

Diakon® ST25G8

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® ST25G8 is a polymethyl methacrylate-acrylic material. This product is available in Europe and is processed by extrusion.

Diakon® The main features of ST25G8 are:

flame retardant/rated flame

Impact modification

Diakon® The typical application field of ST25G8 is: automobile industry

General Information			
UL YellowCard	E108947-218760		
Additive	Impact modifier		
Features	Impact modification		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	2.5	g/10 min	ISO 1133
Water Absorption (Equilibrium, 23°C, 50% RH)	0.32	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	71		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	63.0	MPa	ISO 527-2
Tensile Strain (Yield)	15	%	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Stress	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	3.9	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	42	kJ/m ²	ISO 179/1eU
Notched Izod Impact	3.6	kJ/m ²	ISO 180/1A
Multi-Axial Instrumented Impact Energy	1.50	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	95.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	111	°C	ISO 306/A
--	102	°C	ISO 306/B
CLTE - Flow	1.0E-4	cm/cm/°C	ASTM D696
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	91.0	%	ASTM D1003
Haze	2.0	%	ASTM D1003

Additional Information

Mold Shrinkage, H961/30: .4 to .7%

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	3.0 - 4.0	hr
Hopper Temperature	50.0 - 80.0	°C
Rear Temperature	190 - 240	°C
Middle Temperature	210 - 260	°C
Front Temperature	210 - 280	°C
Nozzle Temperature	220 - 270	°C
Mold Temperature	50.0 - 80.0	°C

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