



TER Plastics
POLYMER GROUP



PLEXIGLAS® 7H

PMMA

Evonik Industries AG

Product Texts

Productprofil:

PLEXIGLAS® 7H is an amorphous thermoplastic molding compound (PMMA).

Typical properties of PLEXIGLAS® molding compounds are:

- good flow
- high mechanical strength, surface hardness and mar resistance
- high light transmission
- excellent weather resistance
- free colorability due to crystal clarity.

Special properties of PLEXIGLAS® 7H are:

- very good mechanical properties
- high heat deflection temperature
- high melt strength
- AMECA listing.

Application:

Used for extruding optical and technical profiles and sheets.

Example:

sheets, tubes, multi-skin sheets, coextrusion of window profiles and similar applications

Processing:

PLEXIGLAS® 7H can be processed on extruders with 3-zone general purpose screws for engineering thermoplastics.

Physical Form / Packaging:

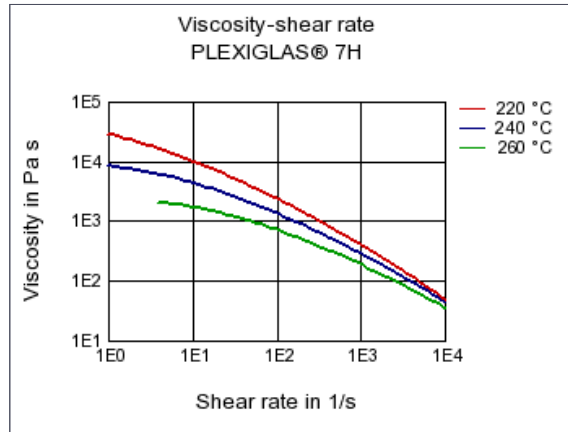
PLEXIGLAS® molding compounds are supplied as pellets of uniform size, packaged in 25kg polyethylene bags or in 500kg boxes with PE lining; other packaging on request.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1.4	cm ³ /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	3.8	kg	ISO 1133
Mechanical properties			
ISO Data			
Tensile Modulus	3200	MPa	ISO 527-1/-2
Stress at break	76	MPa	ISO 527-1/-2
Strain at break	5.5	%	ISO 527-1/-2
Tensile creep modulus, 1h	2900	MPa	ISO 899-1
Tensile creep modulus, 1000h	2300	MPa	ISO 899-1
Charpy impact strength (+23°C)	20	kJ/m ²	ISO 179/1eU
Thermal properties			
ISO Data			
Glass transition temperature, 10°C/min	112	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	95	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	100	°C	ISO 75-1/-2

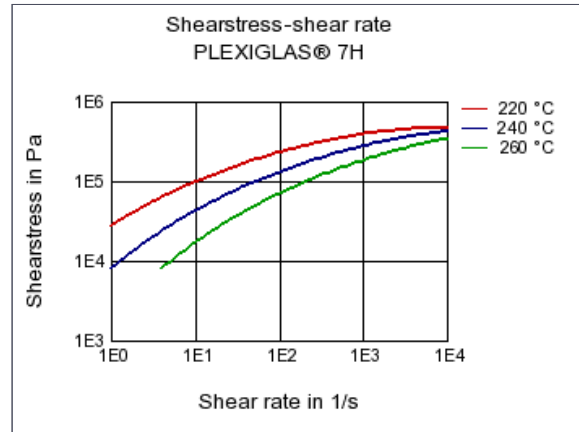
PLEXIGLAS® 7H			
PMMA		Evonik Industries AG	
Vicat softening temperature, 50°C/h 50N	103	°C	ISO 306
Coeff. of linear therm. expansion, parallel	80	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	IEC 60695-11-10
UL recognition	UL	-	-
Oxygen index	17.2	%	ISO 4589-1/-2
Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.7	-	IEC 60250
Relative permittivity, 1MHz	2.8	-	IEC 60250
Dissipation factor, 100Hz	500	E-4	IEC 60250
Dissipation factor, 1MHz	200	E-4	IEC 60250
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	1E13	Ohm	IEC 60093
Comparative tracking index	600	-	IEC 60112
Other properties	Value	Unit	Test Standard
ISO Data			
Water absorption	1.9	%	Sim. to ISO 62
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1190	kg/m³	ISO 1183
Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	72	cm³/g	ISO 307, 1157, 1628
Luminous transmittance	92	%	ISO 13468-1, -2
Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	1060	kg/m³	-
Thermal conductivity of melt	0.181	W/(m K)	-
Spec. heat capacity of melt	2440	J/(kg K)	-
Eff. thermal diffusivity	6.99E-8	m²/s	-
Ejection temperature	85	°C	-
Test specimen production	Value	Unit	Test Standard
ISO Data			
Processing conditions acc. ISO	8260	-	ISO-2
Injection Molding, melt temperature	252	°C	ISO 294
Injection Molding, mold temperature	62	°C	ISO 10724
Injection Molding, injection velocity	195	mm/s	ISO 294

