

HI542-S9678 PMMA, Paintless Grade

PROPERTY	CONDITION	UNIT	METHOD	VALUE
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	4.0
VICAT Softening Point	B/50	°C	ISO 306	101
Heat Deflection Temperature	1.8MPa	°C	ISO 75	98
Coefficient of Linear Expansion	-	1/°C	ASTM D696	7X10 ⁻⁵
MECHANICAL PROPERTIES				
Charpy Impact Strength	notched	kJ/m ²	ISO 179	4.5
Rockwell Hardness	M scale	-	ISO 2039-2	80
Tensile Strength at Break	5mm/min	MPa	ISO 527	60
Tensile Strain at Break	5mm/min	%	ISO 527	30
Tensile Modulus	1mm/min	GPa	ISO 527	2.4
Flexural Strength	2mm/min	MPa	ISO 178	83
Flexural Modulus	2mm/min	GPa	ISO 178	2.3
GENERAL PROPERTIES				
Density	-	g/cm ³	ISO 1183	1.16
Mold Shrinkage	-	%	ASTM D955	0.4-0.7
Water Absorption	24hr	%	ASTM D570	0.4
Flammability UL94	1.5mm	Class	IEC 60695-11-10	HB
RECOMMENDED PROCESSING CONDITIONS				
Predrying Temperature		°C		Max. 70
Predrying Time in Desiccant-Type Drier		hr		3-4
Melt Temperature		°C		210-240
Mold Temperature		°C		50-70

REMARKS : The listed values should be used for reference purpose only.