

PARAPET HR-F

Polymethyl Methacrylate Acrylic

Kuraray Co., Ltd.

Message:

PARAPET HR-F is a polymethyl methacrylate-acrylic material. This product is available in North America, Europe or Asia Pacific. The main characteristics of PARAPET HR-F are: flame retardant/rated flame.

The typical application field of PARAPET HR-F is: automobile industry

General Information			
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.5	g/10 min	ISO 1133
Molding Shrinkage	0.20 - 0.60	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	102		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	65.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/5
Flexural Modulus	3300	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.3	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	20	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Annealed)	101	°C	ISO 75-2/A
Vicat Softening Temperature	108	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Dielectric Strength	20	kV/mm	IEC 60243-1
Dielectric Constant (60 Hz)	4.00		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Optical	Nominal Value		Test Method
Refractive Index	1.490		ISO 489
Additional Information			
Light Transmission, ISO 13468-1, 3 mm: >92%Haze, ISO 14782, 3 mm: <0.3%			

Injection	Nominal Value	Unit
Drying Temperature	75.0 - 85.0	°C
Drying Time	4.0 - 6.0	hr
Rear Temperature	230 - 250	°C
Middle Temperature	230 - 250	°C
Front Temperature	230 - 250	°C
Mold Temperature	50.0 - 80.0	°C
Injection Pressure	80.0 - 140	MPa

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