

Diakon® Frost FR10423

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® Frost FR10423 is a polymethyl methacrylate-acrylic material. This product is available in Europe and is processed by extrusion. Diakon® The main characteristics of Frost FR10423 are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	1.0	g/10 min	ISO 1133
Water Absorption (Equilibrium, 23°C, 50% RH)	0.36	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	60		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	31.0	MPa	ISO 527-2
Tensile Strain (Yield)	25	%	ISO 527-2
Flexural Modulus	1500	MPa	ISO 178
Flexural Stress	42.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	5.9	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	44	kJ/m ²	ISO 179/1eU
Notched Izod Impact	5.1	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	88.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	105	°C	ISO 306/A
--	92.0	°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
Transmittance	82.0	%	ASTM D1003
Haze	92	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 - 4.0	hr	

Hopper Temperature	50.0 - 80.0	°C
Cylinder Zone 1 Temp.	160 - 240	°C
Cylinder Zone 2 Temp.	180 - 250	°C
Cylinder Zone 3 Temp.	200 - 250	°C
Cylinder Zone 4 Temp.	220 - 260	°C
Adapter Temperature	210 - 270	°C
Die Temperature	210 - 270	°C

Extrusion instructions

Vent Zone: 220 to 270°CZone 6: 220 to 270°CZone 7: 210 to 270°CZone 8: 210 to 270°C

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