

TECHNICAL DATASHEET

TRIMMA® SD6320

Modified PMMA

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.10
Water Absorption (24 hours at 23°C)	%	D570	0.5
Melt Flow Rate (220°C, 10kg)	g/10min	D1238	13
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	430
Tensile Elongation at break	%	D638	20
Flexural Strength at yield	kg _f /cm ²	D790	520
Flexural Modulus	kg _f /cm ²	D790	18,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	20
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	80
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	0.5~0.7

※ 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® SD6320 GRADE

Modified PMMA

- General processing conditions for TRIMMASD6320 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	70-80
Drying Time	hr	4-5
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

HEAD OFFICE

Samyang Corporation
31, Jong-ro 33-gil, Jongno-gu, Seoul, Korea
T. +82-2-740-7747

Chemical Research Center

730, Daedeok-daero, Yuseong-gu, Daejeon, Korea
T. +82-42-865-8114

JEONJU ENGINEERING PLASTIC PLANT

147, Palbok-ro, Deokjin-gu, Jeonju, Korea
T. +82-63-210-6664

SAMYANG ENGINEERING PLASTICS (SHANGHAI) CO., LTD.

No.131, Shuangying Road, Qingpu Industrial Area,
Qingpu County, Shanghai, China
T. +86-21-6922-2270

SAMYANG ENGINEERING PLASTICS (HUNGARY) CO., LTD.

H5100, Jaszbereny, Necso, Telep 1, Hungary
T. +36-21-311-1263

SAMYANG ENGINEERING PLASTICS (VIETNAM) LLC

1 Song Hanh Road, Nhon Trach 6 Industrial Zone, Long Tho
Commune, Nhon Trach District, Dong Nai Province, Vietnam
T. +84-0251-3686-707