

PMMA
Paintless Black Grade

IH830-9678

Description

Appropriate for injection molding
Well balanced mechanical with high heat resistance
Good surface hardness & abrasion resistance, High gloss,
High mechanical strength, Excellent weatherability
Recycleable, Environment-friendly, Cost-reduction

Application

Exterior molding garnish, Door frame garnish (B,C pillar), Tail lamp, CHMSL edge black

Table

PROPERTY	CONDITION	UNIT	METHOD	VALUE
THERMAL PROPERTIES				
Melt Flow Index	230°C/3.8kg	g/10min	ISO 1133	2.3
Melt Flow Index	220°C/10kg	g/10min	ISO 1133	4.3
VICAT Softening Point	B/50	°C	ISO 306	108
Heat Deflection Temperature	1.8MPa	°C	ISO 75	101
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	95 / 124(*R)
Tensile Strength at Break	5mm/min	MPa	ISO 527	71
Tensile Strain at Break	5mm/min	%	ISO 527	5.0
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
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	-	80-90
Predrying Time in Desiccant-Type Drier	-	hr	-	4-6
Melt Temperature	-	°C	-	220-250
Mold Temperature	-	°C	-	50-70

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