

STAREX TF-0956

PMMA

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	6	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	6	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0033	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0038	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2500	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	17	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	4.7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	3.9	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	51	MPa	ASTM D 638
Tensile Strength at Break	45	MPa	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	74	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	49	J/m	ASTM D 256
Thermal properties			
ISO Data			
Vicat softening temperature, B	93	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	80	°C	ASTM D 648
Other properties			
Density	1070	kg/m ³	ISO 1183
Density	1070	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	240 - 250	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	220 - 230	°C	-

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Zone 2	230 - 240	°C	-
Zone 3	240 - 250	°C	-
Nozzle temperature	250	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 250	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific