

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

PROPERTY	CONDITION	UNIT	METHOD	VALUE
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	1.8
Melt Flow Index	220°C/10kg	g/10min	ISO 1133	3.4
VICAT Softening Point	B/50	°C	ISO 306	102
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	2.6
Rockwell Hardness	M scale (*R)	-	ISO 2039-2	78 / 120(*R)
Tensile Strength at Break	5mm/min	MPa	ISO 527	67
Tensile Strain at Break	5mm/min	%	ISO 527	30
Tensile Modulus	1mm/min	GPa	ISO 527	2.5
Flexural Strength	2mm/min	MPa	ISO 178	85
Flexural Modulus	2mm/min	GPa	ISO 178	2.4
GENERAL PROPERTIES				
Density	-	g/cm ³	ISO 1183	1.18
Mold Shrinkage	-	%	ASTM D955	0.4-0.8
Water Absorption	24hr	%	ASTM D570	0.4
Flammability UL94	1.5mm	Class	IEC 60695-11-10	HB
RECOMMENDED PROCESSING CONDITIONS				
Predrying Temperature	-	°C	-	70-80
Predrying Time in Desiccant-Type Drier	-	hr	-	4-6
Melt Temperature	-	°C	-	210-240
Mold Temperature	-	°C	-	60-80

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