

Productprofil:

PLEXIGLAS® Resist zk5HF is an amorphous, impact-modified thermoplastic molding compound (PMMA-I).

Typical properties of impact-modified PLEXIGLAS® molding compounds are

- high weather resistance
- excellent transmission and clarity
- brilliant appearance
- the pleasant feel and sound of the moldings.

PLEXIGLAS® Resist zk5HF is characterized by the following special properties:

- high break resistance and impact strength
- improved resistance to stress cracking
- excellent flow.

Application:

Used for injection molding as well as for extruding sheets and profiles.

Example:

applications involving thin walls and long flow paths; thin-walled components; items requiring accurate mold surface reproduction, such as very finely textured luminaire covers.

Processing:

PLEXIGLAS® Resist zk5HF molding compound can be processed on machines with 3-zone general purpose screws for engineering thermoplastics.

Physical Form / Packaging:

PLEXIGLAS® Resist zk molding compounds are supplied as pellets of uniform size in 25 kg polyethylene bags or in 500 kg boxes with PE lining; other packaging on request.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	8.1	cm³/10min	ISO 1133
Temperature	230	°C	-
Load	3.8	kg	-
Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2500	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Yield strain	4.5	%	ISO 527
Nominal strain at break	25	%	ISO 527
Impact Strength (Charpy), +23°C	50	kJ/m²	ISO 179/1eU
Thermal Properties	Value	Unit	Test Standard
ISO Data			
Glass Transition Temperature (10°C/min)	95	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	93	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	102	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	96	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	90	E-6/K	ISO 11359-1/-2

Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.6	mm	-
UL recognition	yes	-	-
Oxygen index	17.5	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.7	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	500	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	300	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E13	Ohm	IEC 62631-3-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	1.9	%	Sim. to ISO 62
Humidity absorption	0.5	%	Sim. to ISO 62
Density	1170	kg/m³	ISO 1183

Material Specific Properties	Value	Unit	Test Standard
ISO Data			
Luminous transmittance	92	%	ISO 13468-1, -2

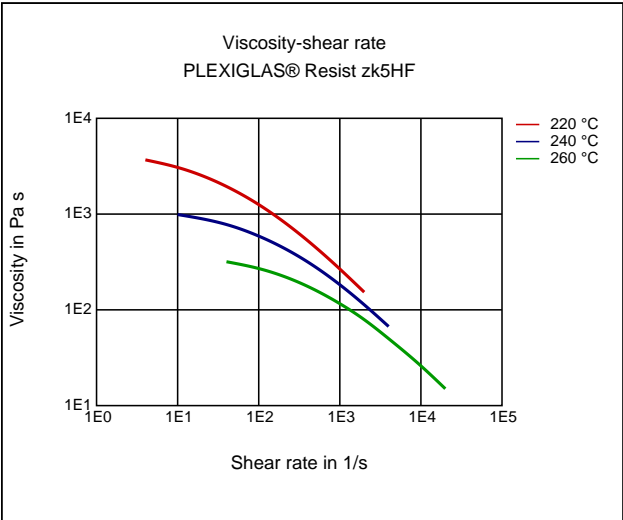
Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	1040	kg/m³	-
Thermal Conductivity of Melt	0.19	W/(m K)	-
Spec. heat capacity of melt	2440	J/(kg K)	-
Eff. thermal diffusivity	7.49E-8	m²/s	-
Ejection temperature	75	°C	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	230	°C	ISO 294
Injection Molding, mold temperature	56	°C	ISO 294
Injection Molding, injection velocity	195	mm/s	ISO 294

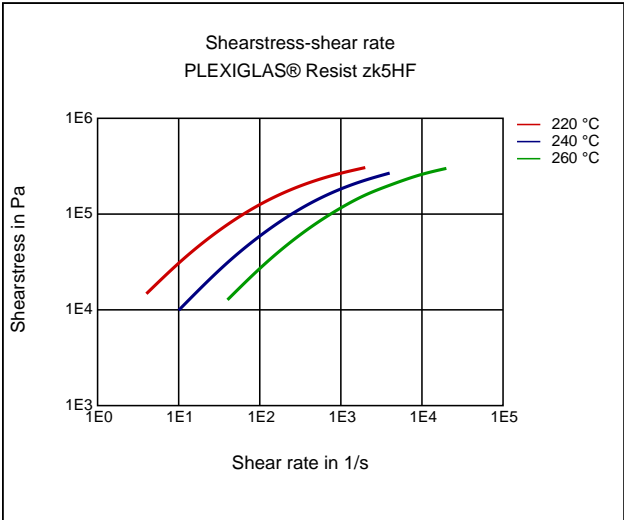
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	2 - 3	h	-
Melt temperature	220 - 260	°C	-
Mold temperature	50 - 70	°C	-

