



Document	ISO Datasheet
Description	PMMA
Grade	DAFNELOY DH
Code	
Application	Injection moulding

Toughened. Good mechanical characteristics.

Properties	Method	Unit	Value
<b>Physical</b>			
Melt Flow Rate (230°C - 3,80 Kg)	ISO 1133	g/10'	1,5
Density at 23°C	ISO 1183	g/cm <sup>3</sup>	1,16
Mould Shrinkage (%)	INTERNAL	%	0,4-0,7
Water absorption	ISO 62	%	0,35
<b>Thermal</b>			
Vicat A50	ISO 306	°C	110
Vicat B50	ISO 306	°C	95
HDT, A (1.80 MPa)	ISO 75/Af	°C	91
HDT, B (0.45 MPa)	ISO 75/Af	°C	97
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	1800
Flexural strength (23°C - 2 mm/min)	ISO 178	MPa	74
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	50
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	25
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	6
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m <sup>2</sup>	7
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	65
<b>Flammability</b>			
Glow Wire Flammability Index GWFI (2,0 mm)	IEC 60695-2-12	°C	650
Flammability class (1,6 mm)	UL94		HB
<b>Processing Conditions</b>			
Melt Temperature Range	ISO 294	°C	230-270
Mold Temperature Range	ISO 294	°C	60-90

Injection Velocity	ISO 294	MEDIUM
Drying Temperature		°C 80
Drying Time		Hour 3
<b>Regulations compliance</b>		
RoHS compliance status:	COMPLIANT	
EN71:		
UL listed file n°:		
Water contact approvals.		
Food contact status:		

§ Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 4.0 x 10.0 x 170 mm sample.

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