



Document	ISO Datasheet
Description	PMMA
Grade	DAFNELOY DA9
Code	
Application	Injection moulding

Low flow, high mechanical strength and light transmission.

Properties	Method	Unit	Value
<b>Physical</b>			
Melt Flow Rate (230°C - 3,80 Kg)	ISO 1133	g/10'	3,0
Density at 23°C	ISO 1183	g/cm <sup>3</sup>	1,16-1,18
Mould Shrinkage (%)	INTERNAL	%	0,4-0,7
Water absorption	ISO 62	%	0,30
<b>Thermal</b>			
Vicat A50	ISO 306	°C	112
Vicat B50	ISO 306	°C	103
HDT, A (1.80 MPa)	ISO 75/Af	°C	80
HDT, B (0.45 MPa)	ISO 75/Af	°C	95
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	3000
Flexural strength (23°C - 2 mm/min)	ISO 178	MPa	115
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	3100
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	70
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	>10
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	2,0
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m <sup>2</sup>	2,0
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	25
<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	220-260

Mold Temperature Range	ISO 294	°C	60-90
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	80
Drying Time		Hour	3

## Regulations compliance

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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### Sirmax s.p.a.

E.A.R. N° 91334  
P.IVA 00168180248  
sirmax@sirmax.com

### Group Headquarter:

Viale dell'Artigianato, 42  
35013 Cittadella (PD) – Italy  
Tel. +39 049 9441111 – Fax +39 049 9441112