

PRODUCT DATA SHEET

LEXACRYL PM-400NT

Description

Lexacryl PM-400NT is PMMA using r-PMMA compound with high stiffness stability.

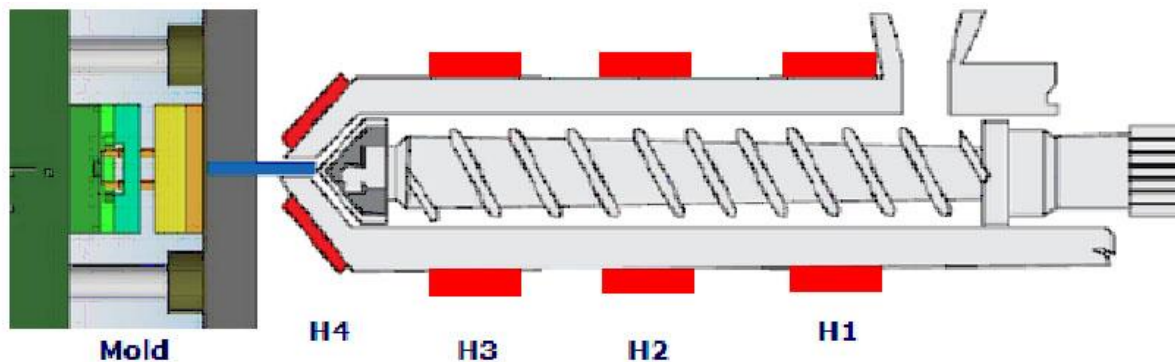
The product is available in natural color pellet form which have good melt flow rate for easy injection molding , specifically design to provide an excellent balance of stiffness for household goods.

Suggested molding conditions: melt temperature 230-240°C, mold temperature 60-90°C.

Application : Household goods, stationery , containers etc..

General properties	Unit	Test method	EPP-1400NT value
Density	g/cm ³	ISO 1183	1.19
Melt flow rate , @ 230°C, 3.8kgf	g / 10min	ISO 1133	4.0
Shrink-rate as-molded	-/1,000	Polylex method	2 ~6 / 1,000
Mechanical properties			
Izod impact strength, 4mm Unnotched @+23°C	KJ/m ²	ISO 180	18
Tensile stress, @ yield, 50 mm/min	MPa	ISO 527-1.-2	60
Tensile strain, @ yield, 50 mm/min	%	ISO 527-1.-2	2
Flexural strength, @yield, 10mm/min	MPa	ISO 178	120
Flexural modulus, @yield, 10mm/min	MPa	ISO 178	3,000
Thermal properties			
Deflection temperature @ 1.8MPa, 4mm	°C	ISO 75-2	85

PROCESSING GUIDE of PM-400NT



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	75 ~ 85
Drying Time		Hr	2 ~ 3
Maximum moisture content		%	0.02
Melt Temperature		°C	230 ~ 240
Cylinder Temperature	H4	°C	230 ~ 240
	H3	°C	220 ~ 230
	H2	°C	210 ~ 220
	H1	°C	200 ~ 210
Mold Temperature		°C	60 ~ 90
Back Pressure		MPa	0.3 ~ 0.7
Screw rotating speed		rpm	20 ~ 100