

**MATERIALS ENGINEERING**  
Technical Datasheet  
**PLENCO 04527**  
Single-Stage Phenolic  
transfer molded

PLENCO 04527 is a heat resistant, mineral and flock filled phenolic molding compound, offering excellent mechanical strength, and resistance to cracking in a wet-dry environment. UL recognized under component file E40654. 04527 is available in black.

<b>PROPERTY</b>	<b>metric</b>	<b>english</b>	<b>ASTM Test Method</b>
Form	Granular		
Apparent Density	0.61 g/cm <sup>3</sup>	38.2 lb/ft <sup>3</sup>	D1895
Specific Gravity	1.59		D792
Mold Shrinkage*	0.0036 m/m	0.0036 in/in	D6289
Post Shrinkage 72hr 120°C	0.32 %		D6289
Izod Impact Notched	25.7 J/m	0.48 ft·lb/in	D256
Charpy Impact Notched	24.5 J/m	0.46 ft·lb/in	D256
Drop Ball Impact	153 J/m	2.9 ft·lb/in	Plenco
Tensile Strength	61 MPa	8,903 psi	D638
Tensile Modulus	9,990 MPa	1,449,000 psi	D638
Tensile Elongation	1.0 %		D638
Flexural Strength	89.9 MPa	13,042 psi	D790
Flexural Modulus	9,664 MPa	1,402,000 psi	D790
Compressive Strength	170 MPa	24,595 psi	D695
Heat Resistance	204 °C	399 °F	D794
Deflection Temperature 1.82MPa	235 °C	455 °F	D648
Water Absorption	0.46 %		D570
Rockwell Hardness	71 E scale		D785
Dielectric Strength short time	8.5 kV/mm	215 V/mil	D149
Dissipation Factor, 1MHz	0.104		D150
Permittivity, 1MHz	7.5		D150
Volume Resistivity	1.5E+12 ohm·cm	5.9E+11 ohm·in	D257
ASTM Arc Resistance	183 sec		D495
Comparative Tracking Index	195 V		D3638
UL Flammability	V-1 @1.5mm		UL 94
Oxygen Index	33.0 %		D2863
Coefficient of Thermal Expansion	3.9E-05 /°C	2.2E-05 /°F	E831
Thermal Conductivity 100°C	0.49 W/m°C	0.28 Btu/hr/ft/°F	E1461

Limited Shelf-Life. Actual shelf-life obtained is dependent on storage conditions, molding process, and mold design. Store in cool dry place.  
*The Typical Values listed are results obtained from the testing of standard specimens using the stated test procedures, with said specimens molded under controlled laboratory conditions from representative samplings of the product. Although Plastics Engineering Company at all times reserves the right to make changes in the materials, suppliers and processing, the values listed as typical are those to be expected at the time of our manufacture. The final determination of the accuracy or completeness of any information, the suitability of the product for the use contemplated, the manner of its use, and the matter of any infringement of patents in use, are all the sole responsibility of the user. PLASTICS ENGINEERING COMPANY MAKES NO WARRANTY, EXPRESS OR IMPLIED, WITH RESPECT TO THIS PRODUCT, INCLUDING NO WARRANTY OF THE MERCHANTABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE. Plastics Engineering Company reserves at all times the right to discontinue the production of any or all of its products. This is an uncontrolled copy and not subject to updates.*  
 \*Mold Shrinkage obtained under controlled laboratory conditions with relatively simple mold geometry and should be used for comparison purposes only and not for actual tool design.