

# Melochem Moulding Compound 736

## Injection Grade

Melochem  
Dry Granulated  
Injection Grade 736

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



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<b>Fields of application</b>	<p>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.</p> <p>Grade 736 is also used in electrical applications requiring heat resistance and abrasion resistance.</p> <p>Melochem products have a high-class feel and can be manufactured by using productive plastic technology.</p> <p>Melochem products are particularly suited for manufacture of scratch resistance and dishwasher safe products.</p>
<b>Recycling</b>	<p>Products made out of our Melochem 736 grades can be recycled. The normal method is to grind used parts, scrap etc. into a particle size suitable for plastic blast media. This blasting product then is used for cleaning sensitive metal surfaces where a normal blast media would be too harsh and chemical methods normally are the only alternative.</p>
<b>Environment</b>	<p>Most components of our melamine-formaldehyde resins are derived from renewable natural resources. On decomposition, products made from melamine- formaldehyde compounds end up as natural harmless chemicals like water, nitrogen and carbon dioxide.</p> <p>Moreover, as potentially carcinogenic flame-retardants are not required, the risk to health is reduced. Therefore the Melochem 736 thermoset compound is the right choice for customers who are working with environmental management systems and sustainable development.</p>
<b>Packaging and storage</b>	<p>Available in bags, octabins, gaylords or big-bags.</p> <p>Store product in cool and dry indoor space.</p> <p>Storage below 20°C will provide a shelf life of least 12 months.</p>



Property	Unit	Value	Test Method
Shrinkage	%	0.6 – 0.8	ISO 2577
Post_Shrinkage	%	1.1 – 1.3	ISO 2577
Density	g/cm <sup>3</sup>	1.50	ISO 1183
Water absorption	mg	< 200	ISO 62
Flexural strength	MPa	≥ 100	ISO 178
Tensile strength	MPa	≥ 55	ISO 527
Impact strength	KJ/m <sup>2</sup>	≥ 8	ISO 179/1 eU
Notched impact strenght	KJ/m <sup>2</sup>	≥ 1.3	ISO 179/1 eA
HDT 1.8 MPa	°C	≥ 155	ISO 75
HDT 8.0 MPa	°C	≥ 110	ISO 75
Glow bar 960 °C 180 sec.	Rating	passes	IEC 707
Flammability UL 94	Class	V-0	UL 94
Oxygen Index	%	> 40	ASTM D2863
Surface resistance	logΩ	≥ 11	IEC 93
Dissipation factor, 1 kHz	delta tan	< 0.1	IEC 250
<b>Recommended process parameters</b>			
Barrel inlet temp.	°C	70-85	//
Barrel nozzle temp.	°C	95-115	//
Mold temp	°C	145-160	//
Hydraulic injection pressure	bar	50-170	//
Specific injection pressure	bar	700-1500	//
Specific holding pressure	bar	300-800	//
Hydraulic backpressure	bar	7-11	//
Specific backpressure	bar	100-140	//
Injection speed	cm <sup>3</sup> /s	100-200	//

The information given in our datasheet, which to our knowledge is correct, does not constitute any kind of warranty or other undertaking of responsibility from Chemiplastica, but serves only as general information with respect to possible applicability of the products as well as the characteristics and handling of the products.

## CHEMIPLASTICA

Chemiplastica SpA

Via Dante,60  
22070 Carbonate Como\_ ITALY\_  
Phone: ++39/0331/83651  
Fax: ++39/0331/836565

Chemiplastica S.A. DE C.V.

Carretera panamericana Km 219.7  
Tramo Celaya-Salamanca Villagran  
Gto., MEXICO  
Phone: +52 411 155 -3131  
Fax: +52 411 155-3198

Chemiplastica AB

28 480 Perstorp\_ SWEDEN  
Phone: +46 0435 370 00  
Fax: +46 0435 388 03

Chemiplastica Inc.

238 Nonotuck Street  
Florence, MA 01062 USA  
Phone: +1 413 584 2472  
Fax: +1 413 586 4089

