

## Product Information

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### PLEXIGLAS® zk6HF Molding Compound

#### Product Profile:

PLEXIGLAS® zk6HF is an amorphous, impact-modified thermoplastic molding compound (PMMA-I).

Typical properties of impact-modified PLEXIGLAS® molding compounds are

- high weather resistance
- excellent transmission and clarity
- brilliant appearance
- the pleasant feel and sound of the moldings.

PLEXIGLAS® zk6HF is characterized by the following special properties:

- excellent break resistance and impact strength
- improved resistance to stress cracking
- very good flow.

#### Application:

Used for injection molding as well as for extruding sheets and profiles.

#### Examples:

applications involving thin walls and long flow paths, thin-walled components; items requiring accurate mold surface reproduction, such as very finely textured luminaire covers.

#### Processing:

PLEXIGLAS® zk6HF can be processed on machines with 3-zone general purpose screws for engineering thermoplastics.

#### Physical Form / Packaging:

PLEXIGLAS® zk HF molding compounds are supplied as pellets of uniform size in 25 kg polyethylene bags or in 500 kg boxes with PE lining; other packaging on request.

**Properties:**

	Parameter	Unit	Standard	PLEXIGLAS® zk6HF
<b>Mechanical Properties</b>				
Tensile Modulus	1 mm/min	MPa	ISO 527	1900
Yield Stress	50 mm/min	MPa	ISO 527	45
Yield Strain	50 mm/min	%	ISO 527	5
Nominal Strain @ Break		%	ISO 527	50
Charpy Impact Strength	23°C	kJ/m <sup>2</sup>	ISO 179/1eU	75
<b>Thermal Properties</b>				
Vicat Softening Temperature	B / 50	°C	ISO 306	94
Coeff. of Linear Therm. Expansion	0 – 50°C	E-5 /°K	ISO 11359	11
Fire Rating			DIN 4102	B2
Flammability UL 94	1.6 mm	Class	IEC 707	HB
<b>Rheological Properties</b>				
Melt Volume Rate, MVR	230°C / 3.8kg	cm <sup>3</sup> /10min	ISO 1133	4.2
<b>Optical Properties</b>				
Luminous transmittance	d=3 mm			
	D65	%	ISO 13468-2	91
Refractive Index			ISO 489	1.49
<b>Other Properties</b>				
Density		g/cm <sup>3</sup>	ISO 1183	1.16
Water Absorption in Water		%	ISO 62	1.8
Humidity Absorption	23°C / 50%	%	ISO 62	0.5
<b>Recommended Processing Conditions</b>				
Predrying Temperature		°C		max. 80
Predrying Time in Desiccant-Type Drier		h		2 – 3
Melt Temperature		°C		220 – 260
Mold Temperature (Injection Molding)		°C		50 – 70

All listed technical data are typical values intended for your guidance. They are given without obligation and do not constitute a materials specification.

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The Business Unit Performance Polymers of Evonik is a worldwide manufacturer of PMMA molding compounds sold under the PLEXIGLAS® trademark on the European, Asian, African and Australian Continent and under the trademark ACRYLITE® in the Americas.

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