

# Vikalloy IM88

Acrylic (PMMA) + PVC

Viking Polymers, LLC

## Message:

IM88 low smoke injection molding compound is a proprietary, high performance compound designed for use in mass transit vehicles such as subways, vans, buses, and trains. It meets the recommended fire safety practices of both the Federal Transit Administration (FTA) and the Federal Rail Administration (FTA) for smoke emission and flammability as tested under ASTM E-662 and ASTM E-162. It is the ideal material for parts used in rail and transit applications.

General Information			
Features	Solvent resistance		
	Cleanable		
	Good chemical resistance		
	Flame retardancy		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	41.4	MPa	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength	63.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	77.8	°C	ASTM D648
Additional Information			
Smoke Generation, ASTM E162, Ds @ 4.0 min: 164			
Injection	Nominal Value	Unit	
Drying Temperature	54.4	°C	
Drying Time	4.0	hr	
Middle Temperature	157 - 196	°C	
Front Temperature	157 - 196	°C	
Processing (Melt) Temp	196 - 207	°C	
Mold Temperature	32.2 - 60.0	°C	
Back Pressure	0.689 - 2.76	MPa	

#### Injection instructions

Drying is not typically required, however if material is old or has been stored in moist conditions follow drying parameters listed.

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#### Recommended distributors for this material

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