

HML5150

HML5150 is a kind of appending 50%~60% biological base plastic environmental PLA/PMMA resin.HML5150 has excellent mechanical properties and excellent transpranet properties.HML5150 is mainly used in window of OA, ornament of TV set,etc.

Properties	Standard	Unit	Condition	Typical Value
Physical				
Density	ASTM D792	g/cm3		1.21
Melt Index	ASTM D1238	g/10min	1900℃×2.16kg 240℃×5kg	6.9 6.9
Mold Shrinkage	ASTM D955	%		0.5~0.7
Mechanical				
Tensile Strength	ASTM D638	MPa		70
Tensile Elongation at Break	ASTM D638	%		8
Flexural Strength	ASTM D790	MPa		75
Flexural Modulus	ASTM D790	MPa		3200
Notched Izod Impact,3.2mm	ASTM D256	J/m	3.2mm,Notched	30
Thermal				
Heat Deflection Temp. 1.82MPa Unannealed	ASTM D648	℃	1.82MPa	64.5
VICAT	ASTM D1525	℃	B	67.5
Flammability				
Flammability	UL-94	Class	1.6mm	HB
Electrical Properties				
Volume Resistivity	IEC 60093	Ohm-cm	/	> 1.0E+15
Surface Resistivity	IEC 60093	Ohm	/	> 1.0E+15

Note: 1) These are typical property values, not specifications.

2) In case of colored products, the values could vary slightly by color.

3) Values are measured at 23℃ and in RH of 50% on injection molded specimens.

4) UL File No. E65424(CSA File No. LS 66457)

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Processing Parameters	Typical Value	Unit
Drying Temperature	80~90	℃
Drying Time	3~4	hour
Maximum moisture content	0.02	%
Barrel Temperature		
Rear	190~200	℃
Middle	210~220	℃
Front	220~230	℃
Nozzle	215~225	℃
Melt Temperature	220~230	℃
Mold Temperature	60~80	℃
Back Pressure	1~5	MPa
Screw Speed	30~60	rpm

Note:

1)The above data is only for reference. Exact settings have to follow the product,injection machine and mold.

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