

Plexiglas® Granite

Polymethyl Methacrylate Acrylic

Altuglas International of Arkema Inc.

Message:

Plexiglas® Granite is a thermoplastic acrylic resin formulated for injection molding. It is characterized by its granite-like, multi-color appearance.

General Information			
UL YellowCard	E39437-231410		
Appearance	Multi-Colored		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.80	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	45		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1930	MPa	ASTM D638
Tensile Strength (Yield)	40.0	MPa	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	1930	MPa	ASTM D790
Flexural Strength (Yield)	60.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	37	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ¹			ASTM D648
0.45 MPa, Annealed	96.7	°C	
1.8 MPa, Annealed	80.0	°C	
Vicat Softening Temperature			
--	103	°C	ASTM D1525 ²
--	92.2	°C	ASTM D1525 ³
Thermal Conductivity	0.20	W/m/K	ASTM C177
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		Test Method
ASTM Classification	PMMA Unspecified		ASTM D788
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 87.8	°C	
Drying Time	4.0	hr	

Suggested Max Moisture	0.10	%
Suggested Shot Size	50	%
Suggested Max Regrind	20	%
Rear Temperature	227	°C
Middle Temperature	238	°C
Front Temperature	249	°C
Nozzle Temperature	249	°C
Processing (Melt) Temp	< 271	°C
Mold Temperature	93.3	°C
Injection Rate	Slow	
Back Pressure	0.00	MPa
Screw Speed	50 to 100	rpm
Screw L/D Ratio	15.0:1.0 to 20.0:1.0	
Screw Compression Ratio	2.0:1.0 to 2.5:1.0	
Vent Depth	0.051	mm

NOTE

1. Annealing cycle: 4hrs @ 176°F
2. Rate A (50°C/h), Loading 1 (10 N)
3. Rate A (50°C/h), Loading 2 (50 N)

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