

TYPICAL PROPERTIES OF ACRYLICS

ASTM Test	Property	— MOLDING GRADE —		
		Cast Sheet	Standard	High Impact
PHYSICAL				
D792	Specific gravity	1.19	1.19	1.15-1.17
D792	Specific volume (in ³ /lb)	23.3	23.3	24.1
D570	Water absorption , 24 h, 1/8-in thk (%)	0.2	0.3	0.3
MECHANICAL				
D638	Tensile strength (psi)	10,500	10,500	5,400-7,000
D638	Elongation (%)	5	5	50
D638	Tensile modulus (10 ⁵ psi)	4.5	4.3	2.2-3.2
D790	Flexural strength (psi)	16,500	16,000	7,000-10,500
D790	Flexural modulus (10 ⁵ psi)	4.5	4.5	2.3-3.2
D256	Impact strength , Izod (ft-lb/in of notch)	0.4	0.4	0.6-1.2
D785	Hardness , Rockwell	M100-102	M95	R99-M68
THERMAL				
D696	Coefficient of thermal expansion (10 ⁻⁵ in/in-°C)	3.9	3.6	3.8
D648	Deflection temperature (°F)			
	At 264 psi	200-215	198	170-190
	At 66 psi	225	214	187
ELECTRICAL				
D149	Dielectric strength (V/mil) Short time, 1/8-in thk	500	500	383-450
D150	Dielectric constant			
	At 1 kHz	3.3	3.3	3.9
	At 1 MHz	2.5	2.3	2.5-3.0
D150	Dissipation factor			
	At 1 kHz	0.04	0.04	—
	At 1 MHz	0.02-0.03	0.02-0.03	0.01-0.02
D257	Volume resistivity (ohm-cm) At 73°F, 50% RH	>10 ¹⁷	>10 ¹⁷	>10 ¹⁵
D495	Arc resistance (s)	No track	No track	No track
OPTICAL				
D542	Refractive index	1.49	1.49	1.49
D1003	Transmittance (%)	92	92	90

Ref: Machine Design – 1985

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