

ShinkoLite-P IR H-70

Polymethyl Methacrylate Acrylic
Mitsubishi Rayon America Inc.

Message:

ShinkoLite-P IR H-70 is a Polymethyl Methacrylate Acrylic material. It is available in North America for extrusion or injection molding.
Important attributes of ShinkoLite-P IR H-70 are:
Low to No Odor/Taste
Chemical Resistant
Good Dimensional Stability
Good Processability
Good Weather Resistance
Typical applications include:
Engineering/Industrial Parts
Hose/Tubing

General Information			
UL YellowCard	E54695-268348	E256044-100422217	E256044-100422219
Features	E95683-101677755		
	Good Chemical Resistance		
	Good Dimensional Stability		
	Good Flow		
	Good Moldability		
	Good Weather Resistance		
	High Gloss		
	High Heat Resistance		
	High Impact Resistance		
	Low to No Odor		
	Low to No Taste		
Uses	Rods		
	Tubing		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.70	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Water Absorption (24 hr)	0.40	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method

Rockwell Hardness		ASTM D785	
M-Scale	37		
R-Scale	92		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	32.4	MPa	ASTM D638
Tensile Elongation (Break)	90	%	ASTM D638
Flexural Modulus	1270	MPa	ASTM D790
Flexural Strength (Break)	45.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525
CLTE - Flow	1.1E-4	cm/cm/°C	ASTM D696
Specific Heat	1460	J/kg/°C	ASTM C351
Thermal Conductivity	0.21	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength	15	kV/mm	ASTM D149
Dielectric Constant (60 Hz)	3.90		ASTM D150
Dissipation Factor (60 Hz)	0.040		ASTM D150
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		ASTM D542
Transmittance	92.0	%	ASTM D1003
Haze	2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	220 to 270	°C	
Middle Temperature	220 to 270	°C	
Front Temperature	220 to 270	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	78.4 to 137	MPa	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	200 to 220	°C	
Cylinder Zone 2 Temp.	230 to 250	°C	
Cylinder Zone 3 Temp.	230 to 250	°C	
Die Temperature	230 to 250	°C	

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