

Technical Data Sheet

HAM8580

PMMA

PRODUCT DESCRIPTION:

PMMA HAM8580 offers high gloss,super high weather resistance with excellent anti-scratch performance

FEATURES:

- High gloss
- High weather resistance

APPLICATION:

- Pillar trim panel

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	g/cm ³	23°C	1.19
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.2-0.6
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	75
Flexural Strength ³	ISO 178	2mm/min	MPa	90
Flexural Modulus	ISO 178	2mm/min	MPa	3200
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	1.5
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	20
Rockwell Hardness	ISO 2039	23°C	R-scale	124
Thermal				
Heat Deflection Temperature ⁴	ISO 75	120°C/hr, 1.80MPa	°C	93
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	108
Other Properties				
Flammability	UL-94	Class	1.6mm	HB
Volume resistivity	IEC 60093	Ohm-cm	/	>1.E+15
Surface resistivity	IEC 60093	Ohm	/	>1.E+15

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		80 ~ 90	°C
Drying Time		3 ~ 4	hour
Maximum moisture content		≤0.02	%
General Guidelines¹			
Barrel Temperature	Rear	220 ~ 240	°C
	Middle	230 ~ 250	°C
	Front	240 ~ 260	°C
Nozzle		240 ~ 260	°C
Melt Temperature		240 ~ 260	°C
Mold Temperature		50 ~ 80	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with unfixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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