

STAREX LD-0955

PMMA

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	22	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.003	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2500	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	10	%	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy impact strength, +23°C	30	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	2	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	25	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	2	kJ/m ²	ISO 180/1A
Rockwell hardness	R 117	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2500	MPa	ASTM D 638
Tensile Strength at Yield	55	MPa	ASTM D 638
Tensile Strength at Break	34	MPa	ASTM D 638
Elongation at Break	25	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	79	MPa	ASTM D 790
Rockwell Hardness	R 117	-	ASTM D 785
Izod Impact notched, 1/8 in	20	J/m	ASTM D 256
Izod Impact notched, 1/4 in	20	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	260	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	250	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	80	°C	ISO 75-1/-2
Vicat softening temperature, B	97	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	99	°C	ASTM D 648
DTUL @ 264 psi	79	°C	ASTM D 648
Other properties			
Density	1170	kg/m ³	ISO 1183
Density	1170	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230 - 250	°C	-

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Mold temperature	50 - 80	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 240	°C	-
Zone 3	240 - 250	°C	-
Nozzle temperature	250	°C	-
Screw speed	50 - 80	rpm	-
Injection pressure	98	MPa	-
Back pressure	0.5 - 2.5	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific