

Bakelite® UP 3620

Thermoset Polyester

Hexion Inc.

Message:

Product Description

Polyester moulding compound, mainly organically filled, styrene free, processing shrinkage as for phenolic moulding compounds, nonflammable, high surface quality, UL listed moulding compound 1,5 mm / V-0 (ALL)

Application Areas

Lamp housings, neon tubes end parts and bases, switch gears, watt hour meters housings and base plates

General Information	
Filler / Reinforcement	Organic
Features	Flame Retardant
	Good Surface Finish
Uses	Gears
	Housings
Processing Method	Compression Molding
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.72	g/cm ³	ISO 1183
Apparent Density	0.70	g/cm ³	ISO 60
Molding Shrinkage			ISO 2577
-- ¹	0.60	%	
-- ²	0.75	%	
Water Absorption - 24h/23C	70.0	mg	ISO 62
Post Shrinkage			ISO 2577
-- ³	0.25	%	
-- ⁴	0.25	%	
Compression Molding Molding Pressure	> 10.0	MPa	
Compression Molding Temperature	160 to 180	°C	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 961/30)	250	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8500	MPa	ISO 527-2/1
Tensile Stress	50.0	MPa	ISO 527-2/5
Flexural Modulus	8000	MPa	ISO 178
Flexural Stress ⁵	85.0	MPa	ISO 178
Compressive Stress	180	MPa	ISO 604

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	1.8	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	7.5	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (8.0 MPa, Unannealed)	75.0	°C	ISO 75-2/C
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+12	ohms·cm	IEC 60093
Electric Strength ⁶ (1.00 mm)	30	kV/mm	IEC 60243-1
Relative Permittivity (100 Hz)	5.00		IEC 60250
Dissipation Factor (100 Hz)	0.020		IEC 60250
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, All)	V-0		UL 94
Injection	Nominal Value	Unit	
Rear Temperature	60.0 to 70.0	°C	
Nozzle Temperature	70.0 to 100	°C	
Processing (Melt) Temp	70.0 to 100	°C	
Mold Temperature	160 to 180	°C	
Injection Pressure	> 10.0	MPa	
Back Pressure	0.500 to 1.00	MPa	
NOTE			
1.	Compression		
2.	Injection		
3.	Injection		
4.	Compression		
5.	2.0 mm/min		
6.	short term, electrode layout P25mm/P25mm in transformer oil equivalent to IEC 60296		

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