

Technical Data Sheet

Bakelite® UP 802

Product Description

Polyester moulding compound, inorganically filled, glass fibre reinforced, styrene free, high dimensional stability, very slight post shrinkage, good mechanical properties, increased electrical values.

Application Areas

Ignition distributor caps, distributor fingers, spark plug connectors

Typical Properties

Bakelite UP 802

<https://www.hexion.com/en-US/product/bakelite-up-802>

Generated: September 18, 2019

Issue Date:

Revision:

® and [™] Licensed trademarks of Hexion Inc.

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. **HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION**, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Property	Value	Unit	Standard
Additional Characteristic	A, D, LB		
Apparent Density	0,89	g/cm ³	ISO 60
Ball Indentation Hardness H961/30	360	MPa	IEC 60243-P1
Charpy Impact Strength 23°C	6,5	kJ/m ²	ISO 179-1 eU
Charpy Notched Impact Strength 23°C	3,5	kJ/m ²	ISO 179-1 eA
Compression - Moulding shrinkage	0,2	%	ISO 2577
Compression - Post shrinkage	0,05	%	ISO 2577
Compressive Strength Test Specimen Flat Tested	250	MPa	ISO 604
Density 23°C	1,98	g/cm ³	ISO 1183
Dissipation Factor 100 Hz, Following IEC 60250	0,02		
Electric Strength 1mm Thickness, Short Term, Electrode Layout P25mm/P25mm in Transformer Oil Equivalent to IEC 60296	26,0	kV/mm	IEC 60243-P1
Flexural Modulus	12500	MPa	ISO 178
Flexural Strength 2mm/min	100	MPa	ISO 178
Injection - Moulding Shrinkage	0	%	ISO 2577
Injection - Post Shrinkage	0	%	ISO 2577
Proof Tracking Index Test Liquid A	600	PTI	IEC 60112
Relative Permittivity 100 Hz, Following IEC 60250	5,5		
Surface Resistivity Following IEC 60093	1E+12	Ohm	
Temp. of Deflection Under Load HDT C-8,0 MPa	185	°C	ISO 75-2
Tensile Modulus 1mm/min, Elongation e1 0,05%; e2 0,25%		MPa	ISO 527 - 1/2
Tensile Strength 5mm/min	0	MPa	ISO 527 - 1/2
Volume Resistivity Following IEC 60093	1E+13	Ohm*cm	
Water Absorption 24h / 23°C, Following ISO 62	25	mg	

Preparation of Test Specimens of Thermosetting Moulding Compound

- Compression to ISO 295
- Injection to ISO 10724

Moulding Conditions

Bakelite UP 802

<https://www.hexion.com/en-US/product/bakelite-up-802>

Generated: September 18, 2019

Issue Date:

Revision:

© and ™ Licensed trademarks of Hexion Inc.

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. **HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION**, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Property	Value	Unit
Cavity Moulding Pressure	>15	MPa
Curing Time (per mm of Wall Thickness)	20 - 40	s
Mould Temperature	160 - 190	°C

Property	Value	Unit
Back Pressure	0,5 - 2	MPa
Barrel Temperature - Feed Zone	60 - 75	°C
Barrel Temperature - Nozzle Zone	80 - 100	°C
Cavity Moulding Pressure	>15	MPa
Curing Time per mm of Wall Thickness	10 - 20	s
Holding Pressure	injection pressure	ca. 60%
Mould Temperature	160 - 190	°C
Temperature of Material	80 - 100	°C

Storage Capability

12 months (shorter shelf life for darker colours), (relative humidity of 50-60% and maximum storage temperature of approximately 20°C)

Contact Information

Hexion GmbH
 Gennaer Str. 2-4
 Germany 58642 Iserlohn-Letmathe
 e-mail: molding-compounds@Hexion.com
 Internet: www.hexion.com

Postfach 7154
 Germany 58609 Iserlohn-
 Letmathe
 Tel.: +49 (0) 2374 / 925 280
 Fax: +49 (0) 2374 / 925 723