



A~Star Plastics Pte Ltd

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Company & GST Registration #: 201504765Z

Technical Data Sheet

Material Type: PMMA OFF GRADE RESIN

Grade: PMMA-MH00IJ-010

Colour: NATURAL

Application: General purpose injection application

<u>Physical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Density	1.18	g/cm ³	ASTM D792
Melt Flow Index at 230°C, 3.8 kgf	6 - 20	g/10min	ASTM D1238
Water Absorption, 23°C	0.3	%	ASTM D570
<u>Mechanical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Tensile Strength at yield	70 ± 2	MPa	ASTM D638
Tensile Elongation at break	> 3	%	ASTM D638
Izod Impact, notched, 23°C	1.5 ± 0.5	kgf.cm/cm	ASTM D256
<u>Thermal</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Heat Deflection Temperature at 1.82 Mpa	87 - 92	°C	ASTM D648

Processing Condition

<u>Temperature</u>	<u>Value</u>	<u>Unit</u>
Melt Temperature	210 - 240	°C
Rear Barrel Temperature	210 - 230	°C
Middle Barrel Temperature	220 - 240	°C
Front Barrel Temperature	220 - 240	°C
Nozzle Temperature	210 - 230	°C
Mould Temperature	60 - 80	°C
Drying Temperature	75 - 85	°C
Drying Time	4	hour

The information should only be used as a reference guide.

A~Star Plastics makes no warranties of the product for any particular use or purpose.

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