

Lotte Chemical Corporation - Methyl Methacrylate / ABS

Wednesday, March 9, 2022

	General In	formation		
General				
Material Status	Commercial: Active			
Availability	Africa & Middle East	Europe	North America	
Availability	Asia Pacific	Latin America		
	ASTM & ISO	Properties ¹		
Physical		Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)		1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0	kg)	24	g/10 min	ASTM D1238
Mechanical		Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)		37.0	MPa	ASTM D638
Impact		Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)		170	J/m	ASTM D256
Hardness		Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)		105		ASTM D785
Thermal		Nominal Value	Unit	Test Method
Vicat Softening Temperature		89.0	°C	ISO 306/B50
	Processing	Information		
Injection	Processing	Nominal Value	Unit	
Drying Temperature	*		Unit	
Desiccant Dryer		80	°C	
Hot Air Dryer			°C	
Drying Time				
Desiccant Dryer		2.0 to 4.0	hr	
Hot Air Dryer		4.0 to 6.0		
Suggested Max Moisture	CHEM	< 0.050		
Rear Temperature		180 to 190		
Middle Temperature		200 to 210		
Front Temperature		220 to 230	°C	
Nozzle Temperature		230	°C	
Mold Temperature		50 to 70	°C	
Injection Pressure		49.0 to 196	MPa	
Back Pressure		0.490 to 1.96	MPa	
Screw Speed		50 to 150	rpm	
Injection Notes				

Hot Runner Temperature: 220°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 5.0 mm/min



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