

MELOPAS® MP 6605

Melamine Phenolic

RASCHIG GmbH

Message:

Cellulose reinforced Melamine moulding compound

Very good electrical properties, excellent surface hardness, good mechanical strength and heat resistance, good wear and UV-stability, good gliding behaviour

Primary application(s): Moulded parts in electrical engineering, arc chambers

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 Electrical Properties		
	Good Strength		
	Good UV Resistance		
	Good Wear Resistance		
	High Hardness		
	Medium Heat Resistance		
Uses	Electrical Parts		
Agency Ratings	EU 2002/96/EC (WEEE)		
	EU 2006/122/EC		
RoHS Compliance	RoHS Compliant		
Forms	Granules		
Processing Method	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 ¹	0.80 to 1.2	%	ISO 2577
Water Absorption (23°C, 24 hr)	< 2.0	%	ISO 62
Post Shrinkage ²	1.2 to 1.8	%	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 (Injection Molded)	5000 to 8000	MPa	ISO 527-2
Tensile Stress (Injection Molded)	60.0 to 85.0	MPa	ISO 527-2
Flexural Modulus (Injection Molded)	6000 to 8000	MPa	ISO 178

Flexural Stress (Injection Molded)	90.0 to 110	MPa	ISO 178
Compressive Stress	200 to 250	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (Injection Molded)	1.3 to 2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (Injection Molded)	7.0 to 11	kJ/m ²	ISO 179/1eU
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	20 to 25	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.	Injection Molded	
2.	168 h / 110°C	

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