

# IH830 PMMA, Injection Grade

PROPERTY	CONDITION	UNIT	METHOD	VALUE
<b>OPTICAL PROPERTIES</b>				
Refractive Index	nd	-	ISO 489	1.49
Light Transmittance	3.2mm	%	ISO 13468-1	92
Haze	3.2mm	%	ISO 14782	<0.5
<b>THERMAL PROPERTIES</b>				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	2.3
VICAT Softening Point	B/50	°C	ISO 306	109
Heat Deflection Temperature	1.8MPa	°C	ISO 75	101
Coefficient of Linear Expansion	-	1/°C	ASTM D696	6X10 <sup>-5</sup>
<b>MECHANICAL PROPERTIES</b>				
Charpy Impact Strength	notched	kJ/m <sup>2</sup>	ISO 179	1.5
Rockwell Hardness	M scale	-	ISO 2039-2	99
Tensile Strength at Break	5mm/min	MPa	ISO 527	71
Tensile Strain at Break	5mm/min	%	ISO 527	5
Tensile Modulus	1mm/min	GPa	ISO 527	2.8
Flexural Strength	2mm/min	MPa	ISO 178	111
Flexural Modulus	2mm/min	GPa	ISO 178	3.0
<b>GENERAL PROPERTIES</b>				
Density	-	g/cm <sup>3</sup>	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
<b>RECOMMENDED PROCESSING CONDITIONS</b>				
Predrying Temperature		°C		Max. 90
Predrying Time in Desiccant-Type Drier		hr		3-4
Melt Temperature		°C		220-250
Cylinder Temperature		°C		220-250
Mold Temperature		°C		50-70

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