

SUMIPEX® MHF

Polymethyl Methacrylate Acrylic

Sumitomo Chemical Co., Ltd.

Message:

SUMIPEX general-purpose grades can be classified into two basic categories; good flow and heat resistant types. Each grade is available in pellet form. Bead form is available for some grades

General Information			
Features	High Heat Resistance		
Uses	Automotive Applications		
	Automotive Instrument Panel		
	Industrial Applications		
	Lenses		
	Lighting Fixtures		
UL File Number	E54705B		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.19	g/cm ³	JIS K7112
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.0	g/10 min	JIS K7210
Molding Shrinkage - Flow	0.20 to 0.60	%	ASTM D955
Water Absorption (24 hr)	0.30	%	JIS K7209
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	100		JIS K7202
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	76.0	MPa	JIS K7113
Tensile Elongation (Break)	12	%	JIS K7113
Flexural Modulus	3200	MPa	JIS K7203
Flexural Strength	120	MPa	JIS K7203
Flexural Rigidity	7.0	%	JIS K7203
Voltage Resistance ²	20.0	kV/min	JIS K6911
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.4	kJ/m ²	JIS K7110
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ³ (1.8 MPa, Annealed)	102	°C	JIS K7207
Vicat Softening Temperature	111	°C	JIS K7206
CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+16	ohms	JIS K6911

Volume Resistivity	> 1.0E+15	ohms·cm	JIS K6911
Dielectric Constant	3.10		JIS K6911
Dissipation Factor	0.040		JIS K6911
Insulation Resistance	> 1.0E+15	ohms	JIS K6911
Flammability	Nominal Value	Unit	Test Method
Burning Rate	30	mm/min	ASTM D63
Flame Rating (1.59 mm, All Colors)	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		JIS K7105
Transmittance ⁴	93.0	%	JIS K7105
Haze	< 0.50	%	JIS K7105
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	240 to 270	°C	
Middle Temperature	240 to 270	°C	
Front Temperature	240 to 270	°C	
Mold Temperature	60.0 to 85.0	°C	
Injection Pressure	78.5 to 137	MPa	
NOTE			
1.	Method A		
2.	60%, 1kHz		
3.	VST 25±3, 4 hrs		
4.	Method A		

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