

# ACRYPET for Extrusion

Mitsubishi Rayon Co., Ltd.

# PMMA for Extrusion Sheet (Physical Properties)

Item	Method	Condition	Unit	Extrusion grade	
				VH	VH6
				001	001
Specific gravity	JIS K7112 ISO 1183		g/cm <sup>3</sup>	1.19	1.19
Total light transmittance	ISO 13468	3mm	%	92.5	93
Haze	ISO 14782	3mm	%	0.3	0.3
Refractive index	ASTM D542	nd	—	1.49	1.49
Water absorption	ISO 62	24hr	%	0.3	0.3
Specific heat	JIS K7123		J/(g·°C)	1.5	1.5
Coefficient of linear expansion	ASTM D696		1/C	6×10 <sup>-5</sup>	6×10 <sup>-5</sup>
Coefficient of Thermal conductivity	ASTM C177		W/(mC)	0.2	0.2
Deflection temperature under load	ISO 75	1.80MPa	C	100	95
Vicat Softening temperature	ISO 306	50N	C	107	102
Melt flow rate	ISO 1133	230C,37.3N	g/10min	2.0	1.5
Mold shrinkage	MRC method		%	0.2-0.6	0.2-0.6
Tensile strength	ISO 527	1A/5	MPa	77	75
Tensile elongation	ISO 527	1A/5	%	6	6
Flexural strength	ISO 178		MPa	140	130
Flexural modulus	ISO 178		GPa	3.3	3.0
Izod Impact strength	ISO 180	1A	kJ/m <sup>2</sup>	2.1	3.3
Charpy impact strength	ISO179	1eU unnotched	kJ/m <sup>2</sup>	20	18
		1eA V notched	kJ/m <sup>2</sup>	1.4	1.6
Rockwell hardness	ISO 2039	M scale	—	101	100

## ACRYPET VH :

Standard grade with top grade of heat resistance.

Suitable for extrusion molding.

for thickness 2mm >

## ACRYPET VH6 :

Suitable for thick extrusion sheet.

for thickness 2mm <<



# Typical Extrusion Molding Condition

Item		VH	VH6
Screw L/D		25~36	25~36
	Hopper side	200~230°C	210~240°C
Cylinder Temperature	Center	220~240°C	220~250°C
	Die side	220~240°C	220~250°C
Die Temperature		220~240°C	220~250°C