

PMMA Injection Grade IF850E

Description

Appropriate for injection molding
High light transmission
High melt flow rate
Good mechanical strength, surface hardness, weather resistance
Free colorability due to crystal clarity

Application

Windows for electric home appliances, Cosmetics containers, Food containers

Table

PROPERTY	CONDITION	UNIT	METHOD	VALUE
OPTICAL PROPERTIES				
Refractive Index	nd	-	ISO 489	1.49
Light Transmittance	3mm	%	ISO 13468-1	92
Haze	3mm	%	ISO 14782	<0.5
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	16
VICAT Softening Point	B/50	°C	ISO 306	94
Heat Deflection Temperature _{unannealed}	1.8MPa	°C	ISO 75	70
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	-	ISO 2093-2	85
Tensile Strength at Break	5mm/min	MPa	ISO 527	63
Tensile Strain at Break	5mm/min	%	ISO 527	4
Tensile Modulus	1mm/min	GPa	ISO 527	3.0
Flexural Strength	2mm/min	MPa	ISO 178	106
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 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.