

PMMA
Paintless Black Grade

IH830HR-9678

Description

Appropriate for injection molding
The highest resistance grade
Good surface hardness & abrasion resistance, High gloss,
High mechanical strength, Excellent weatherability
Recycleable, Environment-friendly, Cost-reduction
Mold flow simulation data is available

Application

Exterior molding garnish (B,C), Door frame garnish (B,C pillar), Roof side molding

Table

PROPERTY	CONDITION	UNIT	METHOD	VALUE
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	1.7
Melt Flow Index	220°C/10kg	g/10min	ISO 1133	2.7
VICAT Softening Point	B/50	°C	ISO 306	115
Heat Deflection Temperature	1.8MPa	°C	ISO 75	107
Coefficient of Linear Expansion	-	1/°C	ASTM D696	6X10 ⁻⁵
MECHANICAL PROPERTIES				
Charpy Impact Strength	notched	kJ/m ²	ISO 179	1.5
Rockwell Hardness	M scale (*R)	-	ISO 2039-2	99 / 125(*R)
Tensile Strength at Break	5mm/min	MPa	ISO 527	75
Tensile Strain at Break	5mm/min	%	ISO 527	4.7
Tensile Modulus	1mm/min	GPa	ISO 527	3.1
Flexural Strength	2mm/min	MPa	ISO 178	117
Flexural Modulus	2mm/min	GPa	ISO 178	3.0
GENERAL PROPERTIES				
Density	-	g/cm ³	ISO 1183	1.19
Mold Shrinkage	-	%	ASTM D955	0.2-0.6
Water Absorption	24hr	%	ASTM D570	0.3
Flammability UL94	1.5mm	Class	IEC 60695-11-10	HB
RECOMMENDED PROCESSING CONDITIONS				
Predrying Temperature	-	°C	-	90-100
Predrying Time in Desiccant-Type Drier	-	hr	-	4-6
Melt Temperature	-	°C	-	230-260
Mold Temperature	-	°C	-	60-90

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