

KumhoSunny PMMA/ABS HAM8541H

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAM8541H is paint free improved PMMA/ABS resin.HAM8541H has comprehensive properties:(1)anti-scratch,PH=2H (2) high gloss(G60°>95)(3)free style(black and spark,semitransparent,spark,transparent) (4)cheap.HAM8541H is mainly used in complex part, thin layer part ,small appliance as telephone, sound. etc.

General Information			
Features	High Gloss		
	Scratch Resistant		
Uses	Appliance Components		
	Appliances		
UL File Number	E254819		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	60.0	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	2500	MPa	ASTM D790
Flexural Strength	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	70	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	86.0	°C	ASTM D648
Vicat Softening Temperature	96.0	°C	ASTM D1525 ¹
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.020	%	

Rear Temperature	200 to 220	°C
Middle Temperature	220 to 230	°C
Front Temperature	230 to 240	°C
Nozzle Temperature	225 to 235	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	40.0 to 80.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 60	rpm

NOTE

1. Rate B (120°C/h)

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