

HI835HS PMMA, Impact Resistant Grade

| PROPERTY | CONDITION | UNIT | METHOD | VALUE |
|------------------------------------------|-------------|-------------------|-----------------|--------------------|
| OPTICAL PROPERTIES | | | | |
| Refractive Index | nd | - | ISO 489 | 1.49 |
| Light Transmittance | 3mm | % | ISO 13468-1 | 91 |
| Haze | 3mm | % | ISO 14782 | <2.0 |
| THERMAL PROPERTIES | | | | |
| Melt Flow Index | 230°C/3.8kg | g/10min | ISO 1133 | 1.5 |
| VICAT Softening Point | B/50 | °C | ISO 306 | 77 |
| Heat Deflection Temperature | 1.8MPa | °C | ISO 75 | 70 |
| Coefficient of Linear Expansion | - | 1/°C | ASTM D696 | 7X10 ⁻⁵ |
| MECHANICAL PROPERTIES | | | | |
| Charpy Impact Strength | notched | kJ/m ² | ISO 179 | 6.0 |
| Rockwell Hardness | M scale | - | ISO 2039-2 | 44 |
| Tensile Strength at Break | 5mm/min | MPa | ISO 527 | 27 |
| Tensile Strain at Break | 5mm/min | % | ISO 527 | 57 |
| Tensile Modulus | 1mm/min | GPa | ISO 527 | 1.0 |
| Flexural Strength | 2mm/min | MPa | ISO 178 | 37 |
| Flexural Modulus | 2mm/min | GPa | ISO 178 | 1.1 |
| GENERAL PROPERTIES | | | | |
| Density | - | g/cm ³ | ISO 1183 | 1.16 |
| Mold Shrinkage | - | % | ASTM D955 | 0.4-0.8 |
| Water Absorption | 24hr | % | ASTM D570 | 0.4 |
| Flammability UL94 | 1.5mm | Class | IEC 60695-11-10 | HB |
| RECOMMENDED PROCESSING CONDITIONS | | | | |
| Predrying Temperature | | °C | | Max. 80 |
| Predrying Time in Desiccant-Type Drier | | hr | | 3-4 |
| Melt Temperature | | °C | | 210-240 |
| Mold Temperature | | °C | | 50-70 |

REMARKS : The listed values should be used for reference purpose only.