Diagrams

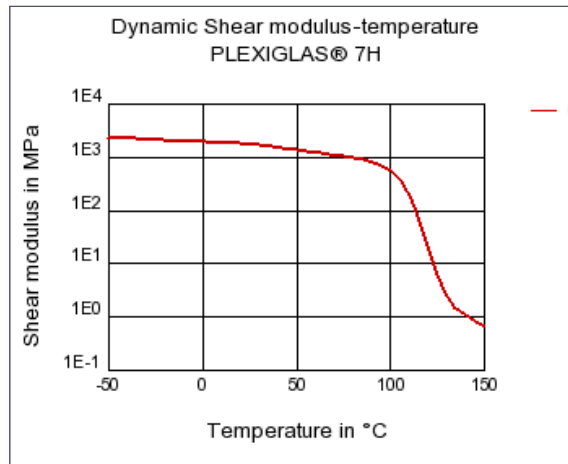
Viscosity-shear rate



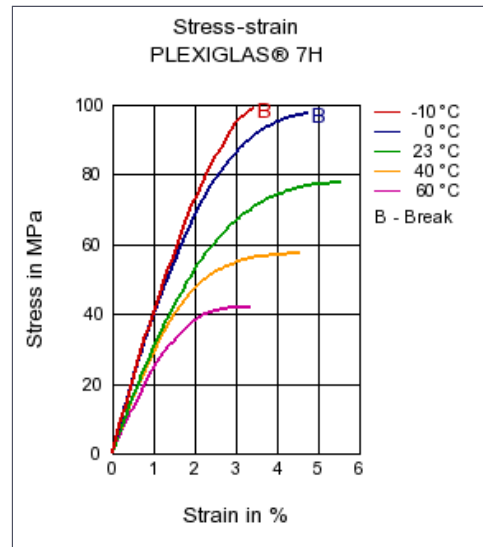
Shearstress-shear rate



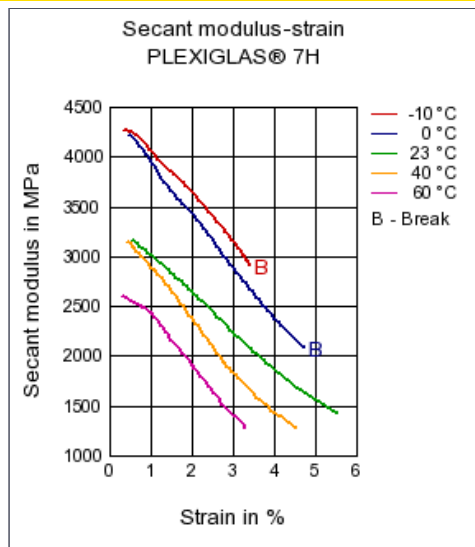
Dynamic Shear modulus-temperature



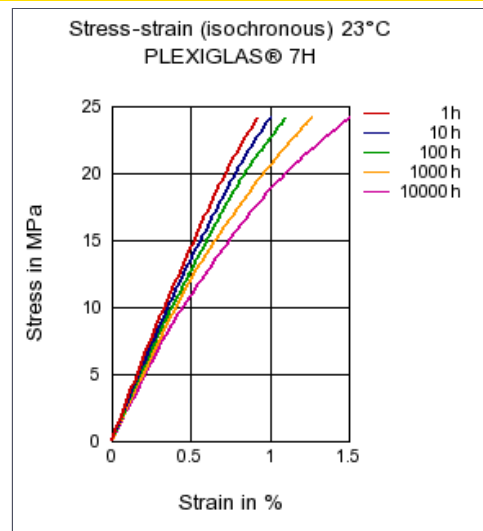
Stress-strain



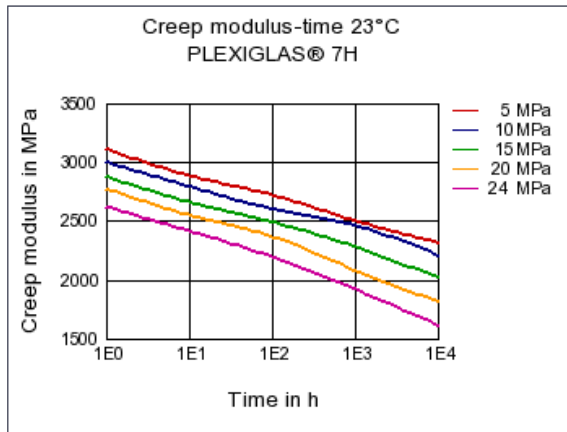
Secant modulus-strain



Stress-strain (isochronous) 23°C



Creep modulus-time 23°C



Characteristics

Processing

Injection Molding, Profile Extrusion, Sheet Extrusion, Other Extrusion, Thermoforming

Special Characteristics

Light stabilized or stable to light, U.V. stabilized or stable to weather, Transparent

Delivery form

Pellets

Other text information

Injection Molding

PREPROCESSING

Predrying temperature: max. 93 °C

Predrying time in a desiccant-type drier: 2 - 3 h

PROCESSING

Min. melt temperature: 220 - 260 °C

Min. mold temperature: 60 - 90 °C

Profile extrusion

PREPROCESSING

Predrying temperature: max. 93 °C

Predrying time in a desiccant-type drier: 2 - 3 h

PROCESSING

Melt temperature: 220 - 260 °C

