ACRYREX CM-207

PMMA — CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**8.5**	cm³/10min	ISO 1133
Temperature	**230**	°C	-
Load	**3.8**	kg	-
Molding shrinkage, parallel	**0.4**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**8**	g/10min	ASTM D 1238
Temperature	**230**	°C	-
Load	**3.8**	kg	-
Mold Shrinkage, MD	**0.004**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**67**	MPa	ISO 527
Stress at break	**67**	MPa	ISO 527
Flexural modulus, 23°C	**2700**	MPa	ISO 178
Flexural strength	**97**	MPa	ISO 178
Charpy notched impact strength, +23°C	**2**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**2**	kJ/m²	ISO 180/1A
ASTM Data			
Tensile Strength at Break	**68.3**	MPa	ASTM D 638
Flexural Strength	**108**	MPa	ASTM D 790
Rockwell Hardness	**M 88**	-	ASTM D 785
Izod Impact notched, 1/8 in	**19.8**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**89**	°C	ISO 75-1/-2
Vicat softening temperature, A	**107**	°C	ISO 306
Vicat softening temperature, B	**99**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**60**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**1.59**	mm	-
Vicat Temperature	**107**	°C	ASTM D 1525

Optical properties	Value	Unit	Test Standard
ASTM Data			
Light Transmittance	**92**	%	ASTM D 1003
Index of Refraction	**1.49**	-	ASTM D 542

Other properties	Value	Unit	Test Standard
Density	**1190**	kg/m³	ISO 1183
Density	**1190**	kg/m³	ASTM D 792
Bulk Density	**700**	kg/m³	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**75 - 80**	°C	-
Pre-drying - Time	**4**	h	-
Mold temperature	**40 - 60**	°C	-
Feed temperature	**185 - 200**	°C	-
Zone 1	**210 - 225**	°C	-
Nozzle temperature	**200 - 220**	°C	-

Characteristics

Processing
Injection Molding

Applications
Electrical and Electronical, General Purpose

Special Characteristics
Heat stabilized or stable to heat

Regional Availability
Asia Pacific