

Toughened Acrylic Polymer Lucite® Diakon® ST35G6

PROPERTY	TEST METHOD	UNITS	VALUE
THERMAL			
Melt Flow Index	ISO 1133	gms/10mins	5.7
Vicat Softening Point	ISO 306A	°C	95
	ISO 306B	°C	85
Heat Deflection Temperature	ISO 75A	°C	85
Coefficient of Expansion	ASTM E831	cm/cm/°C x 10 ⁻⁵	11
OPTICAL			
Light Transmission	ASTM D1003	%	90
Haze	ASTM D1003	%	3
Refractive Index	ISO 489	-	1.49
MECHANICAL			
Tensile Strength	ISO 527	MPa	47
Elongation	ISO 527	%	25
Flexural modulus	ISO 178	GPa	1.9
Flexural Strength	ISO 178	MPa	65
Izod Impact Strength	ISO 180/1A	kJ/m ²	5.8
Charpy Impact Strength	ISO 179/1eA	kJ/m ²	5.6
	ISO 179/1eU	kJ/m ²	58
GENERAL			
Relative Density	ISO 1183	-	1.16
Rockwell Hardness	ISO 2039-2	M Scale	44
Mould Shrinkage	-	%	0.4-0.7
Water Absorption	ISO 62	%	0.35
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.

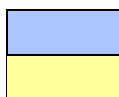
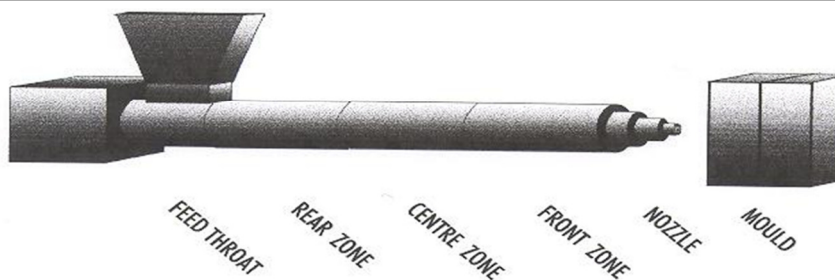
Users of Lucite Diakon polymer should consult the relevant Material Safety Data Sheet.

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Suggested temperature profile for Injection Moulding Lucite® Diakon® ST35G6

°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	Yellow	Blue	
220		Blue	Yellow	Blue	Yellow	
210		Yellow	Blue	Blue	Blue	
200		Blue	Blue			
190		Blue				
180						
170						
160						
150						
100						
90						
80						
70	Blue					Blue
60	Yellow					Blue
50	Blue					Yellow
40						Blue
30						



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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