

Acrylic Polymer Lucite® Diakon® ST15G6

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	13
Vicat Softening Point	ISO 306A	°C	97
	ISO 306B	°C	91
Heat Deflection Temperature	ISO 75A	°C	88
Coefficient of Expansion	ASTM E831	cm/cm/°C x 10 ⁻⁵	8
OPTICAL			
Light Transmission	ASTM D1003	%	91.5
Haze	ASTM D1003	%	1
Refractive Index	ISO 489	-	1.49
MECHANICAL			
Tensile Strength	ISO 527	MPa	70
Elongation	ISO 527	%	6
Flexural Modulus	ISO 178	GPa	2.4
Flexural Strength	ISO 178	MPa	85
Izod Impact Strength	ISO 180/1A ISO 179/1eA ISO	kJ/m ²	2.1
Charpy Impact Strength	179/1eU	kJ/m ²	2.1
GENERAL			
Relative Density	ISO 1183	-	1.18
Rockwell Hardness	ISO 2039-2	M Scale	78
Mould Shrinkage	-	%	0.4-0.7
Water Absorption	ISO 62	%	0.3
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.

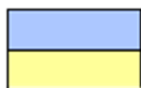
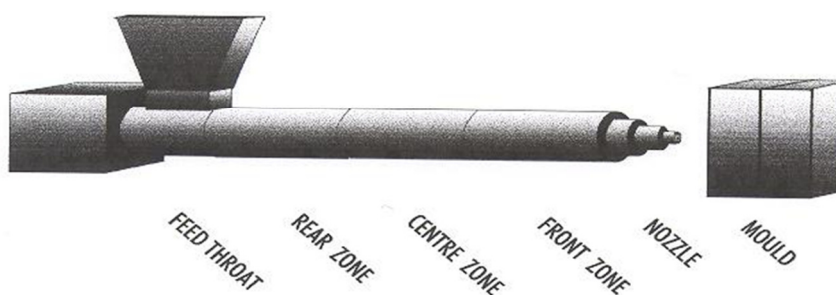
Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet

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Suggested temperature profile for Injection Moulding ST15G6

°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	Blue	Blue	
230		Blue	Blue	Blue/Yellow	Blue	
220		Blue	Blue/Yellow	Blue	Blue/Yellow	
210		Blue/Yellow	Blue	Blue	Blue	
200		Blue	Blue			
190		Blue				
180		Blue				
170						
160						
150						
100						
90	Blue					
80	Blue					
70	Blue					Blue
60	Blue/Yellow					Blue/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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