

# LUCITE® DIAKON®

## Acrylic Bead Polymer Lucite® Diakon® LH752

technical data sheet

PROPERTY	TEST METHOD	UNITS	VALUE
<b>THERMAL</b>			
Melt Flow Index	ISO 1133	gms/10mins	1.6
Vicat Softening Point	ISO 306A	°C	110
	ISO 306B	°C	104
Heat Deflection Temperature	ISO 75A	°C	97
	ISO 75B	°C	101
Coefficient of Expansion	ASTM E831	cm/cm/°C x 10 <sup>-5</sup>	7.1
<b>OPTICAL</b>			
Light Transmission	ASTM D1003	%	92
Haze	ASTM D1003	%	0.4
Refractive Index	ISO 489	-	1.49
<b>MECHANICAL</b>			
Tensile Strength	ISO 527	MPa	83
Elongation	ISO 527	%	5
Flexural Modulus	ISO 178	GPa	3.2
Flexural Strength	ISO 178	MPa	115
Izod Impact Strength	ISO 180/1A	kJ/m <sup>2</sup>	1.9
Charpy Impact Strength	ISO 179/1eA	kJ/m <sup>2</sup>	2.0
	ISO 179/1eU	kJ/m <sup>2</sup>	20
<b>GENERAL</b>			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	92
Mould Shrinkage	-	%	0.4-0.7
Water Absorption	ISO 62	%	0.30
Flammability	UL94	-	HB
Glow Wire Test	IEC 695-2-1	°C	650
Weight Average Particle Size	Sieve Test	microns	600

The above data represents typical results obtained using standard test pieces, it should not form the basis of specifications.

Information contained in this publication (and otherwise supplied to users) is based on our general experience and is given in good faith, but we are unable to guarantee its accuracy or to accept responsibility in respect of factors outside our knowledge or control. Freedom under patent, copyright and registered designs cannot be assumed.

Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet

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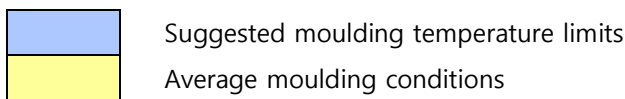
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 The source of inspiration

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## Suggested temperature profile for Injection Moulding

### Lucite® Diakon® LH752

°C	FEED THROAT	REAR ZONE	CENTRE ZONE	FRONT ZONE	NOZZLE	MOULD
300						
290						
280				Blue		
270				Blue	Blue	
260			Blue	Blue	Blue	
250			Blue	Yellow	Blue	
240			Yellow	Blue	Yellow	
230		Blue	Blue	Blue	Blue	
220		Blue	Blue			
210		Yellow				
200		Blue				
190		Blue				
180						
170						
160						
150						
100						
90						
80						Blue
70	Blue					Yellow
60	Yellow					Blue
50	Blue					Blue
40						
30						



### Drying

Drying should not be necessary, material can be moulded as supplied.