

ShinkoLite-P MF

Polymethyl Methacrylate Acrylic
Mitsubishi Rayon America Inc.

Message:

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

General Information			
UL YellowCard	E54695-244809	E256044-100422227	E95683-101677758
Features	Good Chemical Resistance		
	Good Dimensional Stability		
	Good Impact Resistance		
	Good Moldability		
	Good Weather Resistance		
	High Flow		
	High Gloss		
	High Heat 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	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 to 0.60	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3240	MPa	ASTM D638
Tensile Strength (Break)	65.7	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	3040	MPa	ASTM D790
Flexural Strength (Break)	98.2	MPa	ASTM D790
Compressive Strength	98.2	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (6.35 mm)	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	82.0	°C	ASTM D648
Vicat Softening Temperature	97.0	°C	ASTM D1525
CLTE - Flow	6.0E-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	20	kV/mm	ASTM D149
Dielectric Constant (60 Hz)	3.70		ASTM D150
Dissipation Factor (60 Hz)	0.050		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		ASTM D542
Transmittance	93.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 75.0	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	170 to 230	°C	
Middle Temperature	170 to 230	°C	
Front Temperature	170 to 230	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	78.4 to 137	MPa	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	190 to 220	°C	
Cylinder Zone 2 Temp.	210 to 230	°C	
Cylinder Zone 3 Temp.	210 to 230	°C	
Die Temperature	210 to 230	°C	

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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



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