


PLEXIGLAS® Resist zk4HC

PMMA-I

Evonik Industries AG

Product Texts
Productprofil:

PLEXIGLAS® Resist zk4HC 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® Resist zk4HC is characterized by the following special properties:

- improved break resistance and impact strength
- best resistance to stress cracking of all impact-modified PLEXIGLAS molding compounds
- AMECA listing.

Application:

Used for extruding and coextruding sheets and profiles.

Example:

extruded/coextruded sheets and profiles for automotive bodies and the sanitaryware sector (bathtubs and shower trays) or crystal-clear luminaire covers for industrial plants that come into contact with aggressive media.

Processing:

PLEXIGLAS® Resist zk4HC can be processed on machines with 3-zone general purpose screws for engineering thermoplastics.

Physical Form / Packaging:

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

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1.1	cm ³ /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	3.8	kg	ISO 1133
Mechanical properties			
ISO Data			
Tensile Modulus	2900	MPa	ISO 527-1/-2
Yield stress	68	MPa	ISO 527-1/-2
Yield strain	4.5	%	ISO 527-1/-2
Nominal strain at break	17	%	ISO 527-1/-2
Charpy impact strength (+23°C)	25	kJ/m ²	ISO 179/1eU
Thermal properties			
ISO Data			
Glass transition temperature, 10°C/min	108	°C	ISO 11357-1/-2
Vicat softening temperature, 50°C/h 50N	102	°C	ISO 306
Coeff. of linear therm. expansion, parallel	80	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10

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Thickness tested	1.6	mm	IEC 60695-11-10
UL recognition	UL	-	-
Oxygen index	17.5	%	ISO 4589-1/-2

Electrical properties

	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.7	-	IEC 60250
Relative permittivity, 1MHz	2.9	-	IEC 60250
Dissipation factor, 100Hz	500	E-4	IEC 60250
Dissipation factor, 1MHz	300	E-4	IEC 60250
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	1E13	Ohm	IEC 60093

Other properties

	Value	Unit	Test Standard
ISO Data			
Water absorption	2	%	Sim. to ISO 62
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1180	kg/m³	ISO 1183

Material specific properties

	Value	Unit	Test Standard
ISO Data			
Luminous transmittance	92	%	ISO 13468-1, -2

Rheological calculation properties

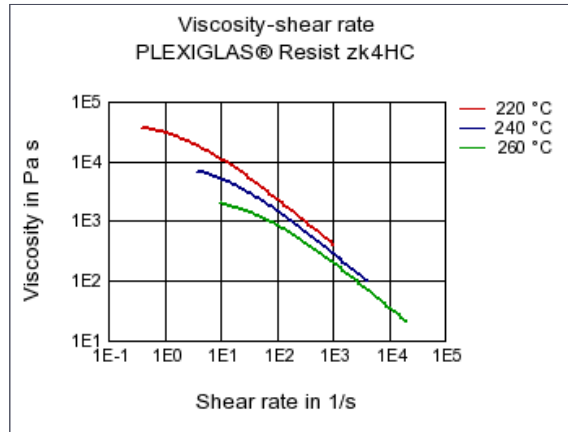
	Value	Unit	Test Standard
ISO Data			
Density of melt	1040	kg/m³	-
Thermal conductivity of melt	0.19	W/(m K)	-
Spec. heat capacity of melt	2440	J/(kg K)	-
Eff. thermal diffusivity	7.49E-8	m²/s	-
Ejection temperature	85	°C	-

Test specimen production

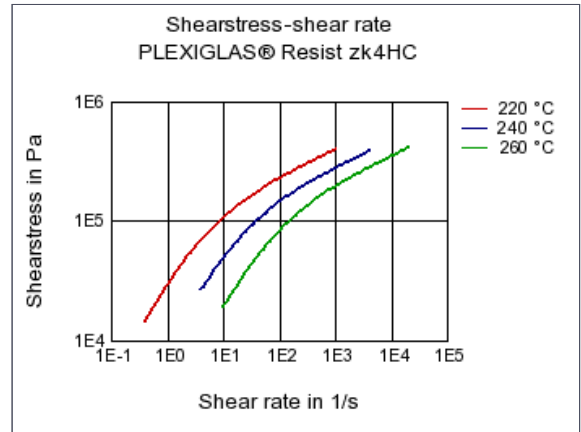
	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	62	°C	ISO 10724
Injection Molding, injection velocity	195	mm/s	ISO 294

