RÖHM ALBIS

PLEXIGLAS® Heatresist hw55

PMMA Röhm GmbH

Productprofil:

PLEXIGLAS® Heatresist hw55 clear is a copolymer based on methyl methacrylate (MMA) with comonomer constituents.

Besides showing the familiar properties of standard PLEXIGLAS® molding compound, such as

- high light transmission,
- good flowability,
- high mechanical strength, surface hardness and abrasion resistance, as well as
- excellent weatherability,

PLEXIGLAS® Heatresist hw55 clear offers the additional benefits of

- increased heat deflection temperature under load and
- improved resistance to stress cacking
- optimised inherent color,
- AMECA listing.

Application:

PLEXIGLAS® Heatresist hw55 clear is particularly suitable for injection molding of technical items.

Example:

lighted keys, luminaire covers, fiber optics.

Processing:

PLEXIGLAS® Heatresist hw55 clear can be processed on injection molding machines with 3-zone general purpose screws for thermoplastics.

Physical Form / Packaging:

PLEXIGLAS® Heatresist hw55 is supplied as pellets of uniform size, packaged in two-ply, 25kg polyethylene bags; other packaging on request.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1.2	cm³/10min	ISO 1133
Temperature	230	°C	-
Load	3.8	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3600	MPa	ISO 527
Stress at Break	80	MPa	ISO 527
Strain at Break	3.5	%	ISO 527
Tensile Creep Modulus, 1h	3300	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	2700	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	20	kJ/m²	ISO 179/1eU

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Glass Transition Temperature (10°C/min)	122	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	106	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	109	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	119	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	70	E-6/K	ISO 11359-1/-2

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Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.6	mm	-
UL recognition	yes	-	-
Oxygen index	18	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.5	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	400	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	200	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E13	Ohm	IEC 62631-3-2
Comparative tracking index	600	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	2.2	%	Sim. to ISO 62
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1190	kg/m³	ISO 1183

Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	60	cm³/g	ISO 307, 1157, 1628
Luminous transmittance	90	%	ISO 13468-1, -2

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	1080	kg/m³	-
Thermal Conductivity of Melt	0.19	W/(m K)	-
Spec. heat capacity of melt	2440	J/(kg K)	-
Eff. thermal diffusivity	7.22E-8	m²/s	-
Ejection temperature	100	°C	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	82	°C	ISO 294
Injection Molding, injection velocity	195	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	109	°C	-
Pre-drying - Time	2 - 3	h	-
Melt temperature	220 - 250	°C	-
Mold temperature	60 - 90	°C	-

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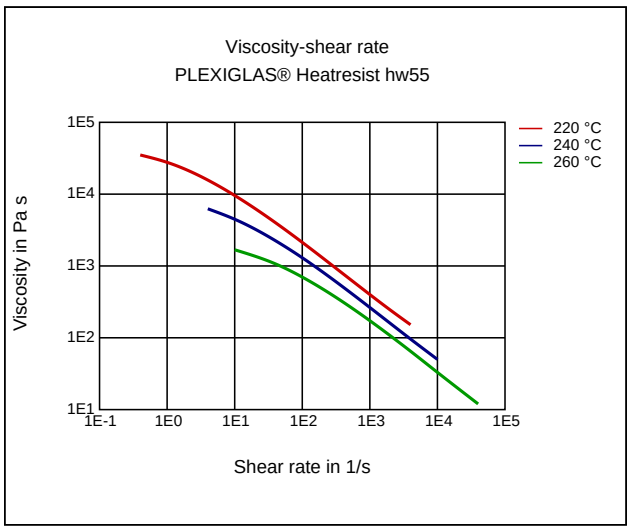
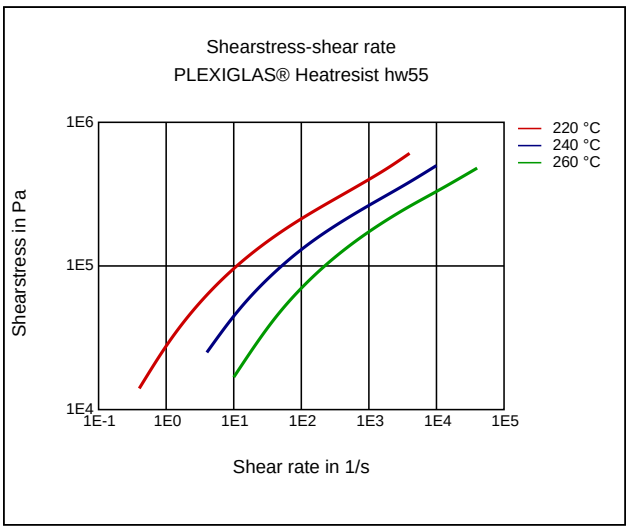
Diagrams

