

ShinkoLite-P IR G-504

Polymethyl Methacrylate Acrylic
Mitsubishi Rayon America Inc.

Message:

ShinkoLite-P IR G-504 is a Polymethyl Methacrylate Acrylic material. It is available in North America for extrusion or injection molding.
Important attributes of ShinkoLite-P IR G-504 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	E95683-101677755
Features	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	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.90	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 (M-Scale)	64		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	44.1	MPa	ASTM D638
Tensile Elongation (Break)	85	%	ASTM D638
Flexural Modulus	1770	MPa	ASTM D790
Flexural Strength (Break)	59.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	58	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	89.0	°C	ASTM D648
Vicat Softening Temperature	104	°C	ASTM D1525
CLTE - Flow	9.5E-5	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)	3.80		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
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

