

**Sumipex® HT084S - Sumipex® HT084S High impact injection molding acrylic**

Technical Data Sheet Properties

Physical Property	Value	Test Method
Melt Flow Rate @ 230°C - 3800g	2 g/10 min	ASTM D 1238
Vicat Softening Point	<= 203 °F	ASTM D 1525
Notched Izod Impact 0.125"	1.8 ft-lbs/in	ASTM D 256
Tensile Strength	8120 psi	ASTM D 638
HDT (264 psi) Annealed	201 °F	ASTM D 648
Flexural Modulus (psi)	363000 psi	ASTM D 790
Flexural Strength	13100 psi	ASTM D 790
Specific Gravity	1.17	ASTM D 792
Melt Flow Rate	1.9 g/10 min	ASTM D1238
Melt Flow	1.9 g/10 min	JIS K7210
Flame Rating	HB	UL 94

\* Data herein is typical and not to be construed as specifications.

Injection Molding Processing Guidelines

Setting	Value
Drying Temperature	158 - 176 °F
Mold Temperature	140 - 185 °F
Drying Time	4 - 6 Hours
Melt Temperature	410 - 473 °F

\* Desiccant type dryer required.

The information provided on this datasheet should only be used as a guideline. Actual lot to lot values will vary.

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