

## PLEXIGLAS® Optical HT PMMA

Röhm GmbH

| Rheological properties                             | Value     | Unit      | Test Standard   |
|----------------------------------------------------|-----------|-----------|-----------------|
| <b>ISO Data</b>                                    |           |           |                 |
| Melt volume-flow rate, MVR                         | 2         | cm³/10min | ISO 1133        |
| Temperature                                        | 230       | °C        | -               |
| Load                                               | 3.8       | kg        | -               |
| <b>Mechanical Properties</b>                       |           |           |                 |
| <b>ISO Data</b>                                    |           |           |                 |
| Tensile Modulus                                    | 3600      | MPa       | ISO 527         |
| Stress at Break                                    | 71        | MPa       | ISO 527         |
| Strain at Break                                    | 3         | %         | ISO 527         |
| Impact Strength (Charpy), +23°C                    | 20        | kJ/m²     | ISO 179/1eU     |
| <b>Thermal Properties</b>                          |           |           |                 |
| <b>ISO Data</b>                                    |           |           |                 |
| Glass Transition Temperature (10°C/min)            | 122       | °C        | ISO 11357-1/-2  |
| Temp. of deflection under load (1.80 MPa)          | 114       | °C        | ISO 75-1/-2     |
| Temp. of deflection under load (0.45 MPa)          | 117       | °C        | ISO 75-1/-2     |
| Vicat softening temperature, 50°C/h 50N            | 118       | °C        | ISO 306         |
| Coeff. of Linear Therm. Expansion, parallel        | 70        | E-6/K     | ISO 11359-1/-2  |
| Burning Behav. at 1.5 mm Nom. Thickn.              | HB        | class     | UL 94           |
| Thickness tested                                   | 1.5       | mm        | -               |
| UL recognition                                     | yes       | -         | -               |
| <b>Other Properties</b>                            |           |           |                 |
| <b>ISO Data</b>                                    |           |           |                 |
| Density                                            | 1190      | kg/m³     | ISO 1183        |
| <b>Material Specific Properties</b>                |           |           |                 |
| <b>ISO Data</b>                                    |           |           |                 |
| Luminous transmittance                             | 92        | %         | ISO 13468-1, -2 |
| <b>Processing Recommendation Injection Molding</b> |           |           |                 |
| Pre-drying - Temperature                           | 90 - 100  | °C        | -               |
| Pre-drying - Time                                  | 4 - 6     | h         | -               |
| Melt temperature                                   | 230 - 250 | °C        | -               |
| Mold temperature                                   | 75 - 95   | °C        | -               |

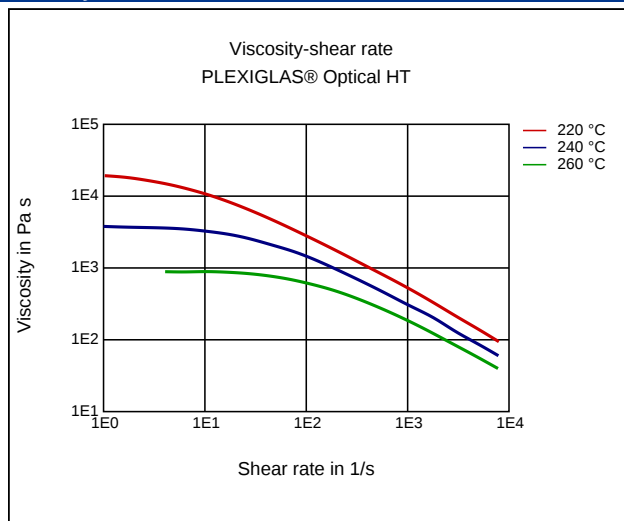
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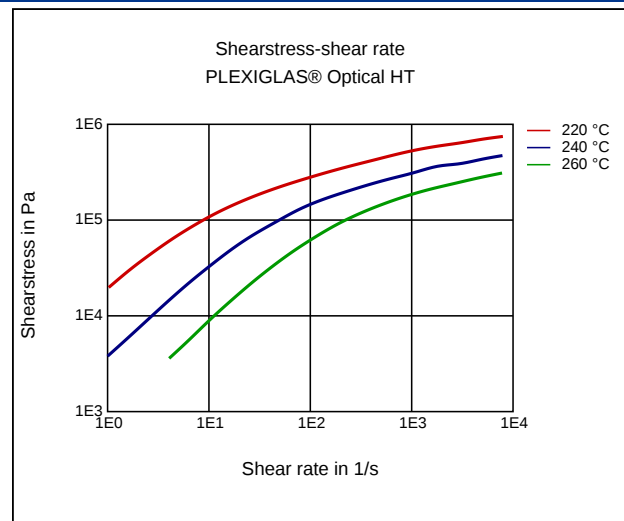
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#### Diagrams

##### Viscosity-shear rate



##### Shearstress-shear rate



#### Characteristics

##### Processing

Injection Molding, Profile Extrusion, Sheet Extrusion, Other Extrusion

##### Delivery form

Pellets

##### Special Characteristics

Light stabilized or stable to light, UV stablized, Heat aging stabilized, Transparent

##### Features

Amorphous

##### Applications

Automotive