

MELOPAS® MF 152

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)

Identification according to ISO 14528-3: MF (LD25+MD20) - (LD35+MD10)

DIN 7708: MF 152

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	1.50 to 1.70	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)	< 2.0	%	ISO 62
Post Shrinkage ³	1.0 to 1.5	%	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	45.0 to 65.0	MPa	
Injection Molded	50.0 to 90.0	MPa	
Flexural Modulus			ISO 178
Compression Molded	8000 to 9000	MPa	
Injection Molded	8000 to 9000	MPa	
Flexural Stress			ISO 178
Compression Molded	80.0 to 110	MPa	
Injection Molded	90.0 to 130	MPa	
Compressive Stress	200 to 250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
Compression Molded	1.2 to 1.8	kJ/m ²	
Injection Molded	1.4 to 2.0	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
Compression Molded	5.0 to 9.0	kJ/m ²	
Injection Molded	7.0 to 12	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, Unannealed	155 to 180	°C	ISO 75-2/A
8.0 MPa, Unannealed	110 to 130	°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	15 to 20	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 (1.50 mm, Tested by RASCHIG)

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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