Hexion Bakelite™ PF 2137 Phenolic Formaldehyde Resin, High Surface Quality, Dishwasher Proof (discontinued **

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

Material Notes:

Phenolic molding compound, inorganically/organically filled, glass fiber reinforced, increased heat resistance, minimal distortion, dish washer proof.Application areas: Iron heat shields, fittings for ovens, dishwashers, and toilet seats.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-2137-Phenolic-Formaldehyde-Resin-High-Surface-Quality-Dishwasher-Proof-nbspdiscontinued-.php

Physical Properties	Metric	English	Comments
Density	1.42 g/cc	0.0513 lb/in³	ISO 1183
Apparent Bulk Density	0.620 g/cc	0.0224 lb/in³	ISO 60
Linear Mold Shrinkage, Flow	0.0040 cm/cm	0.0040 in/in	Compression molding; ISO 2577
	0.0090 cm/cm	0.0090 in/in	Injection molding; ISO 2577

Mechanical Properties	Metric	English	Comments
Ball Indentation Hardness	350 MPa	50800 psi	H 961/30; ISO 2039/P1
Flexural Strength	95.0 MPa	13800 psi	2 mm/min; ISO 178
Flexural Modulus	7.50 GPa	1090 ksi	ISO 178
Compressive Strength	250 MPa	36300 psi	Test specimen flat tested; ISO 604
Charpy Impact Unnotched	0.700 J/cm² @Temperature 23.0 °C	3.33 ft-lb/in² @Temperature 73.4 °F	ISO 179-1/2 eU
Charpy Impact, Notched	0.150 J/cm² @Temperature 23.0 °C	0.714 ft-lb/in² @Temperature 73.4 °F	ISO 179-1/2 eA

Thermal Properties	Metric	English	Comments
Maximum Service Temperature, Air	145 °C	293 °F	<20000 hours; IEC 60216-P1
	240 °C	464 °F	< 50 hours; IEC 60216-P1
Deflection Temperature at 8.0 MPa	125 °C	257 °F	ISO 75-2
Shrinkage	0.350 % @Temperature 110 °C	0.350 % @Temperature 230 °F	Compression molding; ISO 2577

Thermal Properties	Metric	English	Comments
	0.459 %	0.459 %	Injection molding; ISO 2577
	@Temperature 110 °C, Time 605000 sec	@Temperature 230 °F, Time 168 hour	

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	8.0 @Frequency 100 Hz	8.0 @Frequency 100 Hz	IEC 60250
Dielectric Strength	25.0 kV/mm @Thickness 1.00 mm	635 kV/in @Thickness 0.0394 in	IEC 60243-P1
Dissipation Factor	0.25 @Frequency 100 Hz	0.25 @Frequency 100 Hz	IEC 60250
Comparative Tracking Index	125 V	125 V	Test liquid A; IEC 60112

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	

Descriptive Properties	Value	Comments
Media Resistance	Very Good	
Moisture Absorption	50 mg	ISO 62, 24 hours at 23°C
Reserves by Peak Temperature	Very High	
Thermal Expansion	Very Slight	

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