

GENERAL PROPERTIES OF FLODO DOUGH MOULDING COMPOUND

PROPERTY	TEST METHOD	UNITS	602/15	605/20	606/15	614/15	615/15
PHYSICAL	-	-	-	-	-	-	-
DENSITY	BS-2782-PART 5-509A-1970	gm/cc	1.75 - 1.85	1.75 - 1.85	1.75 - 1.80	1.55 - 1.65	1.55 - 1.65
MOULD SHRINKAGE	BS-2782-PART 6-640A-1979	%	0.15 - 0.20	0.15 - 0.20	0.15 - 0.20	0.30 - 0.50	0.20 - 0.30
REINFORCEMENT CONTENT	BS-5734-PART 1-1990	%	14 - 16	19 - 21	14 - 16	9 - 11	9 - 11
*WATER ABSORPTION	BS-2782-PART 4-430A-1983	%	<0.20	<0.20	<0.20	<0.50	<0.30
MECHANICAL	-	-	-	-	-	-	-
TENSILE STRENGTH	BS-2782-PART 3-320E-1976	Kg/sq.cm	250	400	350	200	250
FLEXURAL STRENGTH	BS-2782-PART 3-335A-1993	Kg/sq.cm	700	1100	950	450	500
COMPRESSIVE STRENGTH	BS-2782-PART 3-345A-1993	Kg/sq.cm	1500	1550	1500	1200	1200
IMPACT STRENGTH	BS-2782-PART 3-350-1993	Kg.cm/cm	10	20	15	5	6
ELECTRICAL	-	-	-	-	-	-	-
VOLUME RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm cm	14	13	14	11	11
SURFACE RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm	13	11	11	13	13
TRACKING INDEX	DIN-53480-1972	Volts	+800	+800	+800	+800	+800
DIELECTRIC STRENGTH	BS-2782-PART 2-201C-1970	KV/mm	10	9	10	6	10
ARC RESISTANCE	ASTM-D 495-1989	Seconds	+180	+180	+180	+135	+180
THERMAL	-	-	-	-	-	-	-
*MARTEN HDT TEST	DIN - 53462-1987	Deg C	+130	+125	+125	+120	+130
Flammability	UL- 94-1996	-	V0	V0	V0	V0	V0
RECOMMENDATION	-	-	-	-	-	-	-
MOULDABLE THICKNESS	-	mm	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0
MOULD TEMPERATURE	-	Deg C	120 - 165	140 - 170	140 - 170	130 - 160	130 - 160
MOULDING PRESSURE	-	Kg/cm ²	10 - 75	10 - 75	10 - 75	10 - 75	10 - 75
CURING TIME	seconds/mm THICKNESS	Seconds	30 - 50	30 - 50	30 - 50	30 - 50	30 - 50
TYPE OF MOULDING	-	-	Compression / Transfer	Compression	Compression / Transfer	Transfer/ Injection	Transfer/ Injection

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PROPERTY	TEST METHOD	UNITS	630/15	631/15	636/15	660/15	660/25
PHYSICAL	-	-	-	-	-	-	-
DENSITY	BS-2782-PART 5-509A-1970	gm/cc	1.75 - 1.85	1.75 - 1.85	1.75 - 1.80	1.70 - 1.80	1.80 - 1.90
MOULD SHRINKAGE	BS-2782-PART 6-640A-1979	%	0.10 - 0.15	0.15 - 0.20	0.15 - 0.20	0.15 - 0.20	0.10 - 0.20
REINFORCEMENT CONTENTS	BS-5734-PART 1-1990	%	14 - 16	14 - 16	14 - 16	14 - 16	24 - 26
*WATER ABSORPTION	BS-2782-PART 4-430A-1983	%	<0.20	<0.20	<0.20	<0.20	<0.25
MECHANICAL	-	-	-	-	-	-	-
TENSILE STRENGTH	BS-2782-PART 3-320E-1976	Kg/sq.cm	250	300	300	350	275
FLEXURAL STRENGTH	BS-2782-PART 3-335A-1993	Kg/sq.cm	650	700	850	950	900
COMPRESSIVE STRENGTH	BS-2782-PART 3-345A-1993	Kg/sq.cm	1500	1500	1500	1500	1900
IMPACT STRENGTH	BS-2782-PART 3-350-1993	Kg.cm/cm	10	12	13	15	25
ELECTRICAL	-	-	-	-	-	-	-
VOLUME RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm cm	13	13	14	14	13
SURFACE RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm	12	12	12	12	11
TRACKING INDEX	DIN-53480-1972	Volts	+800	+800	+800	+800	+800
DIELECTRIC STRENGTH	BS-2782-PART 2-201C-1970	KV/mm	10	10	10	10	10
ARC RESISTANCE	ASTM-D 495-1989	Seconds	+190	+180	+180	+180	+180
THERMAL	-	-	-	-	-	-	-
*MARTEN HDT TEST	DIN - 53462-1987	Deg C	+130	+130	+125	+125	+125
Flammability	UL- 94-1996	-	V0	V0	V0	V0	V0
RECOMMENDATION	-	-	-	-	-	-	-
MOULDABLE THICKNESS	-	mm	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0
MOULD TEMPERATURE	-	Deg C	130 - 160	140 - 170	140 - 170	130 - 170	130 - 170
MOULDING PRESSURE	-	Kg/cm ²	10 - 75	10 - 75	10 - 75	10 - 75	10 - 75
CURING TIME	seconds/mm THICKNESS	Seconds	30 - 50	30 - 50	30 - 50	30 - 50	30 - 50
TYPE OF MOULDING	-	-	Injection	Compression	Compression	Compression / Transfer	Compression / Transfer

