

# Altuglas® V 825T

Polymethyl Methacrylate Acrylic  
Altuglas International of Arkema Inc.

Message:

Altuglas® V 825T is a Polymethyl Methacrylate Acrylic product. It is available in Asia Pacific or Europe. Typical application: Automotive. Primary characteristic: flame rated.

| General Information                          |                                              |                   |             |
|----------------------------------------------|----------------------------------------------|-------------------|-------------|
| UL YellowCard                                | E106635-218395                               |                   |             |
| Forms                                        | Granules                                     |                   |             |
| Multi-Point Data                             | Isothermal Stress vs. Strain (ISO 11403-1)   |                   |             |
|                                              | Secant Modulus vs. Strain (ISO 11403-1)      |                   |             |
|                                              | Specific Volume vs Temperature (ISO 11403-2) |                   |             |
|                                              | Viscosity vs. Shear Rate (ISO 11403-2)       |                   |             |
| Physical                                     | Nominal Value                                | Unit              | Test Method |
| Density                                      | 1.19                                         | g/cm <sup>3</sup> | ISO 1183    |
| Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)     | 2.8                                          | g/10 min          | ISO 1133    |
| Molding Shrinkage - Flow                     | 0.20 to 0.60                                 | %                 | ASTM D955   |
| Water Absorption (Equilibrium, 23°C, 50% RH) | 0.30                                         | %                 | ISO 62      |
| Hardness                                     | Nominal Value                                | Unit              | Test Method |
| Rockwell Hardness (M-Scale)                  | 97                                           |                   | ASTM D785   |
| Mechanical                                   | Nominal Value                                | Unit              | Test Method |
| Tensile Stress (Yield, 23°C)                 | 70.0                                         | MPa               | ISO 527-2   |
| Tensile Strain (Break, 23°C)                 | 6.0                                          | %                 | ISO 527-2   |
| Flexural Modulus (23°C)                      | 3300                                         | MPa               | ISO 178     |
| Flexural Stress (23°C)                       | 103                                          | MPa               | ISO 178     |
| Compressive Stress (23°C)                    | 117                                          | MPa               | ISO 604     |
| Impact                                       | Nominal Value                                | Unit              | Test Method |
| Charpy Notched Impact Strength (23°C)        | 2.0                                          | kJ/m <sup>2</sup> | ISO 179/2C  |
| Charpy Unnotched Impact Strength (23°C)      | 11                                           | kJ/m <sup>2</sup> | ISO 179/2U  |
| Notched Izod Impact Strength (23°C)          | 1.8                                          | kJ/m <sup>2</sup> | ISO 180/1A  |
| Thermal                                      | Nominal Value                                | Unit              | Test Method |
| Heat Deflection Temperature                  |                                              |                   |             |
| 0.45 MPa, Unannealed                         | 103                                          | °C                | ISO 75-2/B  |
| 1.8 MPa, Unannealed                          | 100                                          | °C                | ISO 75-2/A  |
| Vicat Softening Temperature                  | 108                                          | °C                | ISO 306/B   |
| CLTE - Flow (-30 to 23°C)                    | 6.5E-5                                       | cm/cm/°C          | ASTM D696   |
| Specific Heat                                | 2090                                         | J/kg/°C           |             |
| Electrical                                   | Nominal Value                                | Unit              | Test Method |

|                               |               |         |             |
|-------------------------------|---------------|---------|-------------|
| Surface Resistivity           | > 1.0E+14     | ohms    | ASTM D257   |
| Volume Resistivity            | > 1.0E+15     | ohms·cm | ASTM D257   |
| Dielectric Strength           | 20            | kV/mm   | ASTM D149   |
| Dielectric Constant (60 Hz)   | 3.70          |         | ASTM D150   |
| Dissipation Factor (1 MHz)    | 0.040         |         | ASTM D150   |
| Flammability                  | Nominal Value | Unit    | Test Method |
| Flame Rating                  | HB            |         | UL 94       |
| Optical                       | Nominal Value | Unit    | Test Method |
| Refractive Index <sup>1</sup> | 1.490         |         | ISO 489     |
| Transmittance                 | 92.0          | %       | ASTM D1003  |
| Haze                          | 0.50          | %       | ASTM D1003  |
| Injection                     | Nominal Value | Unit    |             |
| Drying Temperature            | 85.0 to 90.0  | °C      |             |
| Drying Time                   | 2.0 to 4.0    | hr      |             |
| Processing (Melt) Temp        | 230 to 250    | °C      |             |
| Mold Temperature              | 80.0 to 90.0  | °C      |             |
| NOTE                          |               |         |             |
| 1.                            | Method B      |         |             |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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