TECHNICAL DATA SHEET

Bakelite® UP 3620

Bakelite Synthetics
UP-X

Processing Injection molding, Transfer molding

Product Text

Product Information

Product description:

Polyester moulding compound, mainly organically filled, styrene free, processing shrinkage as for phenolic moulding compounds, non flammable, high surface quality, UL listed moulding compound 1,5 mm / V-0 (ALL).

Application areas:

Lamp parts, switch gears, housings and base plates, MCB housings.

Property Name	Value	Unit	Standard No.
Apparent density (moulding compound)	0.7	g/cm³	ISO 60
Moulding shrinkage (injection moulding, longitudinal)	0.75	%	ISO 2577
Post shrinkage (injection moulding, 168h/110°C)	0.25	%	ISO 2577
Moulding shrinkage (compression moulding, longitudinal)	0.7	%	ISO 2577
Post shrinkage (compression moulding, 168h/110°C)	0.25	%	ISO 2577
Tensile strength (5mm/min)	50	MPa	ISO 527-1/2
Compr. strength (test spec. flat tested)	180	MPa	ISO 604
Flexural strength (2mm/min)	80	MPa	ISO 178

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Flexural modulus	7500	MPa	ISO 178
Ball indentation hardness (H 961/30)	250	MPa	ISO 2039/P1
Water absorption (24h/23°C)	70	mg	similar to ISO 62

Preparation of Test Specimens of Thermosetting Moulding Compound

- Compression to ISO 295
- Injection to ISO 10724

Storage capability
12 month (shorter shelf life for darker colours), (relative humidity of 50-60% and maximum storage temperature of approximately 20°C)

Processing/Physical Characteristics	Value	Unit	Standard
Molding shrinkage, parallel	0.75	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Standard
Tensile modulus	8500	MPa	ISO 527
Poisson's ratio	0.35		ISO 527
Charpy impact strength, +23°C	7.5	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	1.9	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 8.00 MPa	70	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Yellow card available	yes		

Electrical Properties	Value	Unit	Standard
Relative permittivity, 100Hz	5		IEC 62631-2-1
Dissipation factor, 100Hz	0.02	E-4	IEC 62631-2-1
Volume resistivity	1E10	Ohm*m	IEC 62631-3-1
Surface resistivity	1E11	Ohm	IEC 62631-3-2
Electric strength	30	kV/mm	IEC 60243-1
Comparative tracking index	600		IEC 60112

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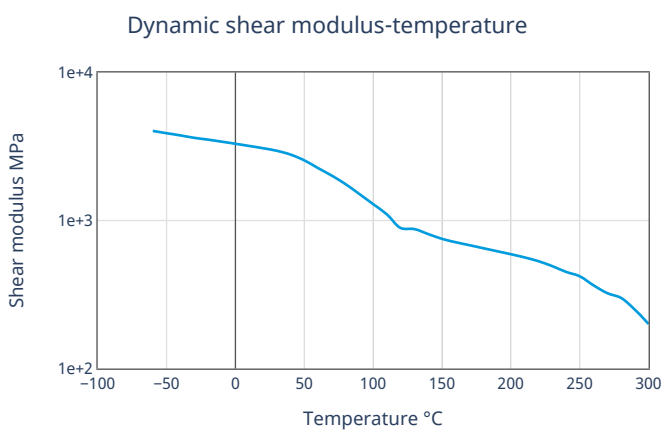
Other Properties	Value	Unit	Standard
Density	1710	kg/m³	ISO 1183

Test Specimen Production	Value	Unit	Standard
Injection molding, injection temperature	105	°C	ISO 10724
Injection molding, injection velocity	170	mm/s	ISO 10724
Injection molding, hold pressure	100	MPa	ISO 10724
Injection molding, cure time	25	min	ISO 10724
Compression molding, mold temperature	160	°C	ISO 295
Compression molding, cure time	1	min	ISO 295

Diagrams



Processing Information

Injection molding

VERARBEITUNG

Temperature of material:	70 - 100	°C
Mould temperature:	160 - 180	°C
Curing time:	10-20	sec

Further Information:

Barrel temperature

- Feed zone:	60-70	°C
- Nozzle zone:	70-100	°C
Cavity moulding pressure:	>10	MPa

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Back pressure:	0.5-1	MPa
Holding pressure:	60% of injection pressure	

Compression molding

PROCESSING

Mould temperature:	160-180	°C
Curing time:	20-40	sec
Cavity moulding pressure:	>10	MPa

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