

Melamine Molding Compound

Thai KK Melamine Molding Compound is a thermosetting compound composed of alpha-cellulose filled melamine-formaldehyde resin, of which it is available in wide range of colors.

With excellent properties of molded articles, products are food contact safety, surface durability, hardness, heat resistance, chemical resistance, hygienic and good electrical properties. It is manufactured for both compression and injection molding, and available in fine powder and granular forms.

Typical properties

PROPERTY	UNIT	COMPRESSION	INJECTION
Appearance	-	Powder / Granular form	Granular form
Specific Gravity	-	1.45 – 1.55	1.45 – 1.55
Bending Strength,	Mpa	79.0 Min.	79.0 Min.
Charpy Impact Strength	kJ/cm ²	2.0 Min.	2.0 Min.
Water Absorption	%	0.8 Max.	0.8 Max.
Insulation Resistance	Ω	10 ¹⁰ Min.	10 ¹⁰ Min.
Disc Flow (2 g material, at 140°C)	mm.	87 Min.	105 Min.
Curing time (2 g material, at 140°C)	sec.	100 Min.	140 Min.

Molding condition

TYPE	ITEM	UNIT	CONDITION
COMPRESSION	Mold Temperature	°C	160 - 165
	Mold Pressure	kg/cm ²	150 - 200
INJECTION	Barrel Zone Temperature	°C	60 - 80
	Barrel Front Zone Temperature	°C	80 - 100
	Nozzle Temperature	°C	90 - 100
	Mold Temperature	°C	155 - 165
	Injection Pressure	kg/cm ²	70 - 150

Material handling, Package and Storage

Material is supplied in multiwall bag, generally 25 kg bag, the material should be stored in a cool (below 30 °C) and dry place, and protected from moisture. Shelf life of material is 6 months.

