ohm-cm	1.00e+11 ohm-cm	IEC 60093
Surface Resistance	1.00e+10 ohm	1.00e+10 ohm	IEC 60093
Dielectric Constant	10 @Frequency 100 Hz	10 @Frequency 100 Hz	IEC 60250
Dielectric Strength	20.0 kV/mm @Thickness 1.00 mm	508 kV/in @Thickness 0.0394 in	IEC 60243-P1
Dissipation Factor	0.30 @Frequency 100 Hz	0.30 @Frequency 100 Hz	IEC 60250
Arc Resistance	60 - 120 sec @Thickness 3.00 mm	60 - 120 sec @Thickness 0.118 in	BK, BN
Comparative Tracking Index	125 V	125 V	Test liquid A; IEC 60112
Hot Wire Ignition, HWI	60 - 120 sec @Thickness 1.50 mm	60 - 120 sec @Thickness 0.0591 in	(BN, BK)
	>= 120 sec @Thickness 3.00 mm	>= 120 sec @Thickness 0.118 in	BK, BN
High Amp Arc Ignition, HAI	60 - 120 arcs @Thickness 1.50 mm	60 - 120 arcs @Thickness 0.0591 in	(BN, BK)
	>= 120 arcs	>= 120 arcs	

Electrical Properties	Metric @ Thickness 3.00 mm	English @ Thickness 0.118 in	BK, BN Comments
High Voltage Arc-Tracking Rate, HVTR	10.0 - 25.4 mm/min @ Thickness 3.00 mm	0.394 - 1.00 in/min @ Thickness 0.118 in	BK, BN

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	Subdued Colors	
Creep Rupture Strength	Good	
Holding Pressure	Approximately 40-60% of injection pressure	
Media Resistance	Good	
Moisture Absorption	75 mg	ISO 62, 24 hours at 23°C
Reserves by Peak Temperature	High	
Thermal Expansion	Slight	

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