

PMMA
Paintless Black Grade

HI835MS-9678

Description

Appropriate for injection molding
Slightly impact grade with medium heat resistance
High gloss, High mechanical strength, Excellent weatherability
Recycleable, Environment-friendly, Cost-reduction
Mold flow simulation data is available

Application

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

Table

| 項目 | 條件 | 單位 | 試驗方法 | 数值 |
|---------------|--------------|-------------------|-----------------|--------------------|
| 热性质 | | | | |
| 流动性 | 230°C/3.8kg | g/10min | ISO 1133 | 1.8 |
| 流动性 | 220°C/10kg | g/10min | ISO 1133 | 3.4 |
| VICAT 軟化点 | B/50 | °C | ISO 306 | 102 |
| 热变形温度 | 1.8MPa | °C | ISO 75 | 98 |
| 线膨胀系数 | - | 1/°C | ASTM D696 | 7X10 ⁻⁵ |
| 机械性质 | | | | |
| Charpy 冲击强度 | notched | kJ/m ² | ISO 179 | 2.6 |
| Rockwell 硬度 | M scale (*R) | - | ISO 2039-2 | 78 / 120(*R) |
| 拉 拉伸强度 | 5mm/min | MPa | ISO 527 | 67 |
| 延伸率率 | 5mm/min | % | ISO 527 | 30 |
| 拉伸模数 | 1mm/min | GPa | ISO 527 | 2.5 |
| 弯曲强度 | 2mm/min | MPa | ISO 178 | 85 |
| 弯曲模数 | 2mm/min | GPa | ISO 178 | 2.4 |
| 一般性质 | | | | |
| 比重 | - | g/cm ³ | ISO 1183 | 1.18 |
| 成型收缩率 | - | % | ASTM D955 | 0.4-0.8 |
| 水分吸收率 | 24hr | % | ASTM D570 | 0.4 |
| 阻燃性能 (UL94) | 1.5mm | Class | IEC 60695-11-10 | HB |
| 压出成型条件 | | | | |
| 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 | - | 60-80 |

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