

ASTAGLAS™ V825

Polymethyl Methacrylate Acrylic
Marplex Australia Pty. Ltd.

Message:

ASTAGLAS™ V825 is a transparent high heat resistance moulding grade of Poly(Methyl Methacrylate). Typical applications require heat resistance and moulded component strength such as automotive tail lights and instrument panel gauge lenses.

General Information			
Features	Good Toughness		
	High Heat Resistance		
	High Impact Resistance		
Uses	Automotive Applications		
	Lenses		
Appearance	Clear/Transparent		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.7	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	93		
R-Scale	124		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	3250	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	70.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	3100	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	103	MPa	ASTM D790
Compressive Strength (6.40 mm)	108	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁶ (1.8 MPa, Annealed, 3.20 mm)	102	°C	ASTM D648
Vicat Softening Temperature	112	°C	ASTM D1525 ⁷
CLTE - Flow	6.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94

Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		ASTM D542
Transmittance (Total, 3200 μm)	92.0	%	ASTM D1003
Haze (3200 μm)	< 2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 240	°C	
Processing (Melt) Temp	230 to 250	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 130	MPa	
Injection Rate	Slow-Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	5.0 to 9.0	kN/cm ²	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	5.0 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	Annealed 4 hr at 95°C		
7.	Loading 1 (10 N)		

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