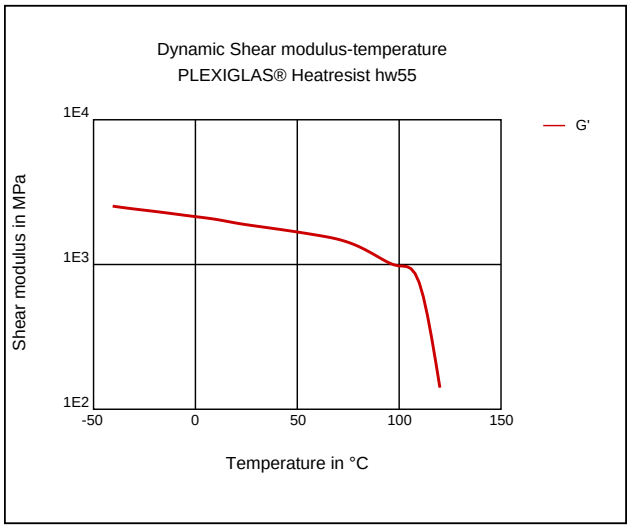
Viscosity-shear rate



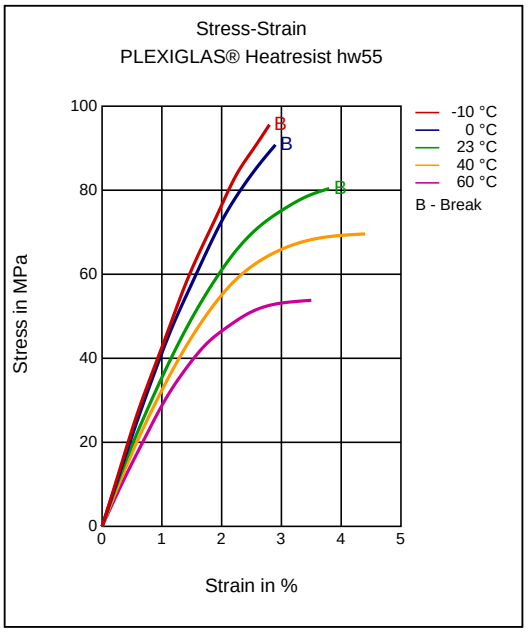
Shearstress-shear rate



Dynamic Shear modulus-temperature



Stress-strain



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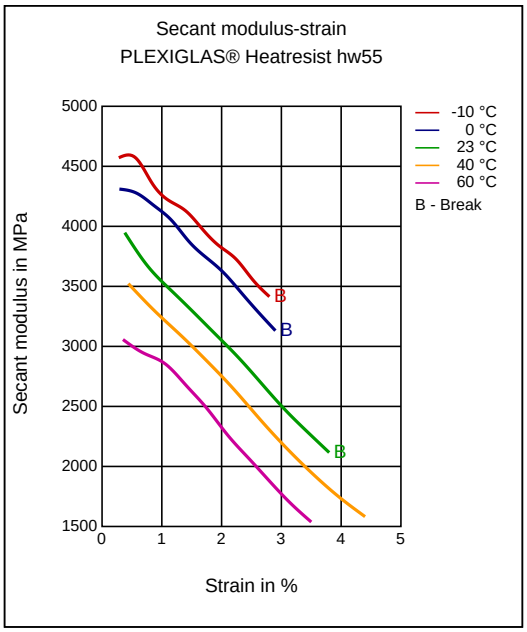
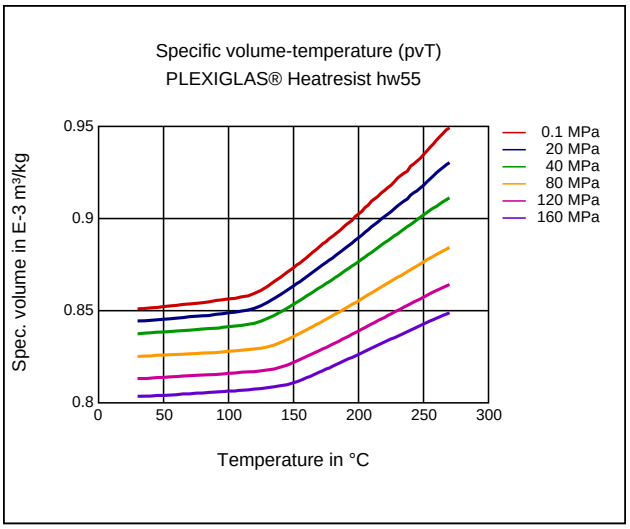
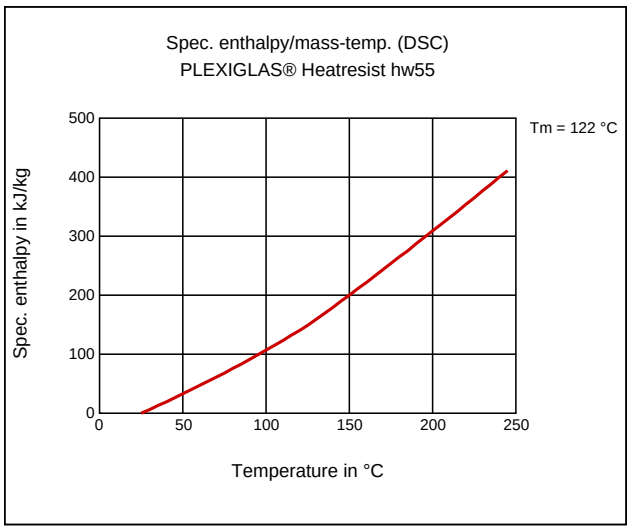
Secant modulus-strain



