# POLYCASA® ACRYL KR 2007/1

Polymethyl Methacrylate Acrylic

### Polycasa

### Message:

Polycasa Acryl is the trade name for thermoplastic moulding compounds from Polycasa. Polycasa Acryl is a highly transparent, amorphous thermoplastic based on polymethylmethacrylate (PMMA), whilst Polycasa Acryl KR products are high-impact modified products with a range of melt viscosities. CHARACTERISTICS Available in many transparent and opaque shades. Excellent transparency and brilliance. Unsurpassed resistance to ageing. High surface hardness. Scratch resistance. Good recyclability. High optical quality. Glass-clear appearance. Good outdoor performance. Meets all current European food contact legislation and can be used in contact with foodstuffs. APPLICATIONS Automotive. Building. Lighting. Food. Signs. Electrical. Sanitary. Marine. Medical.

General Information	
Additive	Impact Modifier
Features	Amorphous
	Food Contact Acceptable
	Good Weather Resistance
	High Clarity
	High Hardness
	High Impact Resistance
	High Scratch Resistance
	Impact Modified
	Opticals
	Outstanding Surface Finish
	Recyclable Material
Uses	Automotive Applications
	Building Materials
	Construction Applications
	Electrical/Electronic Applications
	Lighting Applications

Marine Applications

Medical/Healthcare Applications

#### Non-specific Food Applications

Sanitary Products

Appearance  Clear/Tansparent    Colors Available  Opaque    Processing Method  Bow Molding    Extrusion  Extrusion    injection Molding  Extrusion    Projectad  Mominal Value  Multi    Density  16  gram  Distance    Apparent Density  0.57  gram  Bord March    Molding  information  information  Bord March    Molding Strinkage  0.50 to 80  ref  Iso 1133    Molding Strinkage  Normal Value  Iso 1140  Iso 1133    Molding Strinkage  Normal Value  March 105 to 52.7  Iso 1133    Tensie Strain (Break)  So 20.7  Iso 1140  Iso 1147	Agency Ratings	EU Food Contact, Unspecified Ra	iting	
Processing MethodBlow Molding Costing Extusion injection MoldingPhysicalBlow Molding Extusion injection MoldingPhysicalNominal ValueUnitTest MethodDensity1.16g/cm³Dis 1383Apparent Density0.67g/cm³Dis 1346Apparent Density0.67g/cm³Dis 1346Mettr Absorption (Equilibrium, 23°C, 50% R1)3.0monitor MaterSo 1133Moding Shrinkage0.50 to 0.80%Test MethodMater Absorption (Equilibrium, 23°C, 50% R1)3.0%Test MethodMarker Absorption (Equilibrium, 23°C, 50%) R1)3.0%Test MethodMarker Absorption (Equilibrium, 23°C, 50%) R1)%%%%Marker Absorption (Equilibrium, 23°C, 50%) R1)%%%Marker Absorption (Equilibrium, 23°C, 5	Appearance	Clear/Transparent		
Processing Method  Blow Moding Costing    Projection Modeling  Costing    Projection Modeling  Extrusion Injection Modeling    Physical  Nominal Value  Unit  Test Method    Density  1.16  g/cm <sup>3</sup> 50.118.3    Apparent Density  0.67  g/cm <sup>3</sup> 50.118.3    Method Mume-How Rate (MVR) (20°C/R) Ry  1.20  cm <sup>3</sup> /10min  50.113.3    Molding Shrinkage  0.50 0.80  %		Colors Available		
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Apparent Density0.67g/cm³DIN 53466Melt Volume-Flow Rate (MVR) (230°C/38)1.20cm³/10minISO 1133Molding Shrinkage0.50 to 0.80%Water Absorption (Equilibrium, 23°C, 50%) RH)0.30%Test MethodBall Indentation Hardness (H 358/30)0.30MPa505 0239-1Ball Indentation Hardness (H 358/30)100MPa505 0239-1Tensile Modulus2000MPa505 527-2Tensile Modulus2000MPa505 527-2Tensile Stress (Break)50.0MPa505 527-2Tensile Stress (Break)30%505 527-2Tensile Stress (Break)0.90%505 527-2ImpactNominal ValueUnitTest MethodMaximum Service Temperature short Cycle operation%505 72-2ImpactNominal ValueUnitTest MethodCharpy Unotched Impact Strength (23°C)60K/m²50 179-12TermalNominal ValueUnitTest MethodCharpy Unotched Impact Strength (23°C)60K/m²5	Physical	Nominal Value	Unit	Test Method
