

**SUMIPEX® HT25X**

PMMA

Sumitomo Chemical Co., Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>2</b>	g/10min	ISO 1133
Temperature	<b>230</b>	°C	-
Load	<b>3.8</b>	kg	-
Molding shrinkage, parallel	<b>0.6</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Stress at break	<b>67</b>	MPa	ISO 527
Strain at break	<b>16</b>	%	ISO 527
Flexural modulus, 23°C	<b>2800</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>1.8</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>M 100</b>	-	ISO 2039-2
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>100</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>108</b>	°C	ISO 306
<b>Electrical properties</b>			
<b>ISO Data</b>			
Relative permittivity, 1MHz	<b>3.1</b>	-	IEC 62631-2-1
Volume resistivity	<b>&gt;1E13</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>&gt;1E15</b>	Ohm	IEC 62631-3-2
Electric strength	<b>20</b>	kV/mm	IEC 60243-1
<b>Optical properties</b>			
<b>ISO Data</b>			
Haze	<b>0.7</b>	-	ISO 14782
Luminous transmittance	<b>93</b>	%	ISO 13468-1, -2
<b>Other properties</b>			
Water absorption	<b>0.3</b>	%	Sim. to ISO 62
Density	<b>1180</b>	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>80 - 85</b>	°C	-
Pre-drying - Time	<b>4 - 6</b>	h	-
Mold temperature	<b>60 - 85</b>	°C	-
Zone 1	<b>220</b>	°C	-
Zone 2	<b>230 - 245</b>	°C	-
Zone 3	<b>240 - 260</b>	°C	-
Screw speed	<b>40 - 60</b>	rpm	-
Injection pressure	<b>140 - 160</b>	MPa	-
Back pressure	<b>0.9 - 1.4</b>	MPa	-
Holding pressure	<b>20 - 80</b>	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