GENERAL PROPERTIES OF FLODO DOUGH MOULDING COMPOUND

PROPERTY	TEST METHOD	UNITS	661/C/15	665/25	670/20	671/15	679/15
PHYSICAL	-	-	-	-	-	-	-
DENSITY	BS-2782-PART 5-509A-1970	gm/cc	1.70 - 1.80	1.80 - 1.90	1.75 - 1.85	1.70 - 1.80	1.70 - 1.80
MOULD SHRINKAGE	BS-2782-PART 6-640A-1979	%	0.12 - 0.20	0.10 - 0.15	0.18 - 0.25	0.18 - 0.25	0.15 - 0.20
REINFORCEMENT CONTENTS	BS-5734-PART 1-1990	%	14 - 16	24 - 26	19 - 21	14 - 16	14 - 16
*WATER ABSORPTION	BS-2782-PART 4-430A-1983	%	<0.14	<0.20	<0.20	<0.20	<0.20
MECHANICAL	-	-	-	-	-	-	-
TENSILE STRENGTH	BS-2782-PART 3-320E-1976	Kg/sq.cm	--	250	200	250	250
FLEXURAL STRENGTH	BS-2782-PART 3-335A-1993	Kg/sq.cm	600	900	700	600	550
COMPRESSIVE STRENGTH	BS-2782-PART 3-345A-1993	Kg/sq.cm	1200	1800	1200	1500	1100
IMPACT STRENGTH	BS-2782-PART 3-350-1993	Kg.cm/cm	--	25	15	9	10
ELECTRICAL	-	-	-	-	-	-	-
VOLUME RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm cm	13	12	12	12	13
SURFACE RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm	12.5	13	13	13	12
TRACKING INDEX	DIN-53480-1972	Volts	--	+800	+800	+800	+800
DIELECTRIC STRENGTH	BS-2782-PART 2-201C-1970	KV/mm	--	10	10	10	10
ARC RESISTANCE	ASTM-D 495-1989	Seconds	--	+185	+180	+180	+180
THERMAL	-	-	-	-	-	-	-
*MARTEN HDT TEST	DIN - 53462-1987	Deg C	+180	+125	+130	+125	+130
Flammability	UL- 94-1996	-	V0	V0	V0	V0	V0
RECOMMENDATION	-	-	-	-	-	-	-
MOULDABLE THICKNESS	-	mm	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0
MOULD TEMPERATURE	-	Deg C	140 - 170	130 - 165	140 - 170	140 - 170	120 - 165
MOULDING PRESSURE	-	Kg/cm ²	10 - 75	10 - 75	10 - 75	10 - 75	10 - 75
CURING TIME	seconds/mm THICKNESS	Seconds	30 - 50	30 - 50	30 - 50	30 - 50	30 - 50
TYPE OF MOULDING	-	-	Injection / Transfer	Injection	Compression	Compression	Compression / Transfer

