

# Melochem 736

Melamine Formaldehyde

Chemiplastica, Inc.

## Message:

The Melochem 736 Dry Granulated Moulding Compound are based on melamine-formaldehyde resins fortified with high-class cellulose as reinforcement and further modified with minor amounts of special purpose additives, pigments, cure regulators and lubricants.

Our Melochem 736 grade is a general-purpose injection grade. Chemical components are chosen with the purpose of minimizing the potential risks to working environment and nature.

The Melochem 736 Moulding Compounds can be supplied in most colours from translucent pastels to black.

Moulded parts are free from odour, light stable and have good moisture resistance and water absorption and are therefore dishwasher safe.

Excellent surface hardness and glossy surface is combined with excellent chemical resistance. Fats, oils and common organic solvents like alcohol and acetone do not attack the materials and they are also resistant to surfactants and weak bases. They will withstand attack from weak acids for a shorter duration.

Oxygen index is 40% and is achieved without the use of external flame-retardants. No halogens are present in the composition.

The products comply with the requirements of the widely used material specifications :

DIN 7708 type 152 and 152.7 (\*)

ISO 2112 type MF B10 and B11 (\*)

UL certified

(\*) included in ISO 14528

Fields of application: With unique porcelain-like properties, which are not matched by any other plastic material, the Melochem 736 Moulding Compound is used in a number of household applications like dinnerware jugs ladles, bowls and similar objects.

Grade 736 is also used in electrical applications requiring heat resistance and abrasion resistance.

Melochem products have a high-class feel and can be manufactured by using productive plastic technology.

Melochem products are particularly suited for manufacture of scratch resistance and dishwasher safe products.

General Information		
UL YellowCard	E177332-226446	E70218-249106
Filler / Reinforcement	Fiber filler	
Additive	Lubricant	
	Unspecified additive	
Features	Moisture resistance	
	Highlight	
	Light stabilization	
	Solvent resistance	
	Updatable resources	
	Recyclable materials	
	Good wear resistance	
	Scratch resistance	
	Good chemical resistance	
	Alcohol resistance	
	Heat resistance, high	
	Oil resistance	
	The smell is low to none	
	Lubrication	
	General	

Halogen-free  
Low or no water absorption  
High hardness

Uses	Electrical components Household goods General Table products		
Appearance	Available colors		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			ISO 2577
-- <sup>1</sup>	1.1 - 1.3	%	ISO 2577
--	0.60 - 0.80	%	ISO 2577
Water Absorption		mg	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	> 55.0	MPa	ISO 527-2
Flexural Stress	> 100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	> 1.3	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength	> 8.0	kJ/m <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	> 155	°C	ISO 75-2/A
8.0 MPa, not annealed	> 110	°C	ISO 75-2/C
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.1E+11	ohms	IEC 60093
Dissipation Factor (1 kHz)	< 0.10		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Glow Wire Flammability Index <sup>2</sup>	960	°C	IEC 707
Oxygen Index	> 40	%	ASTM D2863
Injection	Nominal Value	Unit	
Nozzle Temperature	95.0 - 115	°C	
Mold Temperature	145 - 160	°C	
Injection Pressure	70.0 - 150	MPa	
Holding Pressure	30.0 - 80.0	MPa	
Back Pressure	10.0 - 14.0	MPa	
Injection instructions			

Barrel inlet temp: 70 to 85°C Hydraulic injection pressure: 50 to 170 bar Hydraulic backpressure: 7 to 11 bar Injection speed: 100 to 200 cm<sup>3</sup>/s

#### NOTE

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| 1. | Post-shrink |
| 2. | 180 sec     |

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