Diagrams

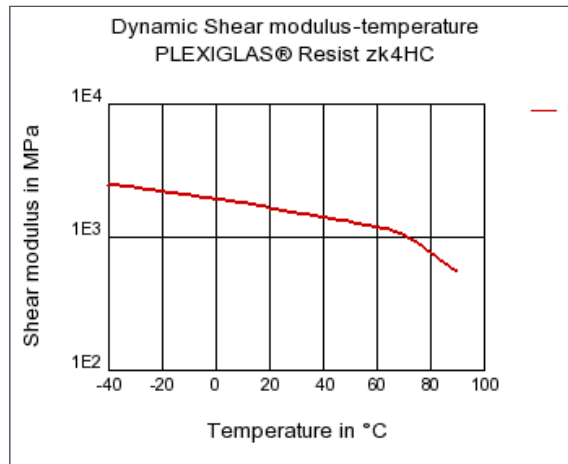
Viscosity-shear rate



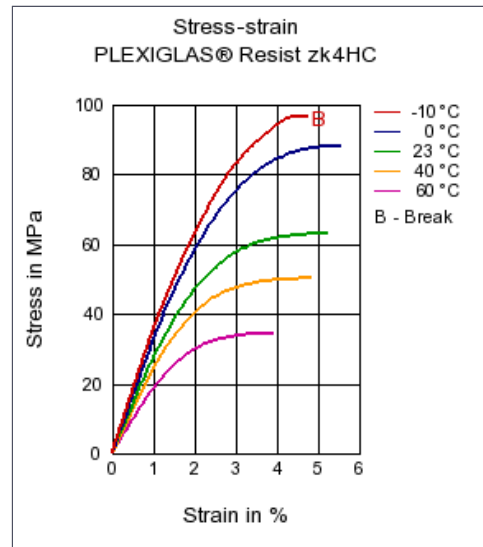
Shearstress-shear rate



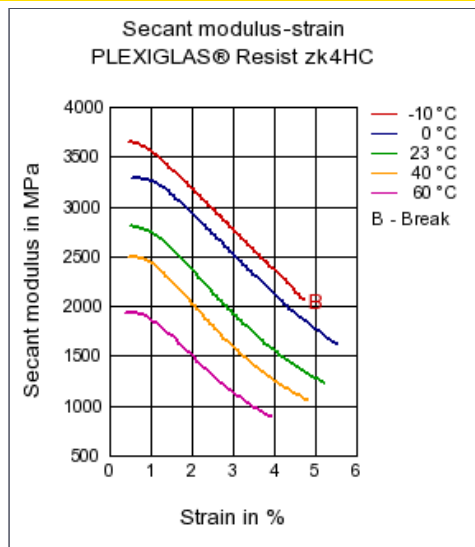
Dynamic Shear modulus-temperature



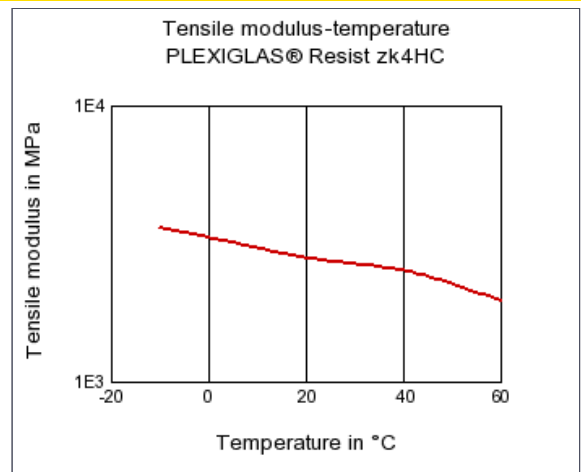
Stress-strain



Secant modulus-strain



Tensile modulus-temperature



Characteristics

PLEXIGLAS® Resist zk4HC	
PMMA-I	Evonik Industries AG
Processing	Additives
Film Extrusion, Profile Extrusion, Sheet Extrusion, Other Extrusion	Release agent
Delivery form	Special Characteristics
Pellets	High impact or impact modified, Light stabilized or stable to light, U.V. stabilized or stable to weather, Transparent
Other text information	
Profile extrusion	
PREPROCESSING	
Predrying temperature: max. 95 °C	
Predrying time in a desiccant-type drier: 2 - 3 h	
PROCESSING	
Melt temperature: 220 - 260 °C	
Die temperature: 220 - 260 °C	
Sheet extrusion	
PREPROCESSING	
Predrying temperature: max. 95 °C	
Predrying time in a desiccant-type drier: 2 - 3 h	
PROCESSING	
Melt temperature: 220 - 260 °C	
Die temperature: 220 - 260 °C	
Chemical Media Resistance	
Acids	
☺	Acetic Acid (5% by mass) (23°C)
☺	Citric Acid solution (10% by mass) (23°C)
☺	Lactic Acid (10% by mass) (23°C)
☺	Hydrochloric Acid (36% by mass) (23°C)
☺	Sulfuric Acid (38% by mass) (23°C)
☺	Sulfuric Acid (5% by mass) (23°C)
Bases	
☺	Sodium Hydroxide solution (35% by mass) (23°C)
☺	Sodium Hydroxide solution (1% by mass) (23°C)
☺	Ammonium Hydroxide solution (10% by mass) (23°C)
Hydrocarbons	
☺	n-Hexane (23°C)
☺	iso-Octane (23°C)
Mineral oils	
☺	SAE 10W40 multigrade motor oil (23°C)
Standard Fuels	
☺	Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23°C)
☺	Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23°C)
Salt solutions	
☺	Sodium Carbonate solution (20% by mass) (23°C)
☺	Sodium Carbonate solution (2% by mass) (23°C)
Other	
☺	50% Oleic acid + 50% Olive Oil (23°C)
☺	Water (23°C)