Alt Volume-Flow Rate (MVR) (230°C/3 %  1.20  cm²/10min  ISO 1133    Molding Shrinkage  0.50 to 0.80  %     Water Absorption (Equilibrium, 23°C, 50%)  0.30  %     Hardness  Nominal Value  Unit  Test Method    Ball Indentation Hardness (H 358/30)  100  MPa  150 2039-1    Mechanical  Nominal Value  Unit  Test Method    Tensile Modulus  200  MPa  150 527-2    Tensile Stress (Break)  30.0  %  150 527-2    Tensile Stress (Break)  30.0  MPa  150 527-2    Tensile Stress (Break)  82.0  MPa  150 527-2    Tensile Stress (Break)  0.0  MPa  150 178    Water Vapor Permeability  0.9  Morinal Value  Inter Method    Maximum Service Temperature - short  50  160  170    Charpy Unnotched Impact Strength (23°C)  60  Int  Test Method    Charpy Unnotched Impact Strength (23°C)  60.0  Int  Test Method    Theread	Density	1.16	g/cm³	ISO 1183
kg)1.20cm³/0minISO 1133Moding Shrinkage5.05 0.80%Water Absorption (Equilibriur, 23° C, SW3.03%HardnessSo.03%HardnessNominal ValueNuBall Indentation Hardness (H S5A)10MaMohandatoNominal ValueNuTensle Modulus200MaTensle Strass (Break)0.01MaBaltandention Bardness3.03MaTensle Strass (Break)0.01MaMominal ManageMaSo 27-2Tensle Strass (Break)0.01MaMominal ManageMaSo 27-2Tensle Strass (Break)0.01MaMardnessSo 20-2MaMardnessSo 20-2So 20-2Tensle Strass (Break)0.01MaMardnessSo 20-2So 20-2FilmaNominal ValueMaMardness (Break)So 30-2So 20-2Mardness (Break)So 30-2So 20-2Mardness (Break)So 30-2So 20-2Mardness (Break)So 30-2So 30-2Mardness	Apparent Density	0.67	g/cm³	DIN 53466
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Water Absorption (Equilibrium, 23°C, 50%)  0.30  %    Hardness  Nominal Value  Unit  Test Method    Ball Indentation Hardness (H 358/30)  100  MPa  ISO 2039-1    Mechanical  Nominal Value  Unit  Test Method    Tensile Modulus  2000  MPa  ISO 527-2    Tensile Stress (Break)  50.0  MPa  ISO 527-2    Tensile Stress (Break)  82.0  MPa  ISO 527-2    Flexural Stress  82.0  MPa  ISO 527-2    Flims  Nominal Value  Unit  Test Method    Water Vapor Permeability  0.90  gm²/24 hr  ISO 178    Maximum Service Temperature - short  go  °C  Image    Inpact  Nominal Value  Unit  Test Method    Charpy Notched Impact Strength (23°C)  4.0  N/m²  ISO 179/10    Charpy Notched Impact Strength (23°C)  60  M/m²  ISO 179/10    Charpy Ontched Impact Strength (23°C)  60  M/m²  ISO 179/10    Thermal  Nominal Value	-			150 1133
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Ball Indentation Hardness (H 358/30)  100  MPa  ISO 2039-1    Mechanical  Nominal Value  Unit  Test Method    Tensile Modulus  2200  MPa  ISO 527-2    Tensile Stress (Break)  50.0  MPa  ISO 527-2    Tensile Stress (Break)  30  MPa  ISO 527-2    Tensile Strain (Break)  30  ISO 527-2  ISO 527-2    Tensile Strain (Break)  Nominal Value  Unit  Test Method    Maximum Service Temperature - short cycle operation  90  "C  ISO 179/10    Inpact  Nominal Value  Unit  Test Method    Charpy Unotched Impact Strength (23°C)  60  KI/m <sup>2</sup> ISO 179/10    Heat Deflection Temperature (1.8 MP		0.30	%	
MechanicalNominal ValueUnitTest MethodTensile Modulus2200MPaISO 527-2Tensile Stress (Break)50.0MPaISO 527-2Tensile Strain (Break)30%ISO 527-2Tensile Strain (Break)82.0MPaISO 178FlimsNominal ValueUnitTest MethodWater Vapor Permeability0.90g/m²/24 hrDIN 53122Maximum Service Temperature - short cycle operation90°CScInpactNominal ValueUnitTest MethodCharpy Notched Impact Strength (23°C)4.0kl/m²ISO 179/1eUCharpy Unnotched Impact Strength (23°C)60VinitSo 179/1eUHeat Deflection Temperature (1.8 MPa, Unannealed)90.0°CISO 75-2/AfVicat Softening Temperature101°CISO 306/B50Lief Leflow (23 to 80°C)1.0E-4cm/cm/°CISO 306/B50	Hardness	Nominal Value	Unit	Test Method
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Tensile Stress (Break)50.0MPaISO 527-2Tensile Strain (Break)30%ISO 527-2Flexural Stress82.0MPaISO 178FlimsNominal ValueUnitTest MethodWater Vapor Permeability0.90g/m²/24 hrDIN 53122Maximum Service Temperature - short cycle operation90°CTest MethodImpactNominal ValueUnitTest MethodCharpy Notched Impact Strength (23°C)4.0K/m²ISO 179/1eCharpy Unnotched Impact Strength (23°C)60K/m²ISO 179/1eUThermalNominal ValueUnitTest MethodHeat Deflection Temperature (18 MPA, Unannealed)90.0°CSio 75-2/AfVicat Softening Temperature101°CSio 306/B50Vicat Softening Temperature10E-4mrcm/°CDIN 53752	Mechanical	Nominal Value	Unit	Test Method
