

**HCL7140**

(PLA+PMMA)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	6.6	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	53	MPa	ASTM D 638
Elongation at Break	12	%	ASTM D 638
Flexural Modulus	2250	MPa	ASTM D 790
Flexural Strength	76	MPa	ASTM D 790
Izod Impact notched, 1/8 in	580	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	115	°C	ASTM D 648
Vicat Temperature	76.5	°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

Other properties	Value	Unit	Test Standard
Density	1200	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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**

Heat stabilized or stable to heat