

Diakon® CLH952L

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® CLH952L is a polymethyl methacrylate-acrylic material. This product is available in Europe and is processed by extrusion or injection molding. Diakon® The main characteristics of the CLH952L are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	1.7	g/10 min	ISO 1133
Molding Shrinkage	0.40 - 0.70	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	92		ISO 2039-2
Ball Indentation Hardness (H 961/30)	180	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	83.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2
Flexural Modulus	3200	MPa	ISO 178
Flexural Stress	115	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	20	kJ/m ²	ISO 179/1eU
Notched Izod Impact	1.9	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	101	°C	ISO 75-2/B
1.8 MPa, not annealed	97.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	109	°C	ISO 306/A
--	103	°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 Flammability Index	650	°C	IEC 60695-2-12

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 - 4.0	hr	
Hopper Temperature	50.0 - 90.0	°C	
Rear Temperature	200 - 240	°C	
Middle Temperature	210 - 260	°C	
Front Temperature	210 - 270	°C	
Nozzle Temperature	220 - 260	°C	
Mold Temperature	50.0 - 80.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 - 4.0	hr	
Hopper Temperature	50.0 - 80.0	°C	
Cylinder Zone 1 Temp.	160 - 240	°C	
Cylinder Zone 2 Temp.	180 - 250	°C	
Cylinder Zone 3 Temp.	200 - 250	°C	
Cylinder Zone 4 Temp.	220 - 260	°C	
Adapter Temperature	210 - 270	°C	
Die Temperature	210 - 270	°C	
Extrusion instructions			

Vent Zone Temperature: 220-270°C Zone 6 Temperature: 220-270°C Zone 7 Temperature: 210-270°C Zone 8 Temperature: 210-270°C

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