

Diakon® CTG615

Polymethyl Methacrylate Acrylic

Lucite International Holland BV

Message:

Diakon® CTG615 is a polymethyl methacrylate-acrylic material. This product is available in Europe, and the processing method is injection molding. Diakon® The main characteristics of CTG615 are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.7	g/10 min	ISO 1133
Molding Shrinkage	0.40 - 0.70	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.32	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	57		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	56.0	MPa	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Stress	79.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	2.7	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	29	kJ/m ²	ISO 179/1eU
Notched Izod Impact	2.8	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	87.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	96.0	°C	ISO 306/A
--	86.0	°C	ISO 306/B
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	92.0	%	ASTM D1003
Haze	1.5	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	

Drying Time	3.0 - 4.0	hr
Hopper Temperature	50 - 90	°C
Rear Temperature	190 - 250	°C
Middle Temperature	210 - 270	°C
Front Temperature	210 - 290	°C
Nozzle Temperature	220 - 280	°C
Mold Temperature	50 - 90	°C

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