

Acrigel® ECL100

Polymethyl Methacrylate Acrylic

Unigel Plásticos

Message:

Low flow rate, good thermal resistance and good balance stiffness/impact.

Applications:

Extruded profiles

Injected technical parts

General Information			
Features	Good Impact Resistance		
	Good Stiffness		
	Low Flow		
	Medium Heat Resistance		
Uses	Engineered Applications		
	Profiles		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	96		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	72.0	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	15	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	98.0	°C	ASTM D648
Vicat Softening Temperature			
--	102	°C	ASTM D1525 ¹
--	110	°C	ASTM D1525 ²
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.490		ASTM D542
Transmittance	92.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	

Drying Time	4.0	hr
Rear Temperature	230	°C
Middle Temperature	240	°C
Front Temperature	250	°C
Nozzle Temperature	245	°C
Mold Temperature	60.0	°C

NOTE		
1.	Rate A (50°C/h), Loading 2 (50 N)	
2.	Rate B (120°C/h), Loading 1 (10 N)	

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