

Diakon® Rapide CLG356B

Polymethyl Methacrylate Acrylic

Lucite International Inc.

Message:

Diakon® Rapide CLG356B is a Polymethyl Methacrylate Acrylic material. It is available in Europe for injection molding. Primary attribute of Diakon® Rapide CLG356B: Flame Rated.

General Information			
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	15	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	97		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	61.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.1	%	ISO 527-2
Flexural Modulus	2900	MPa	ISO 178
Flexural Stress	59.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	16	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	99.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	96.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	104	°C	ISO 306/A
--	100	°C	ISO 306/B
CLTE - Flow	7.1E-5	cm/cm/°C	ASTM E831
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	0.50	%	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	180 to 230	°C
Middle Temperature	210 to 260	°C
Front Temperature	210 to 270	°C
Nozzle Temperature	210 to 260	°C
Mold Temperature	50.0 to 70.0	°C

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