

HML5150
(PLA+PMMA)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	6.9	g/10min	ASTM D 1238
Temperature	240	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	70	MPa	ASTM D 638
Elongation at Break	8	%	ASTM D 638
Flexural Modulus	3200	MPa	ASTM D 790
Flexural Strength	75	MPa	ASTM D 790
Izod Impact notched, 1/8 in	30	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	64.5	°C	ASTM D 648
Vicat Temperature	67.5	°C	ASTM D 1525

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

Other properties	Value	Unit	Test Standard
Density	1210	kg/m ³	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