GENERAL PROPERTIES OF FLODO DOUGH MOULDING COMPOUND

PROPERTY	TEST METHOD	UNITS	679/15/C	681/15	681/20	695/25	679/20
PHYSICAL	-	-	-	-	-	-	-
DENSITY	BS-2782-PART 5-509A-1970	gm/cc	1.70 - 1.80	1.75 - 1.85	1.75 - 1.85	1.70 - 1.90	1.70 - 1.90
MOULD SHRINKAGE	BS-2782-PART 6-640A-1979	%	0.20 - 0.30	0.00 - 0.05	0.00 - 0.05	0.15 - 0.20	0.15 - 0.25
REINFORCEMENT CONTENTS	BS-5734-PART 1-1990	%	14 - 16	14 - 16	19 - 21	19 - 21	18 - 22
*WATER ABSORPTION	BS-2782-PART 4-430A-1983	%	<0.20	<0.20	<0.20	<0.30	<0.20
MECHANICAL	-	-	-	-	-	-	-
TENSILE STRENGTH	BS-2782-PART 3-320E-1976	Kg/sq.cm	275	350	275	400	275
FLEXURAL STRENGTH	BS-2782-PART 3-335A-1993	Kg/sq.cm	600	950	750	850	750
COMPRESSIVE STRENGTH	BS-2782-PART 3-345A-1993	Kg/sq.cm	1200	1560	1600	1700	1600
IMPACT STRENGTH	BS-2782-PART 3-350-1993	Kg.cm/cm	10	10	20	30	35
ELECTRICAL	-	-	-	-	-	-	-
VOLUME RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm cm	13	14	13	12	13
SURFACE RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm	12	13	12	13	12
TRACKING INDEX	DIN-53480-1972	Volts	+800	+800	+800	+800	+800
DIELECTRIC STRENGTH	BS-2782-PART 2-201C-1970	KV/mm	10	10	10	10	12
ARC RESISTANCE	ASTM-D 495-1989	Seconds	+180	+185	+180	+180	+180
THERMAL	-	-	-	-	-	-	-
*MARTEN HDT TEST	DIN - 53462-1987	Deg C	+130	+130	+140	+180	200
Flammability	UL- 94-1996	-	V0	V0	V0	V0	V0
RECOMMENDATION	-	-	-	-	-	-	-
MOULDABLE THICKNESS	-	mm	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0	3.00 - 20.0
MOULD TEMPERATURE	-	Deg C	120 - 165	140 - 170	140 - 170	140 - 170	140 - 170
MOULDING PRESSURE	-	Kg/cm ²	10 - 75	10 - 75	10 - 75	10 - 75	-
CURING TIME	seconds/mm THICKNESS	Seconds	30 - 50	30 - 50	30 - 50	30 - 50	15 - 20
TYPE OF MOULDING	-	-	Compression / Transfer	Compression / Transfer	Compression / Transfer	Compression / Transfer	Injection

GENERAL PROPERTIES OF FLODO DOUGH MOULDING COMPOUND

PROPERTY	TEST METHOD	UNITS	901/20
PHYSICAL	-	-	Injection grade
DENSITY	BS-2782-PART 5-509A-1970	gm/cc	1.90 - 2.00
MOULD SHRINKAGE	BS-2782-PART 6-640A-1979	%	0.00 - 0.02
REINFORCEMENT CONTENTS	BS-5734-PART 1-1990	%	18 - 22
*WATER ABSORPTION	BS-2782-PART 4-430A-1983	%	<0.20
MECHANICAL	-	-	-
TENSILE STRENGTH	BS-2782-PART 3-320E-1976	Kg/sq.cm	350
FLEXURAL STRENGTH	BS-2782-PART 3-335A-1993	Kg/sq.cm	850
COMPRESSIVE STRENGTH	BS-2782-PART 3-345A-1993	Kg/sq.cm	1500
IMPACT STRENGTH	BS-2782-PART 3-350-1993	Kg.cm/cm	60
ELECTRICAL	-	-	-
VOLUME RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm cm	-
SURFACE RESISTIVITY	DIN-53482-1967	Log ₁₀ ohm	-
TRACKING INDEX	DIN-53480-1972	Volts	-
DIELECTRIC STRENGTH	BS-2782-PART 2-201C-1970	KV/mm	-
ARC RESISTANCE	ASTM-D 495-1989	Seconds	-
THERMAL	-	-	-
*MARTEN HDT TEST	DIN - 53462-1987	Deg C	-
Flammability	UL- 94-1996	-	-
RECOMMENDATION	-	-	-
MOULDABLE THICKNESS	-	mm	3.00 - 20.0
MOULD TEMPERATURE	-	Deg C	140 - 170
MOULDING PRESSURE	-	Kg/cm ²	-
CURING TIME	seconds/mm THICKNESS	Seconds	15 - 20
TYPE OF MOULDING	-	-	Injection

Note:

- The above-furnished grades are standard available grades. Special grades can be compounded to customer's specifications & special applications
- Standard colors available are black, white & grey. If any other specific colour is required the same can be produced on requisition.
- * Regular test certificate will not contain this data, as this parameter is only the supporting data.