



Optix® CP-924

Plaskolite, Inc. - Polymethyl Methacrylate Acrylic

Sunday, November 3, 2019

General Information

General

Material Status	• Commercial: Active		
Availability	• Europe	• North America	
Features	• Chemical Resistant • Electrically Insulating • Good Dimensional Stability • Good Impact Resistance	• Good Processability • Good Weather Resistance • High Clarity • High Flow	• Low Odor • Low to No Taste • Machinable
Automotive Specifications	• SAE J576		
Appearance	• Colors Available		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.17		ASTM D792
Melt Mass-Flow Rate (230°C/3.8 kg)	6.4	g/10 min	ASTM D1238
Molding Shrinkage - Flow	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Mechanical			
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength	8500	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	370000	psi	ASTM D790
Flexural Strength	12500	psi	ASTM D790
Impact			
Notched Izod Impact	0.90	ft·lb/in	ASTM D256
Unnotched Izod Impact	8.9	ft·lb/in	ASTM D256
Gardner Impact	14.0	in·lb	ASTM D3029
Hardness			
Rockwell Hardness (M-Scale)	68		ASTM D785
Thermal			
Deflection Temperature Under Load 264 psi, Unannealed	190	°F	ASTM D648
Vicat Softening Temperature	219	°F	ASTM D1525
CLTE - Flow (-22 to 86°F)	4.1E-5	in/in/°F	ASTM D696
Flammability			
Flame Rating	HB		UL 94
Optical			
Refractive Index	1.490		ASTM D542
Transmittance	91.0	%	ASTM D1003
Haze	2.00	%	ASTM D1003

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Additional Information

Thermal Index, UL-746 ABC: 50°C

Burn Rate, ASTM D635: 1.6 in/min

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 165	°F
Rear Temperature	400 to 480	°F
Middle Temperature	410 to 490	°F
Front Temperature	420 to 500	°F
Nozzle Temperature	410 to 500	°F
Processing (Melt) Temp	410 to 480	°F
Mold Temperature	120 to 175	°F

Injection Notes

Heated Manifold: 410-480°F

Heated Drop (Sprue): 410-480°F

Notes

¹ Typical properties: these are not to be construed as specifications.