PF (woodflour and mineral filled, molding)

General information

Designation

Phenol formaldehyde (Woodflour and Mineral Filled, Molding)

Tradenames

Bakelite; Durez; Ferropreg; Fiberite; Norsophen; Plaslok; Plenco; Polychem; Reliapreg; Resinoid; Texolite; Trolitan; Vyncolite

Typical uses

Adhesives for automotive brake linings; Binders for wood-particle board; Water-resistant adhesive for plywood; Impregnating paper for electrical laminates; Hardening elastomers

Composition overview

Compositional summary

PF + woodflour + mineral filler

Material family		Plastic (thermoset)			
Base material		PF (Phenol formaldehyde resin)			
% filler (by weight)	*	30	-	60	%
Filler/reinforcement		Wood			
Filler/reinforcement form		Particulate			
Polymer code		PF-(NX+MD)30			

Composition detail (polymers and natural materials)

Polymer	60	-	80	%
Mineral (unspecified)	10	-	20	%
Woodflour / cellulose	10	-	20	%

Price

Price	*	1.04	-	1.14	USD/lb

Physical properties

Density	0.052	-	0.0564	lb/in^3

Mechanical properties

Young's modulus		1	-	1.8	10^6 psi
Yield strength (elastic limit)	*	5.2	-	6	ksi
Tensile strength		6.5	-	7.5	ksi
Elongation	*	1.65	-	3.09	% strain
Compressive modulus	*	1	-	1.8	10^6 psi
Compressive strength	*	24.9	-	30	ksi
Flexural modulus		1.2	-	1.3	10^6 psi
Flexural strength (modulus of rupture)		9.01	-	12	ksi
Shear modulus	*	0.376	-	0.676	10^6 psi
Bulk modulus	*	1.28	-	1.35	10^6 psi
Poisson's ratio		0.31	-	0.35	
Shape factor		14			
Hardness - Vickers	*	10.8	-	12.4	HV
Hardness - Rockwell M	*	100	-	110	
Hardness - Rockwell R	*	121	-	133	
Fatigue strength at 10^7 cycles	*	2.46	-	3.19	ksi
Mechanical loss coefficient (tan delta)	*	0.00687	-	0.0103	

Impact & fracture properties

Fracture toughness	*	1.04	-	1.76	ksi.in^0.5

Impact strength, notched 23 °C		9.17e-4	-	0.0011	BTU/in^2
Impact strength, unnotched 23 °C		0.00284	-	0.00436	BTU/in^2

Thermal properties

Glass temperature		338	-	518	°F
Heat deflection temperature 0.45MPa	*	388	-	459	°F
Heat deflection temperature 1.8MPa		360	-	379	°F
Maximum service temperature	*	288	-	315	°F
Minimum service temperature	*	-45.4	-	44.6	°F
Thermal conductivity		0.145	-	0.242	BTU.ft/hr.ft^2.°F
Specific heat capacity	*	0.314	-	0.326	BTU/lb.°F
Thermal expansion coefficient		30	-	40	µstrain/°F

Electrical properties

Electrical resistivity	*	3.3e15	-	3e16	µohm.cm
Dielectric constant (relative permittivity)		5.8	-	7	
Dissipation factor (dielectric loss tangent)	*	0.07	-	0.1	
Dielectric strength (dielectric breakdown)		330	-	376	V/mil
Comparative tracking index		125	-	225	V

Optical properties

Transparency	Opaque

Magnetic properties

Magnetic type	Non-magnetic

Bio-data

RoHS (EU) compliant grades?	✓

Absorption & permeability

Water absorption @ 24 hrs		0.2	-	0.35	%

Processing properties

Polymer injection molding		Acceptable			
Polymer extrusion		Unsuitable			
Polymer thermoforming		Unsuitable			
Linear mold shrinkage		0.3	-	0.8	%
Melt temperature		331	-	390	°F
Mold temperature		302	-	338	°F
Molding pressure range		2	-	20	ksi

Durability

Water (fresh)	Excellent
Water (salt)	Excellent
Weak acids	Excellent
Strong acids	Limited use
Weak alkalis	Unacceptable
Strong alkalis	Unacceptable
Organic solvents	Excellent
Oxidation at 500C	Unacceptable
UV radiation (sunlight)	Good
Flammability	Self-extinguishing

Primary production energy, CO2 and water

Embodied energy, primary production	* 2.49e4	-	2.75e4	BTU/lb
CO2 footprint, primary production	* 3.76	-	4.15	lb/lb
NOx creation	* 0.0126	-	0.0139	lb/lb
SOx creation	* 0.0377	-	0.0417	lb/lb
Water usage	* 7.89e3	-	8.72e3	in^3/lb

Processing energy, CO2 footprint & water

Polymer molding energy	* 6.67e3	-	7.38e3	BTU/lb
Polymer molding CO2	* 1.16	-	1.29	lb/lb
Polymer molding water	* 312	-	468	in^3/lb
Coarse machining energy (per unit wt removed)	* 718	-	794	BTU/lb
Coarse machining CO2 (per unit wt removed)	* 0.125	-	0.139	lb/lb
Fine machining energy (per unit wt removed)	* 5.35e3	-	5.91e3	BTU/lb
Fine machining CO2 (per unit wt removed)	* 0.933	-	1.03	lb/lb
Grinding energy (per unit wt removed)	* 1.05e4	-	1.16e4	BTU/lb
Grinding CO2 (per unit wt removed)	* 1.83	-	2.02	lb/lb

Recycling and end of life

Recycle	✗			
Recycle fraction in current supply	0.1			%
Downcycle	✓			
Combust for energy recovery	✓			
Heat of combustion (net)	* 1.04e4	-	1.09e4	BTU/lb
Combustion CO2	* 2.22	-	2.33	lb/lb
Landfill	✓			
Biodegrade	✗			

Geo-economic data for principal component

Principal component	Phenol formaldehyde			
Annual world production	9.35e6	-	1.03e7	ton/yr
Reserves	2.34e8	-	2.59e8	l. ton

Links

ProcessUniverse

Producers

Reference

Shape