

ASTAGLAS™ MV825I

Polymethyl Methacrylate Acrylic
Marplex Australia Pty. Ltd.

Message:

ASTAGLAS™ MV825I is a toughened high heat resistance moulding grade of Poly(Methyl Methacrylate) in the ASTAGLAS™ range. Typical applications are tinted or solid colour components requiring heat resistance and moulded component strength.

General Information			
Features	High Heat Resistance		
	High Strength		
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)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	3000	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	65.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	15	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2850	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	45	J/m	ASTM D256
Falling Ball Impact	2.00	J	ASTM D6717
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed, 6.40 mm)	98.0	°C	ASTM D648
Vicat Softening Temperature	101	°C	ASTM D1525 ⁶
CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	HB	UL 94	
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		ASTM D542
Transmittance (Total, 3200 µm)	92.0	%	ASTM D1003
Haze (3200 µm)	< 2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	

Front Temperature	220 to 240	°C
Processing (Melt) Temp	230 to 250	°C
Mold Temperature	50.0 to 90.0	°C
Injection Pressure	60.0 to 130	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.100 to 0.500	MPa
Screw Speed	40 to 60	rpm
Clamp Tonnage	5.0 to 9.0	kN/cm ²

NOTE

- | | |
|----|------------------------------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 5.0 mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |
| 6. | Rate B (120°C/h), Loading 2 (50 N) |

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