

**HAM8541H**  
(PMMA+ABS)

Shanghai Kumho Sunny Plastics Co., Ltd.

| Processing/Physical Characteristics | Value  | Unit    | Test Standard |
|-------------------------------------|--------|---------|---------------|
| <b>ASTM Data</b>                    |        |         |               |
| Melt Flow Index, MFI                | 10     | g/10min | ASTM D 1238   |
| Temperature                         | 220    | °C      | -             |
| Load                                | 10     | kg      | -             |
| Mold Shrinkage, MD                  | 0.0055 | mm/mm   | ASTM D 955    |

| Mechanical properties       | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| <b>ASTM Data</b>            |       |      |               |
| Tensile Strength            | 60    | MPa  | ASTM D 638    |
| Elongation at Break         | 20    | %    | ASTM D 638    |
| Flexural Modulus            | 2500  | MPa  | ASTM D 790    |
| Flexural Strength           | 75    | MPa  | ASTM D 790    |
| Izod Impact notched, 1/8 in | 70    | J/m  | ASTM D 256    |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| <b>ASTM Data</b>   |       |      |               |
| DTUL @ 264 psi     | 86    | °C   | ASTM D 648    |
| Vicat Temperature  | 96    | °C   | ASTM D 1525   |

| Electrical properties | Value | Unit  | Test Standard |
|-----------------------|-------|-------|---------------|
| <b>ISO Data</b>       |       |       |               |
| Volume resistivity    | 1E15  | Ohm*m | IEC 62631-3-1 |
| Surface resistivity   | >1E15 | Ohm   | IEC 62631-3-2 |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1120  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 80 - 90   | °C   | -             |
| Pre-drying - Time                           | 3 - 4     | h    | -             |
| Processing humidity                         | ≤0.02     | %    | -             |
| Melt temperature                            | 200 - 230 | °C   | -             |
| Mold temperature                            | 40 - 80   | °C   | -             |
| Zone 1                                      | 200 - 220 | °C   | -             |
| Zone 2                                      | 220 - 230 | °C   | -             |
| Zone 3                                      | 230 - 240 | °C   | -             |
| Nozzle temperature                          | 225 - 235 | °C   | -             |
| Screw speed                                 | 30 - 60   | rpm  | -             |
| Back pressure                               | 1 - 5     | MPa  | -             |

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Features**

High Gloss, Scratch Resistant