

MELOPAS® MF 2500

Melamine Formaldehyde

RASCHIG GmbH

Message:

Cellulose reinforced Melamine moulding compound

Very good electrical properties, excellent surface hardness, good wear and UV-stability, very good chemical resistance

Primary application(s): Moulded parts in electrical engineering, mountings for household appliances

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)

General Information			
Filler / Reinforcement	Cellulose		
Features	Good Chemical Resistance		
	Good Electrical Properties		
	Good UV Resistance		
	Good Wear Resistance		
	High Hardness		
Uses	Appliance Components		
	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	1.60 to 1.75	g/cm ³	ISO 1183
Apparent Density	0.55 to 0.75	g/cm ³	ISO 60
Molding Shrinkage - Flow			ISO 2577
-- ¹	0.50 to 1.0	%	
-- ²	0.80 to 1.3	%	
Water Absorption (23°C, 24 hr)	< 2.5	%	ISO 62
Post Shrinkage ³	1.2 to 2.0	%	ISO 2577
Maximum Service Temperature			IEC 60216
<50 h	160	°C	
20,000 h	135	°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	5000 to 8000	MPa	
Injection Molded	5000 to 8000	MPa	
Tensile Stress			ISO 527-2
Compression Molded	40.0 to 65.0	MPa	
Injection Molded	70.0 to 90.0	MPa	
Flexural Modulus			ISO 178
Compression Molded	5000 to 8000	MPa	
Injection Molded	5000 to 8000	MPa	
Flexural Stress			ISO 178
Compression Molded	100 to 130	MPa	
Injection Molded	110 to 140	MPa	
Compressive Stress	200 to 250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
Compression Molded	1.3 to 1.5	kJ/m ²	
Injection Molded	1.3 to 1.5	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
Compression Molded	7.0 to 10	kJ/m ²	
Injection Molded	8.0 to 13	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, Unannealed	170 to 190	°C	ISO 75-2/A
8.0 MPa, Unannealed	120 to 140	°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	0.40 to 0.50	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	0.30 to 0.50		
1 MHz	0.030 to 0.050		
Arc Resistance	PLC 5	ASTM D495	
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 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.	Injection Molded		
3.	168 h / 110°C		

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