

ACRYREX CM-211

PMMA

CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	16	cm ³ /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	16	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	65	MPa	ISO 527
Stress at break	65	MPa	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	95	MPa	ISO 178
Charpy notched impact strength, +23°C	2	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	2	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength at Break	66.9	MPa	ASTM D 638
Flexural Strength	97.9	MPa	ASTM D 790
Rockwell Hardness	M 84	-	ASTM D 785
Izod Impact notched, 1/4 in	19.8	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	78	°C	ISO 75-1/-2
Vicat softening temperature, A	103	°C	ISO 306
Vicat softening temperature, B	96	°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	103	°C	ASTM D 1525
Optical properties			
ASTM Data			
Light Transmittance	92	%	ASTM D 1003
Index of Refraction	1.49	-	ASTM D 542
Other properties			
Density	1190	kg/m ³	ISO 1183
Density	1190	kg/m ³	ASTM D 792
Bulk Density	700	kg/m ³	-
Processing Recommendation Injection Molding			
Pre-drying - Temperature	70 - 75	°C	-
Pre-drying - Time	4	h	-
Mold temperature	30 - 50	°C	-
Feed temperature	180 - 190	°C	-
Zone 1	195 - 215	°C	-
Nozzle temperature	190 - 210	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

Asia Pacific

Applications

Electrical and Electronical