Die temperature: 220 - 260 °C

Sheet extrusion

PREPROCESSING

Predrying temperature: max. 93 °C

Predrying time in a desiccant-type drier: 2 - 3 h

PROCESSING

Melt temperature: 220 - 260 °C

Die temperature: 220 - 260 °C

Chemical Media Resistance

Acids

- ☺ Citric Acid solution (10% by mass) (23°C)
- ☺ Lactic Acid (10% by mass) (23°C)
- ☺ Nitric Acid (40% by mass) (23°C)
- ☺ Sulfuric Acid (38% by mass) (23°C)
- ☺ Sulfuric Acid (5% by mass) (23°C)

Bases

- ☺ Sodium Hydroxide solution (35% by mass) (23°C)
- ☺ Sodium Hydroxide solution (1% by mass) (23°C)
- ☺ Ammonium Hydroxide solution (10% by mass) (23°C)

Hydrocarbons

- ☺ n-Hexane (23°C)
- ☺ iso-Octane (23°C)

Standard Fuels

- ☺ Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23°C)
- ☺ Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23°C)
- ☺ Diesel fuel (pref. ISO 1817 Liquid F) (23°C)

Salt solutions

- ☺ Sodium Carbonate solution (20% by mass) (23°C)
- ☺ Sodium Carbonate solution (2% by mass) (23°C)

Other

- ☺ 50% Oleic acid + 50% Olive Oil (23°C)
- ☺ Water (23°C)