

**HCL7110NH**

(PLA+PMMA)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	20.8	g/10min	ASTM D 1238
Temperature	240	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955
<b>Thermal properties</b>			
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	84	°C	ASTM D 648
Vicat Temperature	85	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	1200	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	220 - 230	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	190 - 200	°C	-
Zone 2	210 - 220	°C	-
Zone 3	220 - 230	°C	-
Nozzle temperature	215 - 225	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	1 - 5	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Special Characteristics**

Flame retardant, Halogen-free