

**MA504-M**

PMMA

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	8	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0035	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	70	MPa	ASTM D 638
Flexural Modulus	2500	MPa	ASTM D 790
Flexural Strength	85	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	40	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	80	°C	ASTM D 648
Vicat Temperature	92	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2

Optical properties	Value	Unit	Test Standard
<b>Other Standards<sup>[5]</sup></b>			
Gloss	85	-	ASTM D523

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Density	1170	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230 - 240	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	190 - 210	°C	-
Zone 2	210 - 220	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	225 - 235	°C	-
Screw speed	30 - 50	rpm	-
Back pressure	1 - 5	MPa	-

**Characteristics****Processing**

Injection Molding

**Features**

High Gloss, Scratch Resistant

**Special Characteristics**

U.V. stabilized or stable to weather

**Regional Availability**

Asia Pacific