



Technical Data Sheet

PMMA/ASA WS4000U BK02

JL/SJ-17

FEATURES	APPLICATIONS
<ul style="list-style-type: none"> • Good surface Appearance • Good Weather Resistance 	<ul style="list-style-type: none"> • Automotive Parts • Injection Molding

Properties	Test Standard	Test Condition	S.I.Unit	Typical Values
MECHANICAL PROPERTIES				
Tensile Stress at break	ISO 527-2	50mm/min	Mpa	55
Flexural Stress	ISO 178	2mm/min	Mpa	75
Flexural Modulus	ISO 178	2mm/min	Mpa	2300
Izod Impact Strength Notched	ISO 180	23℃	KJ/m ²	5.5
THERMAL PROPERTIES				
Heat Deflection Temperature 1.8MPa	ISO 75	4mm	℃	80
Vicat Softening Temperature	ISO 306	50℃/hr, 5kg	℃	95
Others				
Density	ISO 1183	23℃	g/cm ³	1.15
Ash Content	ISO 3451/1	600℃	%	--
Melt Flow Index	ISO 1133	220℃, 10KG	g/10min	2.5
Linear Molding Shrinkage	ISO294-4	23℃	%	0.4-0.6
Fire Resistance UL94	UL94	1.5mm	--	HB

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

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

NOTICE:

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TYPICAL PROCESSING CONDITIONS

Item	Optimum	Range
Melt Temperature	250	240-260
Barrel Zone Temperature	Rear	250
	Center	240
	Front	230
Mold Temperature	60	40-100
Processing Temperature Upper Limit	300	
Injection Speed	Medium or high	
Drying Temperature/Time	90°C, 4hr	

The parameter is just for referential purpose only. In actual processing, the parameter should be adjusted by construction of mold, shape and size of product, and so on.

SAFETY AND HANDLING CONSIDERATIONS

Material safety data sheets (MSDS) for resins are available from Hongfeng plastic industry. Co. Ltd. and its subsidiaries. MSDS sheets are provided to help customers satisfy their own handling, safety, disposal needs, and those that may be required by locally applicable health and safety regulations. The following comments are general and applied only to resins as supplied. Various additives and processing aids used in fabrication and other materials used in finishing steps have their own safe use profile and must be investigated separately.

These resins have a very low degree of toxicity under normal conditions of use and should pose no unusual problems from ingestion, eye, or skin contact. However, caution is advised when handling, storing, using, or disposing of these resins. Good housekeeping and controlling of dusts are necessary for safe handling of product. Workers should be protected from the possibility of contact with molten resin during fabrication.

Handling and fabrication of plastic resins can result in the generation of vapors and dusts. Dusts resulting from sawing, filing, and sanding of plastic parts in post-molding operations may cause irritation to eyes and the upper respiratory tract. In dusty atmospheres, using an approved dust respirator is recommended.

Good general ventilation of the polymer processing area is recommended. Processing may release fumes which may include polymer fragments and other decomposition products. Fumes can be irritating. At temperatures exceeding melt temperature, polymer fragments can occur. Good general ventilation should be sufficient for most conditions. Local exhaust ventilation may be necessary for some operations. Use chemical splash goggles if there is a potential for exposure to particles which could cause injury to the eye. Use gloves with insulation for thermal protection. Color change of the product may be caused by UV exposure in general. So it is recommended that storage should keep in dry, cool place and avoid direct sunlight We encourage customers and potential users of our products to review their applications for such products from the standpoint of human health and environmental quality. To help ensure that our products are not used in ways for which they were not intended or tested, our personnel will assist customers in dealing with ecological and product safety considerations. Your sales representative can arrange the proper contacts.

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