

TECHNICAL DATASHEET

TRIMMA® FM6341HF

Modified PMMA

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.08
Water Absorption (24 hours at 23°C)	%	D570	0.02
Melt Flow Rate (220°C, 10kg)	g/10min	D1238	50
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	450
Tensile Elongation at break	%	D638	40
Flexural Strength at yield	kg _f /cm ²	D790	600
Flexural Modulus	kg _f /cm ²	D790	25,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	12
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	82
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.2mm thickness)	-	(UL 94)	HB

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRIMMA® FM6341HF GRADE

Modified PMMA

- General processing conditions for TRIMMAFM6341HF are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	75-80
Drying Time	hr	3-5
Moisture Content, Max	%	0.02
Melt Temperature	℃	220-240
Nozzle Temperature	℃	220-240
Front Temperature	℃	210-230
Middle Temperature	℃	210-230
Rear Temperature	℃	190-200
Mold Temperature	℃	50-80
Back Pressure	MPa	0.3-0.5
Screw Speed	rpm	40-70
Vent Depth	mm	0.02-0.08

Global Network

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