

Acrylic Bead Polymer Lucite® Diakon® MG100

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	4.8
Vicat Softening Point	ISO 306A	°C	113
	ISO 306B	°C	106
Heat Deflection Temperature	ISO 75A	°C	99
	ISO 75B	°C	102
Coefficient of Expansion	ASTM E831	cm/cm/°C x 10 ⁻⁵	7.1
OPTICAL			
Light Transmission	ASTM D1003	%	92
Haze	ASTM D1003	%	0.4
Refractive Index	ISO 489	-	1.49
MECHANICAL			
Tensile Strength	ISO 527	MPa	80
Elongation Flexural	ISO 527	%	5
Modulus Flexural	ISO 178	GPa	3.2
Strength	ISO 178	MPa	110
Izod Impact Strength	ISO 180/1A	kJ/m ²	1.8
Charpy Impact Strength	ISO 179/1eA	kJ/m ²	2.0
	ISO 179/1eU	kJ/m ²	18
GENERAL			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	98
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	230

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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Suggested temperature profile for Injection Moulding Lucite® Diakon® MG100

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



 Suggested moulding temperature limits
 Average moulding conditions

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

DIAKON® ELVAKON® TUFLOAT® ACRYPET®

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