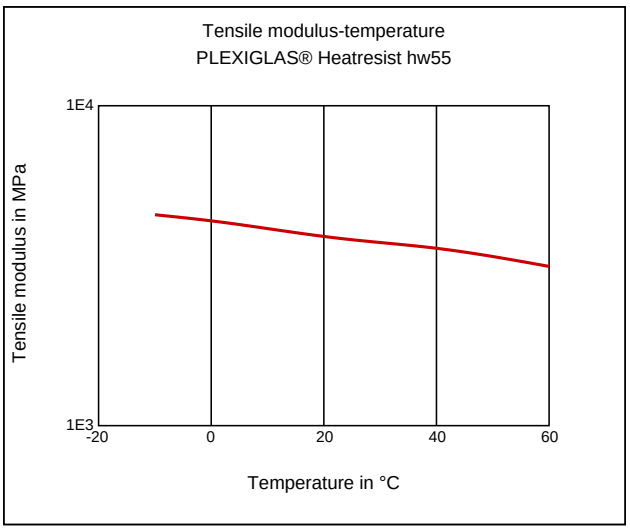
Specific volume-temperature (pvT)



Spec. enthalpy/mass-temp. (DSC)



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Features

Copolymer

Delivery form

Pellets

Chemical Resistance

Environmental Stress Crack Resistance

Special Characteristics

Light stabilized or stable to light, UV stablized, Heat aging stabilized, Transparent

Injection Molding

PREPROCESSING

Predrying temperature: max. 109 °C

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Predrying time in a desiccant-type drier: 2 - 3 h
PROCESSING
Melt temperature: 220 - 250°C
Mold temperature:60 - 90°C

Chemical Media Resistance

Acids

- ✔ Citric Acid solution (10% by mass) (23°C)
- ✔ Lactic Acid (10% by mass) (23°C)
- ✔ Nitric Acid (40% by mass) (23°C)
- ✔ Sulfuric Acid (38% by mass) (23°C)
- ✔ Sulfuric Acid (5% by mass) (23°C)

Bases

- ✔ Sodium Hydroxide solution (35% by mass) (23°C)
- ✔ Sodium Hydroxide solution (1% by mass) (23°C)
- ✔ Ammonium Hydroxide solution (10% by mass) (23°C)

Hydrocarbons

- ✔ n-Hexane (23°C)
- ✔ iso-Octane (23°C)

Standard Fuels

- ✔ Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23°C)
- ✔ Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23°C)
- ✔ Diesel fuel (pref. ISO 1817 Liquid F) (23°C)

Salt solutions

- ✔ Sodium Carbonate solution (20% by mass) (23°C)
- ✔ Sodium Carbonate solution (2% by mass) (23°C)

Other

- ✔ 50% Oleic acid + 50% Olive Oil (23°C)
- ✔ Water (23°C)