Lucite International

Your unique partner for
tailor made PMMA solutions

Toughened Acrylic Polymer Lucite® Diakon® CRG812

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	1.8
Vicat Softening Point	ISO 306A	ºC	110
	ISO 306B	ºC	95
Heat Deflection Temperature	ISO 75A	ºC	93
Coefficient of Expansion	ASTM E831	cm/cm/ºC x 10-5	11
OPTICAL			
Light Transmission	ASTM D1003	%	90
Haze	ASTM D1003	%	2.8
Refractive Index	ISO 489	-	1.49
MECHANICAL			
Tensile Strength Elongation Flexural	ISO 527	MPa	50
Modulus Flexural Strength	ISO 527	%	25
Izod Impact Strength	ISO 178	GPa	2.0
Charpy Impact Strength	ISO 178	MPa	70
	ISO 180/1A	kJ/m ²	6.0
	ISO 179/1eA	kJ/m ²	6.5
	ISO 179/1eU	kJ/m ²	65
GENERAL			
Relative Density	ISO 1183	-	1.16
Rockwell Hardness	ISO 2039-2	M Scale	54
Mould Shrinkage	-	%	0.4-0.7
Water Absorption	ISO 62	%	0.35
Flammability	UL94	-	HB
Glow Wire Test	IEC 695-2-1	ºC	650

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.

Contact : rozenburg@lucite.com, +31 (0) 181 233 233, lucitediakon.com

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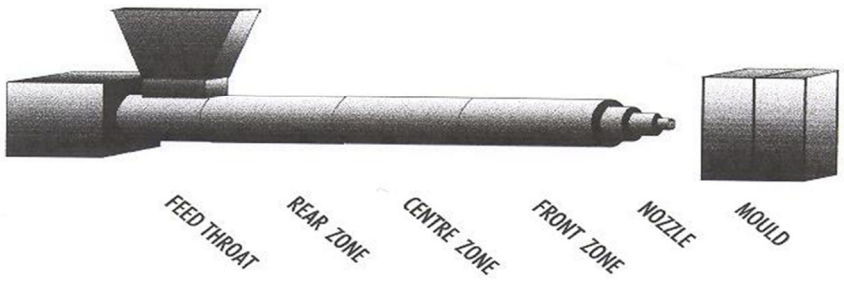
Suggested temperature profile for Injection Moulding Lucite® Diakon® CRG812

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



Suggested moulding temperature limits

Average moulding conditions

Drying Conditions

The material should be dried in an air circulating oven or a continuous hot air dryer or ideally a dehumidified air dryer at 80°C for 3 to 4 hours.

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