

## Hexion Bakelite™ PF 14600 Phenolic Formaldehyde Resin, High Surface Quality (discontinued \*\*)

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

### Material Notes:

Phenolic molding compound, mainly organically filled, low specific gravity. Application areas: Cookware fittings, electric devices. 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-14600-Phenolic-Formaldehyde-Resin-High-Surface-Quality-nbspdiscontinued.php](http://www.lookpolymers.com/polymer_Hexion-Bakelite-PF-14600-Phenolic-Formaldehyde-Resin-High-Surface-Quality-nbspdiscontinued.php)

Physical Properties	Metric	English	Comments
Density	1.37 g/cc	0.0495 lb/in <sup>3</sup>	ISO 1183
Apparent Bulk Density	0.550 g/cc	0.0199 lb/in <sup>3</sup>	ISO 60
Linear Mold Shrinkage, Flow	0.0065 cm/cm	0.0065 in/in	Compression molding; ISO 2577

Mechanical Properties	Metric	English	Comments
Flexural Strength	95.0 MPa	13800 psi	2 mm/min; ISO 178
Flexural Modulus	7.00 GPa	1020 ksi	ISO 178
Charpy Impact Unnotched	0.550 J/cm <sup>2</sup> @Temperature 23.0 °C	2.62 ft-lb/in <sup>2</sup> @Temperature 73.4 °F	ISO 179-1/2 eU
Charpy Impact, Notched	0.140 J/cm <sup>2</sup> @Temperature 23.0 °C	0.666 ft-lb/in <sup>2</sup> @Temperature 73.4 °F	ISO 179-1/2 eA

Thermal Properties	Metric	English	Comments
Deflection Temperature at 8.0 MPa	105 °C	221 °F	ISO 75-2
Shrinkage	0.550 % @Temperature 110 °C	0.550 % @Temperature 230 °F	Compression 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	12 @Frequency 100 Hz	12 @Frequency 100 Hz	IEC 60250
	0.35	0.35	

Electrical Properties	Metric @ Frequency 100 Hz	English @ Frequency 100 Hz	IEC 60250 Comments
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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	95 mg	ISO 62, 24 hours at 23°C
Reserves by Peak Temperature	High	
Thermal Expansion	Slight	

## Contact Songhan Plastic Technology Co.,Ltd.

Website : [www.lookpolymers.com](http://www.lookpolymers.com)

Email : [sales@lookpolymers.com](mailto:sales@lookpolymers.com)

Tel : +86 021-51131842

Mobile : +86 13061808058

Skype : lookpolymers

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