

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

PROPERTY	CONDITION	UNIT	METHOD	VALUE
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	1.0
VICAT Softening Point	B/50	°C	ISO 306	93
Heat Deflection Temperature _{annealed}	1.8MPa	°C	ISO 75	94
Coefficient of Linear Expansion	-	1/°C	ASTM D696	8X10 ⁻⁵
MECHANICAL PROPERTIES				
Charpy Impact Strength	notched	kJ/m ²	ISO 179	8.0
Rockwell Hardness	R scale	-	ISO 2093-2	106
Tensile Strength at Break(@yield)	50mm/min	MPa	ISO 527	46
Tensile Strain at Break	50mm/min	%	ISO 527	62
Tensile Modulus	1mm/min	GPa	ISO 527	1.7
Flexural Strength	2mm/min	MPa	ISO 178	61
Flexural Modulus	2mm/min	GPa	ISO 178	1.8
GENERAL PROPERTIES				
Density	-	g/cm ³	ISO 1183	1.15
Mold Shrinkage	-	%	ASTM D955	0.4-0.7
Water Absorption	24hr	%	ASTM 570	0.3
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	-	50-70

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