Tensile Strain (Break)30% 0ISO 527-2Flexural Stress82.0MPaISO 178FlimsNominal ValueUnitTest MethodWater Vapor Permeability0.90g/m²/24 hrDIN 53122Maximum Service Temperature - short cycle operation90cSin 2000ImpactNominal ValueUnitTest MethodCharpy Notched Impact Strength (23°C)4.0K/m²ISO 179/1eCharpy Unnotched Impact Strength (23°C)60k/m²ISO 179/1eUThermalNominal ValueUnitTest MethodHeat Deflection Temperature (1.8 MPa, Unannealed)9.0.0cISO 75-2/AfVicat Softening Temperature101°CISO 306/B50Vicat Softening Temperature10.1Si 0.3 06/B50ISO 306/B50Vicat Softening Temperature1.0E-4mrcm/°CDIN 53752	Tensile Modulus	2200	MPa	ISO 527-2
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FilmsNominal ValueUnitTest MethodWater Vapor Permeability0.90g/m²/24 hrDIN 53122Maximum Service Temperature - short cycle operation90°CStatestImpactNominal ValueUnitTest MethodCharpy Notched Impact Strength (23°C)4.0K/m²ISO 179/1eCharpy Unnotched Impact Strength (23°C)60K/m²ISO 179/1eUThermalNominal ValueUnitTest MethodHeat Deflection Temperature (1.8 MPa, Unannealed)9.0°CSo 75-2/AfVicat Softening Temperature101°CISO 306/BS0Vicat Softening Temperature1.0E-4m/cmcm°CDIN 53752	Tensile Strain (Break)	30	%	ISO 527-2
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Maximum Service Temperature - short cycle operation90cImpactNominal ValueUnitTest MethodCharpy Notched Impact Strength (23°C)4.0k/m²ISO 179/1eCharpy Unnotched Impact Strength (23°C)60k/m²ISO 179/1eUThermalNominal ValueUnitTest MethodHeat Deflection Temperature (1.8 MPa, Unannealed)90.0cISO 75-2/AfVicat Softening Temperature101°CISO 306/B50LTE - Flow (23 to 80°C)1.0E-4cm/cm/°CDIN 53752	Films	Nominal Value	Unit	Test Method
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Charpy Notched Impact Strength (23°C)4.0kJ/m²ISO 179/1eCharpy Unnotched Impact Strength (23°C)60kJ/m²ISO 179/1eUThermalNominal ValueUnitTest MethodHeat Deflection Temperature (1.8 MPa, Unannealed)90.0°CISO 75-2/AfVicat Softening Temperature101°CISO 306/B50CLTE - Flow (23 to 80°C)1.0E-4cm/cm/°CDIN 53752	-	90	°C	
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ThermalNominal ValueUnitTest MethodHeat Deflection Temperature (1.8 MPa, Unannealed)90.0°CISO 75-2/AfVicat Softening Temperature101°CISO 306/B50CLTE - Flow (23 to 80°C)1.0E-4cm/cm/°CDIN 53752	Charpy Notched Impact Strength (23°C)	4.0	kJ/m²	ISO 179/1e
Heat Deflection Temperature (1.8 MPa, Unannealed)90.0°CISO 75-2/AfVicat Softening Temperature101°CISO 306/B50CLTE - Flow (23 to 80°C)1.0E-4cm/cm/°CDIN 53752	Charpy Unnotched Impact Strength (23°C)	60	kJ/m²	ISO 179/1eU
Unannealed)  90.0  °C  ISO 75-2/Af    Vicat Softening Temperature  101  °C  ISO 306/B50    CLTE - Flow (23 to 80°C)  1.0E-4  cm/cm/°C  DIN 53752	Thermal	Nominal Value	Unit	Test Method
CLTE - Flow (23 to 80°C)  1.0E-4  cm/cm/°C  DIN 53752		90.0	°C	ISO 75-2/Af
	Vicat Softening Temperature	101	°C	ISO 306/B50
Specific Heat 1500 J/kg/°C IEC 1006	CLTE - Flow (23 to 80°C)	1.0E-4	cm/cm/°C	DIN 53752
	Specific Heat	1500	J/kg/°C	IEC 1006

Thermal Conductivity	0.18	W/m/K	DIN 52612
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Electric Strength <sup>1</sup>	60	kV/mm	IEC 60243-1
Dielectric Constant			IEC 60250
100 Hz	3.20		
1 MHz	2.90		
Dissipation Factor			IEC 60250
100 Hz	0.040		
1 MHz	0.030		
Comparative Tracking Index (Solution B)	600	V	IEC 60112
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.492		ISO 489
Transmittance (3000 µm)	90.0	%	DIN 5036-3
Haze	< 2.0	%	DIN 5036-3
Injection	Nominal Value	Unit	
Processing (Melt) Temp	210 to 250	°C	
Mold Temperature	50.0 to 70.0	°C	
Extrusion	Nominal Value	Unit	
Melt Temperature	180 to 250	°C	
NOTE			
NOTE			

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#### Recommended distributors for this material

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