

# Acrigel® LFP100

Polymethyl Methacrylate Acrylic

Unigel Plásticos

## Message:

Medium flow rate, good thermal resistance and good balance stiffness/impact.

Applications:

Appliances

Technical parts

| General Information                                              |                         |                   |                         |
|------------------------------------------------------------------|-------------------------|-------------------|-------------------------|
| Features                                                         | Good Impact Resistance  |                   |                         |
|                                                                  | Good Stiffness          |                   |                         |
|                                                                  | High Flow               |                   |                         |
|                                                                  | Medium Heat Resistance  |                   |                         |
| Uses                                                             | Appliances              |                   |                         |
|                                                                  | Engineered Applications |                   |                         |
| Processing Method                                                | Injection Molding       |                   |                         |
| Physical                                                         | Nominal Value           | Unit              | Test Method             |
| Specific Gravity                                                 | 1.19                    | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)                         | 7.5                     | g/10 min          | ASTM D1238              |
| Molding Shrinkage - Flow                                         | 0.30 to 0.60            | %                 | ASTM D955               |
| Hardness                                                         | Nominal Value           | Unit              | Test Method             |
| Rockwell Hardness (M-Scale)                                      | 94                      |                   | ASTM D785               |
| Mechanical                                                       | Nominal Value           | Unit              | Test Method             |
| Tensile Strength (Break)                                         | 68.0                    | MPa               | ASTM D638               |
| Tensile Elongation (Break)                                       | 3.0                     | %                 | ASTM D638               |
| Impact                                                           | Nominal Value           | Unit              | Test Method             |
| Notched Izod Impact (23°C, 3.20 mm)                              | 14                      | J/m               | ASTM D256               |
| Thermal                                                          | Nominal Value           | Unit              | Test Method             |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm) | 94.0                    | °C                | ASTM D648               |
| Vicat Softening Temperature                                      |                         |                   |                         |
| --                                                               | 94.0                    | °C                | ASTM D1525 <sup>1</sup> |
| --                                                               | 102                     | °C                | ASTM D1525 <sup>2</sup> |
| Optical                                                          | Nominal Value           | Unit              | Test Method             |
| Refractive Index                                                 | 1.490                   |                   | ASTM D542               |
| Transmittance                                                    | 92.0                    | %                 | ASTM D1003              |
| Injection                                                        | Nominal Value           | Unit              |                         |
| Drying Temperature                                               | 85.0                    | °C                |                         |

|                    |      |    |
|--------------------|------|----|
| Drying Time        | 4.0  | hr |
| Rear Temperature   | 210  | °C |
| Middle Temperature | 220  | °C |
| Front Temperature  | 230  | °C |
| Nozzle Temperature | 225  | °C |
| Mold Temperature   | 60.0 | °C |

#### NOTE

1. Rate A (50°C/h), Loading 2 (50 N)
2. Rate B (120°C/h), Loading 1 (10 N)

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