

KumhoSunny PMMA/ABS HAM8541

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAM8541 is paint free improved PMMA/ABS resin.HAM8541 has comprehensive properties:(1)anti-scratch,PH=1H (2) high gloss(G60°>95)(3)free style(black and spark,semitransparent,spark,transparent) (4)cheap.HAM8541 is mainly used in PDP, LCD TV Decoration, stand & back cover /DVD housing,specially suitable for black colors,etc.

General Information			
UL YellowCard	E254819-100086410		
Features	High Gloss		
	Scratch Resistant		
Uses	Appliance Components		
	Appliances		
	Decorative Parts		
UL File Number	E254819		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Pencil Hardness - 500g	H		ASTM D3363
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	55.0	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	2400	MPa	ASTM D790
Flexural Strength	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	83.0	°C	ASTM D648
Vicat Softening Temperature	90.0	°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
Rear Temperature	210 to 220	°C
Middle Temperature	220 to 230	°C
Front Temperature	230 to 240	°C
Nozzle Temperature	230 to 240	°C
Processing (Melt) Temp	220 to 240	°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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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

