

SUMIPEX® HT25X

Polymethyl Methacrylate Acrylic

Sumitomo Chemical Co., Ltd.

Message:

In addition to the standard SUMIPEX which features of transparency, weather resistance and mechanical strength, SUMIPEX HT incorporates substantially greater impact strength. This increased strength functions to reduce the amount of cracking that might occur, at the time of molding or transportaion.

General Information			
UL YellowCard	E54705-245051		
Features	Good Crack Resistance		
	Good Impact Resistance		
	Good Strength		
	Good Weather Resistance		
	High Heat Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Instrument Panel		
	Automotive Interior Trim		
	Construction Applications		
	Table Products		
UL File Number	E54705B		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity ¹	1.18	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	0.40 to 0.70	%	ASTM D955
Water Absorption (24 hr)	0.30	%	JIS K7209
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		JIS K7202
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	67.0	MPa	JIS K7113
Tensile Elongation (Break)	27	%	JIS K7113
Flexural Modulus	2800	MPa	JIS K7203
Flexural Strength	107	MPa	JIS K7203
Flexural Rigidity	> 8.0	%	JIS K7203
Voltage Resistance ²	20.0	kV/min	JIS K6911

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.8	kJ/m ²	JIS K7110
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ³ (1.8 MPa, Annealed)	99.0	°C	JIS K7207
Vicat Softening Temperature	108	°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	1.0	%	JIS K7105
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	220 to 250	°C	
Middle Temperature	220 to 250	°C	
Front Temperature	220 to 250	°C	
Mold Temperature	70.0 to 80.0	°C	
Injection Pressure	58.8 to 137	MPa	
NOTE			
1.	Method A		
2.	60%, 1kHz		
3.	VST 25±3, 4 hrs		
4.	Method A		

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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

