

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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ISO Test	Property	MOLDING GRADE			
		Cast Sheet	Standard	High Impact	
PHYSICAL					
ISO1183	Specific gravity	1.19	1.19	1.15-1.17	
ISO1183	Specific volume (cm ³ /g)	0.84	0.84	0.86	
ISO62	Water absorption, 24 h, 3 mm thk (%)	0.2	0.3	0.3	
MECHANICAL					
ISO527	Tensile strength (MPa)	72.39	72.39	37.23-48.26	
ISO527	Elongation (%)	5	5	50	
ISO527	Tensile modulus (MPa)	3,102	2,964	1,516-2,206	
ISO178	Flexural strength (MPa)	113	110	48-72	
ISO178	Flexural modulus (MPa)	3,102	3,102	1,516-2,206	
ISO179	Impact strength, Izod (J/m)	21	21	32-64	
ISO2039	Hardness, Rockwell	M100-102	M95	R99-M68	
THERMAL					
ISO11359	Coefficient of thermal expansion (10 ⁻⁴ m/m°C)	0.7	0.65	0.68	
ISO527	Deflection temperature (°C)	At 1.80 MPa	93-102	92	77-88
		At 0.45 MPa	107	101	86
ELECTRICAL					
IEC243	Dielectric strength (kV/mm) Short time, 3 mm thk	19.6	19.6	15.0-17.7	
IEC250	Dielectric constant	At 1 kHz	3.3	3.3	3.9
		At 1 MHz	2.5	2.3	2.5-3.0
IEC250	Dissipation factor	At 1 kHz	0.04	0.04	—
		At 1 MHz	0.02-0.03	0.02-0.03	0.01-0.02
IEC93	Volume resistivity (ohm-cm) At 23°C, 50% RH	>10 ¹⁷	>10 ¹⁷	>10 ¹⁵	
ASTM D495	Arc resistance (s)	No track	No track	No track	
OPTICAL					
ISO489	Refractive index	1.49	1.49	1.49	
ASTM D1003	Transmittance (%)	92	92	90	

Ref: Machine Design – 1985