

PMMA  
Paintless Black Grade

# HI781-9678

## Description

Appropriate for injection molding  
High impact resistance  
High gloss, High mechanical strength, Excellent weatherability  
Recycleable, Environment-friendly, Cost-reduction  
Equivalent to PMMA/ASA High impact resistance grades

## Application

Exterior molding garnish, Door frame garnish (B, C, D Pillar),  
Car front grill & rear deco, Side mirror base plate cover & mirror housing

## Table

項目	條件	單位	試驗方法	数值
<b>热性质</b>				
流动性	230°C/3.8kg	g/10min	ISO 1133	1.0
VICAT 軟化点	B/50	°C	ISO 306	93
热变形温度	1.8MPa	°C	ISO 75	94
线膨胀系数	-	1/°C	ASTM D696	8X10 <sup>-5</sup>
<b>机械性质</b>				
Charpy 冲击强度	notched	kJ/m <sup>2</sup>	ISO 179	8.0
Rockwell 硬度	R scale	-	ISO 2093-2	106
拉 拉伸强度(@yield)	50mm/min	MPa	ISO 527	46
延伸率率	50mm/min	%	ISO 527	62
拉伸模数	1mm/min	GPa	ISO 527	1.7
弯曲强度	2mm/min	MPa	ISO 178	61
弯曲模数	2mm/min	GPa	ISO 178	1.8
<b>一般性质</b>				
比重	-	g/cm <sup>3</sup>	ISO 1183	1.15
成型收缩率	-	%	ASTM D955	0.4-0.7
水分吸收率	24hr	%	ASTM 570	0.3
阻燃性能 (UL94)	1.5mm	Class	IEC 60695-11-10	HB
<b>压出成型条件</b>				
预备干燥 温度	除湿干燥	°C	-	70-80
预备干燥 时间	除湿干燥	hr	-	4-6
熔化温度	-	°C	-	210-240
模具温度	-	°C	-	50-70

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