

Diakon® TD735

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® TD735 is a Polymethyl Methacrylate Acrylic material. It is available in Europe for injection molding. Primary attribute of Diakon® TD735: Flame Rated.

General Information			
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	1.8	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.80	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	35		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	50.0	MPa	ISO 527-2
Tensile Strain (Yield)	35	%	ISO 527-2
Flexural Modulus	1700	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	4.7	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	53	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	4.2	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	94.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	107	°C	ISO 306/A
--	96.0	°C	ISO 306/B
CLTE - Flow	1.2E-4	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	89.0	%	ASTM D1003
Haze	2.5	%	ASTM D1003
Injection	Nominal Value	Unit	

Drying Temperature	80.0	°C
Drying Time	3.0 to 4.0	hr
Hopper Temperature	50.0 to 80.0	°C
Rear Temperature	190 to 240	°C
Middle Temperature	210 to 260	°C
Front Temperature	210 to 280	°C
Nozzle Temperature	220 to 270	°C
Mold Temperature	50.0 to 80.0	°C

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Recommended distributors for this material

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

