

Acrylic Bead Polymer Lucite® Diakon® MH254

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	0.8
Vicat Softening Point	ISO 306A	°C	117
	ISO 306B	°C	109
Heat Deflection Temperature	ISO 75A	°C	102
	ISO 75B	°C	106
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	85
Elongation Flexural	ISO 527	%	5
Modulus Flexural	ISO 178	GPa	3.4
Strength	ISO 178	MPa	120
Izod Impact Strength	ISO 180/1A	kJ/m ²	2.2
Charpy Impact Strength	ISO 179/1eA	kJ/m ²	2.2
	ISO 179/1eU	kJ/m ²	26
GENERAL			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	99
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

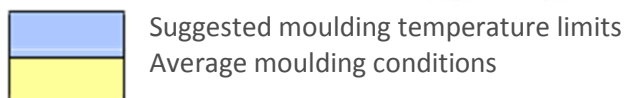
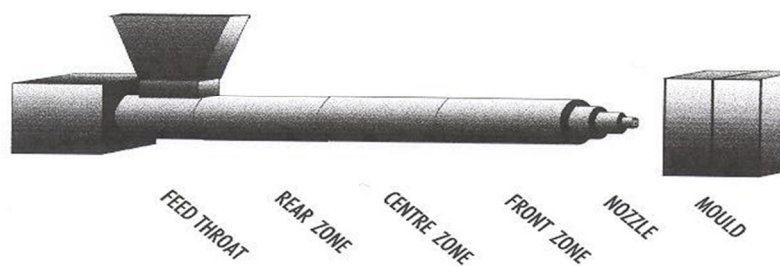
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Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet

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Suggested temperature profile for Injection Moulding Lucite® Diakon® MH254

°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.