

## Acrylic Bead Polymer Lucite® Diakon® LG156

PROPERTY	TEST METHOD	UNITS	VALUE
<b>THERMAL</b>			
Melt Flow Index	ISO 1133	gms/10mins	16
Vicat Softening Point	ISO 306A	°C	98
	ISO 306B	°C	93
Heat Deflection Temperature	ISO 75A	°C	88
	ISO 75B	°C	91
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	75
Elongation	ISO 527	%	4
Flexural Modulus	ISO 178	GPa	2.9
Flexural Strength	ISO 178	MPa	105
Izod Impact Strength	ISO 180/1A	kJ/m <sup>2</sup>	1.7
Charpy Impact Strength	ISO 179/1eA	kJ/m <sup>2</sup>	2.0
	ISO 179/1eU	kJ/m <sup>2</sup>	18
<b>GENERAL</b>			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	85
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

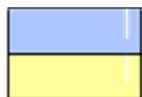
The above data represents typical results obtained using standard test pieces, it should not form the basis of specifications. Information contained in this publication (and otherwise supplied to users) is based on our general experience and is given in good faith, but we are unable to guarantee its 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  
Lucite and Diakon are registered trademarks of the Lucite International group of companies

**DIAKON® ELVAKON® TUFLOAT® ACRYPET®**

**Suggested temperature profile for Injection Moulding Lucite® Diakon® LG156**

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



Suggested moulding temperature limits

Average moulding conditions

Screw speed

80 - 100 rpm

Back pressure

8 - 12 bar

These processing parameters should only be used as a guide, part geometry, thickness, processing temperatures and rates will affect final cycle conditions

**DIAKON® ELVAKON® TUFLOAT® ACRYPET®**

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