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MANUFACTURING

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### WHAT IS LOW PRESSURE MOLDING GOOD FOR?

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An even better question to ask might be what is it beginning of a project, as there are many advantages to using Low Pressure Molding with Macromelt® materials, and there are some projects better suited for a different process and type of material. The Macromelt® Data chart below will give you an idea whether LPM is right for your application. Feel free [contact us](#) with any questions.

Macromelt® Data					
Material	OM 663 / OM 638	OM 641 / OM 646	OM 652 / OM 657	OM 673 / OM 678	MM 6208 / MM 6208S
Color	amber/black	amber/black	amber/black	amber/black	amber/black
<b>Physical</b>					
Specific gravity, S.G.	0.98	0.98	0.98	0.98	0.98
Working temperature, °C	-40 to +125	-40 to +125	-40 to +100	-40 to +140	-40 to +130
Elongation @ rupture, %	400	800	400	500	600
Hardness @ 25°C, shore A	90	92	77	88	78
Hardness @ 125°C, shore A	65	63	N/A	64	N/A
Softening point, ball & ring, °C	175	175	155	185	155
Glass transition temperature, °C	-36	-35	-45	-50	-42
Molding temperature, °C	200 to 240	210 to 240	180 to 230	210 to 240	190 to 230
Viscosity @ 210° C, mPas	3700	7000	4100	3400	3600
<b>Electrical</b>					
Dielectric constant @ 1kHz	4.5 / 4.7	5.1 / 5.5	6.2 / 6.3	4.9 / 4.9	6.1 / 6.3
Volume resistivity, Ohm cm	1.7E15 / 2.4E13	6.3E12 / 1.7E12	1.0E12 / 7.2E11	1.90E12 / 1.90E12	1.9E11 / 1.6E11
Dielectric strength, kV / mm	24 / 19	25 / 22	14 / 15	20 / 20	23 / 23
<b>Ratings</b>					
FDA category, adhesives	175.105 (OM633)	175.105 (OM641)	175.105 (OM652)	175.105 (OM673)	175.105 (OM6208)
Flammability rating	V-0	V-0	V-0	V-0	V-0

### Characteristics of Macromelt® Materials worth noting

1. Each grade of material is available in the amber base version and in black.
2. Some custom colors are available – [contact us](#).
3. The softer materials generally offer the best adhesive properties. However, Cavist Manufacturing will perform adhesion tests on actual application substrates in order to recommend a specific molding compound.
4. These molding compounds shrink approximately 1.5% after molding.
5. Moisture and solvent resistance requirements will be key factors in selecting a specific grade of material. Most Macromelt materials do not have good resistance to polar solvents in combination with mechanical stress.