

Acrylic Polymer Lucite® Diakon® Frost 952 51

PROPERTY	TEST METHOD	UNITS	VALUE
OPTICAL			
Light Transmission	ASTM D1003	%	74
Haze	ASTM D1003	%	66
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	1.3
Vicat Softening Point	ISO 306A	°C	109
	ISO 306B	°C	102
Heat Deflection Temperature	ISO 75A	°C	96
	ISO 75B	°C	100
MECHANICAL			
Tensile Strength	ISO 527	MPa	73
Elongation	ISO 527	%	4
Flexural Modulus	ISO 178	GPa	3.4
Flexural Strength	ISO 178	MPa	103
Izod Impact Strength	ISO 180/1A	kJ/m ²	1.6
Charpy Impact Strength	ISO 179/1eA	kJ/m ²	1.4
	ISO 179/1eU	kJ/m ²	10
GENERAL			
Relative Density	ISO 1183	-	1.19
Rockwell Hardness	ISO 2039-2	M Scale	94
Ball Indentation Hardness	ISO 2039-1	MPa	180
	(H 961/30)		
Water Absorption	ISO 62	%	0.30
Flammability	UL94	-	HB
Glow Wire Test	IEC 695-2-1	°C	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.

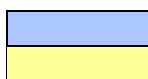
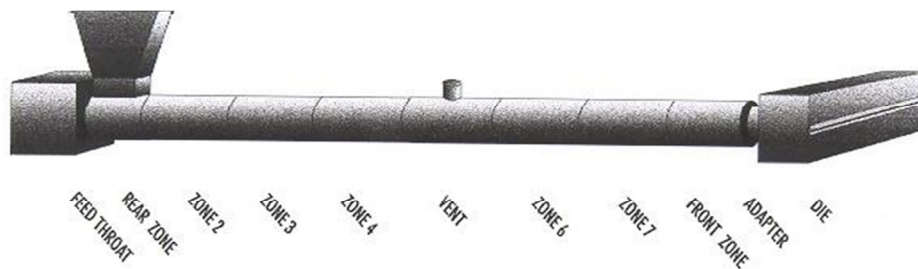
Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet

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DIAKON® ELVAKON® TUFLOAT® ACRYPET®

Suggested temperature profile for extruding Lucite® Diakon® Frost 952 51

°C	Feed Throat	Feed Zone	Zone 2	Zone 3	Zone 4	Vent Zone	Zone 6	Zone 7	Zone 8	Adapter	Die
300											
290											
280											
270											
260											
250											
240											
230											
220											
210											
200											
190											
180											
170											
160											
150											
90											
80											
70											
60											
50											
40											



Suggested extrusion temperature limits
 Average extrusion temperatures

Drying Conditions

The material may be extruded without pre-drying using a well designed, vented extruder. The material will require pre-drying on a non-vented extruder. It is recommended using a dehumidified air dryer at 80°C for 3 to 4 hours.