

# MELMEX M Fine

Melamine Formaldehyde

BIP (Oldbury) Limited

Message:

A fine powder normally pelleted and HF Preheated to give superior surface finish for such articles as tableware and ashtrays. Available in a wide range of colours. Suitable for food contact applications.

| General Information            |                                |                   |             |
|--------------------------------|--------------------------------|-------------------|-------------|
| Filler / Reinforcement         | Cellulose                      |                   |             |
| Uses                           | Non-specific Food Applications |                   |             |
|                                | Table Products                 |                   |             |
| Agency Ratings                 | BS 1322 MF B10                 |                   |             |
|                                | BS 1322 MF B11                 |                   |             |
|                                | DIN 7708 Type 152.7            |                   |             |
|                                | ISO 2112 MF B10                |                   |             |
|                                | ISO 2112 MF B11                |                   |             |
| Processing Method              | Compression Molding            |                   |             |
| Physical                       | Nominal Value                  | Unit              | Test Method |
| Density                        | 1.52                           | g/cm <sup>3</sup> | ISO 1183    |
| Apparent Density               | 0.44                           | g/cm <sup>3</sup> | ISO 60      |
| Bulk Factor                    | 3.5                            |                   | ISO 171     |
| Molding Shrinkage              |                                |                   | ISO 2577    |
| -- <sup>1</sup>                | 0.58                           | %                 |             |
| -- <sup>2</sup>                | 0.62                           | %                 |             |
| Water Absorption               |                                |                   |             |
| Cold <sup>3</sup>              | 70.0                           | mg                | DIN 53472   |
| Cold <sup>4</sup>              | 13.0                           | mg                | ISO 62      |
| Hot <sup>5</sup>               | 50.0                           | mg                | ISO 62      |
| Post Shrinkage                 |                                |                   | ISO 2577    |
| -- <sup>6</sup>                | 0.85                           | %                 |             |
| -- <sup>7</sup>                | 1.1                            | %                 |             |
| Martens Temperature            | 145                            | °C                | DIN 43458   |
| Mechanical                     | Nominal Value                  | Unit              | Test Method |
| Flexural Stress                | 119                            | MPa               | ISO 178     |
| Impact                         | Nominal Value                  | Unit              | Test Method |
| Notched Izod Impact Strength   | 2.2                            | kJ/m <sup>2</sup> | ISO 180/C   |
| Unnotched Izod Impact Strength | 9.8                            | kJ/m <sup>2</sup> | ISO 180     |
| Thermal                        | Nominal Value                  | Unit              | Test Method |

|                                                   |               |       |             |
|---------------------------------------------------|---------------|-------|-------------|
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 186           | °C    | ISO 75-2/Ae |
| Electrical                                        | Nominal Value | Unit  | Test Method |
| Electric Strength                                 |               |       | IEC 60243-1 |
| -- <sup>8</sup>                                   | 8.5           | kV/mm |             |
| -- <sup>9</sup>                                   | 6.1           | kV/mm |             |
| Comparative Tracking Index                        | > 600         | V     | IEC 60167   |
| Flammability                                      | Nominal Value | Unit  | Test Method |
| Flame Rating (1.50 mm)                            | V-0           |       | UL 94       |
| Oxygen Index <sup>10</sup>                        | 44            | %     | ISO 4589-2  |
| NOTE                                              |               |       |             |

|     |                          |
|-----|--------------------------|
| 1.  | Preheated powder         |
| 2.  | Cold powder              |
| 3.  | 96 hr @ 23°C             |
| 4.  | 24 hr @ 23°C             |
| 5.  | 30 min @ 100°C           |
| 6.  | Cold powder              |
| 7.  | (48 hr) Preheated powder |
| 8.  | (90°C) Preheated powder  |
| 9.  | Cold powder              |
| 10. | Procedure A              |

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