

Acrylic Polymer Lucite® Diakon® Rapide CLG910B

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	6
Vicat Softening Point	ISO 306A	°C	112
	ISO 306B	°C	105
Heat Deflection Temperature	ISO 75A	°C	101
	ISO 75B	°C	104
Coefficient of Expansion	ASTM E831	cm/cm/°C x 10-5	7.1
OPTICAL			
Light Transmission	ASTM D1003	%	92
Haze	ASTM D1003	%	0.5
Refractive Index	ISO 489	-	1.49
MECHANICAL			
Tensile Strength	ISO 527	MPa	66
Elongation	ISO 527	% GPa	3.1
Flexural	ISO 178	MPa	3.1
Modulus	ISO 178	kJ/m ²	61
Flexural Strength	ISO 179/1eU		19
Charpy Impact Strength			
GENERAL			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	96
Mould Shrinkage	-	%	0.4-0.7
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.

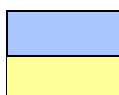
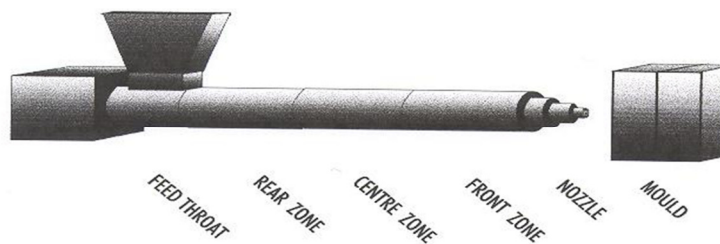
Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet

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Suggested temperature profile for Injection Moulding Lucite® Diakon® Rapide CLG910B

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



■ Suggested moulding temperature limits
■ Average moulding conditions

Drying Conditions

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

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