

ASTAGLAS™ DR

Polymethyl Methacrylate Acrylic
Marplex Australia Pty. Ltd.

Message:

ASTAGLAS™ DR is a transparent high impact and heat resistance Poly(Methyl Methacrylate) Acrylic for injection moulding and extrusion processes. Typical applications require an optimum balance of toughness and heat resistance products for automotive, lighting, appliance and houseware applications.

General Information			
Features	Good Toughness		
	High Heat Resistance		
	High Impact Resistance		
Uses	Appliances		
	Automotive Applications		
	Household Goods		
	Labels		
Appearance	Clear/Transparent		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.55	%	ASTM D955
Water Absorption (24 hr)	0.40	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	45		
R-Scale	110		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2000	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	42.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	1820	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	65.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	46	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load ⁶ (1.8 MPa, Annealed, 3.20 mm)	87.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525 ⁷
CLTE - Flow	1.0E-4	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)	90.0	%	ASTM D1003
Haze (3200 μm)	< 2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	200 to 230	°C	
Middle Temperature	210 to 240	°C	
Front Temperature	220 to 250	°C	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	50.0 to 85.0	°C	
Injection Pressure	60.0 to 130	MPa	
Injection Rate	Slow-Moderate		
Back Pressure	0.100 to 1.00	MPa	
Screw Speed	40 to 80	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.	Annealed 4 hr at 80°C		
7.	Loading 1 (10 N)		

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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



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