Diagrams

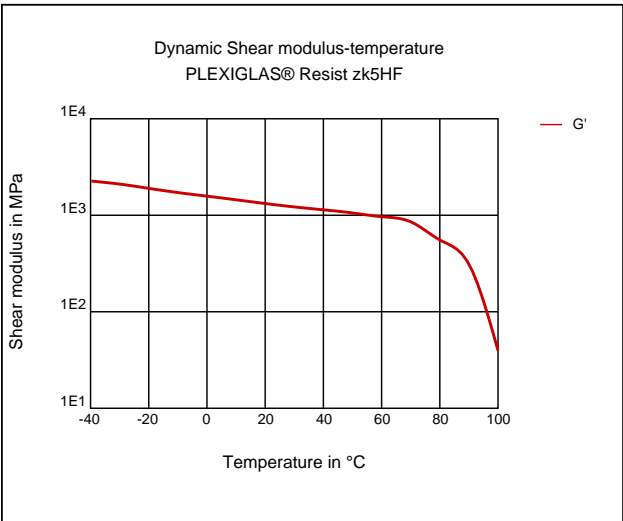
Viscosity-shear rate



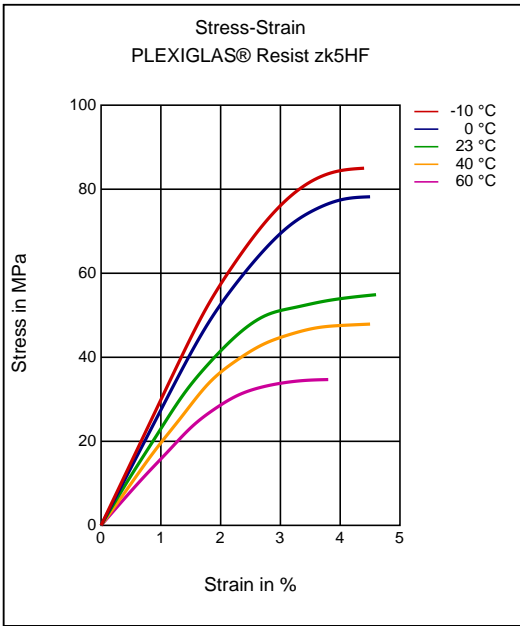
Shearstress-shear rate



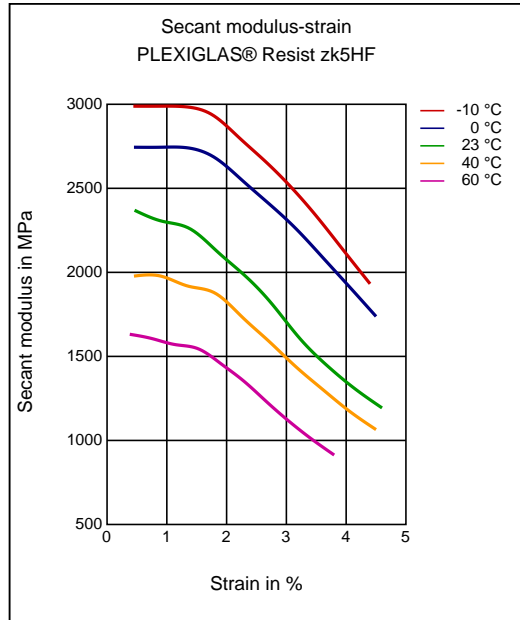
Dynamic Shear modulus-temperature



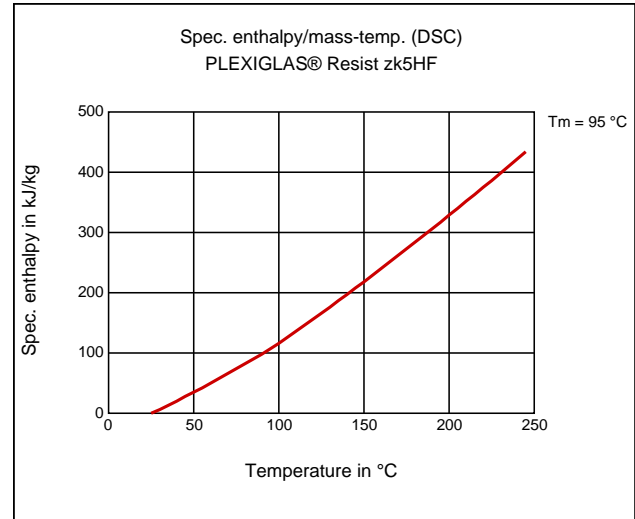
Stress-strain



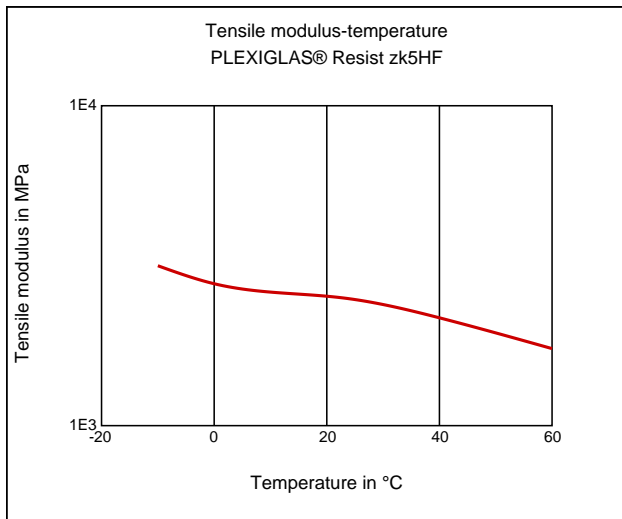
Secant modulus-strain



Spec. enthalpy/mass-temp. (DSC)



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding, Profile Extrusion, Sheet Extrusion

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Impact modified, Light stabilized or stable to light, UV stabilized, Transparent

Features

Amorphous

Chemical Resistance

Environmental Stress Crack Resistance

Injection Molding

PREPROCESSING

Predrying temperature: max. 85 °C

Predrying time in a desiccant-type drier: 2 - 3 h

PROCESSING

Melt temperature: 220 - 260 °C

Mold temperature: 50 - 70 °C

Chemical Media Resistance

Acids

- ✓ Citric Acid solution (10% by mass) (23 °C)
- ✓ Lactic Acid (10% 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)

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)

Other

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

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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