

**SUMIPEX® HT01X**

PMMA

Sumitomo Chemical Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	2	g/10min	ISO 1133
Temperature	230	°C	-
Load	3.8	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Stress at break	38	MPa	ISO 527
Strain at break	>50	%	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Charpy notched impact strength, +23°C	5.6	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	M 100	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	87	°C	ISO 75-1/-2
Vicat softening temperature, B	97	°C	ISO 306

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	20	kV/mm	IEC 60243-1

Optical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Haze	1.1	-	ISO 14782
Luminous transmittance	91	%	ISO 13468-1, -2

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Density	1150	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	4 - 6	h	-
Mold temperature	60 - 85	°C	-
Zone 1	220	°C	-
Zone 2	230 - 245	°C	-
Zone 3	240 - 260	°C	-
Screw speed	40 - 60	rpm	-
Injection pressure	140 - 160	MPa	-
Back pressure	0.9 - 1.4	MPa	-
Holding pressure	20 - 80	MPa	-

**Characteristics****Processing**

Injection Molding, Other Extrusion

**Special Characteristics**

High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat, Transparent

**Chemical Resistance**

Alkali Resistance, General Chemical Resistance, Oil Resistance

**Regional Availability**

North America, Europe, Asia Pacific

**Features**

Light Diffusing