

MELOPAS® MF 156

Melamine Formaldehyde

RASCHIG GmbH

Message:

Glass fibre reinforced Melamine moulding compound

Primary application(s): Moulded parts in electrical engineering

This product meets the allowed upper limits for heavy metals and PCAs and also conforms to the requirements of the EU directives 2002/95 (RoHS), 2002/96 (WEEE) and 2006/122 (PFOS)

Identification according to ISO 14528-1: MF (GF20+MD25) - (GF30+MD15)

DIN 7708: MF 156

General Information			
Filler / Reinforcement	Glass Fiber		
Uses	Electrical Parts		
Agency Ratings	EU 2002/96/EC (WEEE)		
	EU 2006/122/EC		
RoHS Compliance	RoHS Compliant		
Forms	Granules		
Processing Method	Compression Molding		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Density	1.80 to 1.90	g/cm ³	ISO 1183
Apparent Density	0.60 to 0.80	g/cm ³	ISO 60
Molding Shrinkage - Flow ¹	0.50 to 0.90	%	ISO 2577
Water Absorption (23°C, 24 hr)	< 1.0	%	ISO 62
Post Shrinkage ²	0.70 to 1.0	%	ISO 2577
Maximum Service Temperature			IEC 60216
<50 h	200	°C	
20,000 h	150	°C	
Compression Molding Molding Pressure	> 20.0	MPa	
Compression Molding Temperature	160 to 180	°C	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ISO 527-2
Compression Molded	7000 to 9000	MPa	
Injection Molded	8000 to 10000	MPa	
Tensile Stress			ISO 527-2
Compression Molded	40.0 to 50.0	MPa	
Injection Molded	45.0 to 60.0	MPa	
Flexural Modulus			ISO 178
Compression Molded	9000 to 11000	MPa	

Injection Molded	10000 to 12000	MPa	
Flexural Stress			ISO 178
Compression Molded	90.0 to 110	MPa	
Injection Molded	100 to 120	MPa	
Compressive Stress	200 to 250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
Compression Molded	1.5 to 3.0	kJ/m ²	
Injection Molded	2.5 to 4.0	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
Compression Molded	4.0 to 7.0	kJ/m ²	
Injection Molded	7.0 to 9.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, Unannealed	> 200	°C	ISO 75-2/A
8.0 MPa, Unannealed	130 to 150	°C	ISO 75-2/C
CLTE - Flow (50 to 100°C)	1.5E-5 to 3.5E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.50 to 0.60	W/m/K	ASTM E1461
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+11 to 1.0E+12	ohms·cm	IEC 60093
Electric Strength	20 to 30	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
	16.0		
100 Hz	11.0		
	9.00		
1 MHz	7.00		
Dissipation Factor			IEC 60250
100 Hz	0.20 to 0.40		
1 MHz	0.020 to 0.040		
Arc Resistance	PLC 5		ASTM D495
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	900	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	

Middle Temperature	70.0 to 90.0	°C
Front Temperature	90.0 to 100	°C
Processing (Melt) Temp	100 to 115	°C
Mold Temperature	160 to 180	°C
Back Pressure	0.800 to 1.20	MPa
Screw Speed	80 to 120	rpm

NOTE

1. Compression Molded
2. 168 h / 110°C

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

