

Diakon® CLG356L

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® CLG356L is a Polymethyl Methacrylate Acrylic material. It is available in Europe for injection molding. Primary attribute of Diakon® CLG356L: Flame Rated.

General Information			
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	15	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ISO 2039-2
Ball Indentation Hardness (H 961/30)	175	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	75.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	%	ISO 527-2
Flexural Modulus	2900	MPa	ISO 178
Flexural Stress	105	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	18	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	1.7	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	91.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	88.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	98.0	°C	ISO 306/A
--	93.0	°C	ISO 306/B
CLTE - Flow	7.1E-5	cm/cm/°C	ASTM E831
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Glow Wire Ignition Temperature	650	°C	IEC 60695-2-13
Optical	Nominal Value	Unit	Test Method

Refractive Index	1.490		ISO 489
Transmittance	92.0	%	ASTM D1003
Haze	0.40	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 to 4.0	hr	
Hopper Temperature	50.0 to 80.0	°C	
Rear Temperature	180 to 230	°C	
Middle Temperature	210 to 260	°C	
Front Temperature	210 to 270	°C	
Nozzle Temperature	210 to 260	°C	
Mold Temperature	50.0 to 70.0	°C	

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