

STAREX TF-0957H

PMMA

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	16	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	16	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955
Mechanical properties			
ISO Data	Value	Unit	Test Standard
Tensile Modulus	2000	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	15	%	ISO 527
Flexural modulus, 23°C	1900	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	2	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	2	kJ/m ²	ISO 180/1A
Rockwell hardness	R 108	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	44	MPa	ASTM D 638
Tensile Strength at Break	44	MPa	ASTM D 638
Elongation at Break	40	%	ASTM D 638
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	68	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/8 in	49	J/m	ASTM D 256
Izod Impact notched, 1/4 in	49	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	70	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	75	°C	ISO 75-1/-2
Vicat softening temperature, B	85	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	80	°C	ASTM D 648
DTUL @ 264 psi	75	°C	ASTM D 648
Optical properties			
ASTM Data	Value	Unit	Test Standard
Haze	1.7	%	ASTM D 1003
Other properties			
Value	Unit	Test Standard	
Density	1170	kg/m ³	ISO 1183
Density	1170	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value	Unit	Test Standard	
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