SALES RANGE
MOLDING COMPOUNDS
Sales Range

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PLEXIGLAS® MOLDING COMPOUNDS

Depending on the grade, our standard molding compounds differ in their physical properties such as flow and heat deflection temperature under load. They can be processed by means of all conventional thermoplastic processing methods.

PLEXIGLAS®

PLEXIGLAS® molding compounds are thermoplastics based on polymethyl methacrylate (PMMA), standardized to DIN 7745/ISO 8257.

PLEXIGLAS® molding compounds are characterized by a number of chemical, physical and technical properties that are indispensable for manufacturing high-quality parts by injection molding, injection blow molding and extrusion.

General Remarks

ABSOLUTELY CLEAR
PLEXIGLAS® crystal-clear molding compound grades are so highly transparent that molded parts and semifinished products manufactured from them provide the maximum possible light transmission of 92%. The grades only show the physically unavoidable reflection loss of 4% at each surface where light enters and exits. This unique clarity makes it possible to obtain particularly pure colors with an outstanding degree of precision.

CONVINCING LONGEVITY
As confirmed by tests in all of the world’s climates, PLEXIGLAS® molding compounds show unsurpassed resistance to weathering and aging. They do not turn yellow or wear away under chemical attack, show no deterioration of their properties and are not subject to decay. PLEXIGLAS® therefore makes a major contribution to resource conservation. That was also one of the outstanding points in its favor in the Life Cycle Assessment (LCA) performed in accordance with DIN ISO 14040.

RECYCLABLE
Owing to their chemical composition, PLEXIGLAS® molding compounds are uniquely suitable for chemical recycling and material recovery.

TOUGH SURFACE
In addition to their pleasant feel and sound, molded parts and semifinished products made from PLEXIGLAS® (PMMA) present the greatest surface hardness and thus the best scratch resistance of all thermoplastics. This enables them to conserve their high gloss even after prolonged use.

FOOD CONTACT APPROVALS
The crystal-clear molding compounds PLEXIGLAS® 6N, 7N, 7M, 7H, 8N and 8H as well as PLEXIGLAS® Resist 2k4R neutral, 2k5BR neutral and 2k6BR neutral conform to FDA Regulation CFR 21 § 177.1010, Commission Regulation (EU) 10/2011 including amendments (EU) 2019/1338, (EU) 2019/37 and German Recommendation XXII of the German Federal Institute of Risk Assessment (BfR). Please consult us with regard to other grades and colored molding compounds.

CERTIFIED QUALITY
Röhm has combined its management systems for environmental protection, safety, health and quality in an integrated management system and is certified in accordance with ISO 9001:2015 and ISO 14001:2015. Moreover, the quality management system of the Business Unit Molding Compounds has satisfied the stringent IATF 16949:2016 standard of the automotive industry. All manufacturing processes for PLEXIGLAS® molding compounds are subjected to a continuous improvement process and are monitored by a modern quality management system.
**Product Overview and Markets**

<table>
<thead>
<tr>
<th>Product</th>
<th>Automotive &amp; Transportation*</th>
<th>Electronic &amp; Communication</th>
<th>Lighting Technologies</th>
<th>Building &amp; Architecture</th>
<th>Home &amp; Living</th>
<th>Health &amp; Medical</th>
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*Note on the Automotive & Transportation market segment*

There are increasing demands from the automotive industry for material data to be entered in the International Material Data System (IMDS).

The IMDS archives and manages all materials used in vehicle manufacture. This is the only way to fulfill the obligations imposed on automobile manufacturers, and consequently on suppliers, by national and international norms, standards, laws and directives.

Our material data sheets are published in IMDS and are therefore accessible to all IMDS participants. After they have registered free of charge at www.mdsystems.com, they can retrieve the data sheets by entering our company ID 2211.
[BASIC GRADES – MOLDING COMPOUNDS]

Depending on the grade, our standard molding compounds differ in their physical properties such as flow and heat deflection temperature under load. They can be processed by means of all conventional thermoplastic processing methods.

PLEXIGLAS® 6N
For injection-molded thin-wallet parts

PLEXIGLAS® 7H
For extrusion of profiles and sheets (lighting engineering)

PLEXIGLAS® 7N
For injection-molded optical and technical items

PLEXIGLAS® 7M
For extrusion of profiles and sheets (lighting engineering)

PLEXIGLAS® 8N
For injection-molded advanced technical items

PLEXIGLAS® 8H
For extrusion of profiles and sheets (lighting engineering)

[SPECIAL GRADES]

OPTICAL GRADES
PLEXIGLAS® 0q
For premium articles the molding compounds PLEXIGLAS® 7N and 8N can be supplied on request in “tested optical quality”

PLEXIGLAS® 8N SuPure
Optimized pellet shape and the fact that it undergoes extended quality assurance tests

MEDICAL TECHNOLOGY
CYROLITE®
CYROLITE® products are impact-resistant thermoplastic molding compounds based on methacrylate

AUXILIARY AGENTS
ACRIFIX® sp
Cleaning Agent of high molecular weight

[ADVANCED GRADES – BASED ON BASIC GRADES]

IMPACT
PLEXIGLAS® Resist
Impact-modified grades

HEAT
PLEXIGLAS® Heatresist
Higher heat deflection temperature under load

PLEXIMID®
PMMI with extremely high heat deflection temperature and very high resistance to chemicals, stress cracking and optical stability under heat. Retains optical properties permanently even at high operating temperatures

DIFFUSION
PLEXIGLAS® Satinice
We design polymers with targeted know-how

PLEXIGLAS® LED
For efficient lighting engineering

PLEXIGLAS® LED LD
Light guiding over large area with light input from both sides

PLEXIGLAS® Hi-Gloss
Allow high brilliance for high-gloss, Class A surfaces (e.g. piano black)

BRILLIANCE
PLEXIGLAS® LED LD
PLEXIGLAS® MOLDING COMPOUNDS

Depending on the grade, our standard molding compounds differ in their physical properties such as flow and heat deflection temperature under load. They can be processed by means of all conventional thermoplastic processing methods.

PLEXIGLAS® 6N
FOR INJECTION-MOLDED THIN-WALLET PARTS
- Molding compound with good flow and a standard heat deflection temperature under load
- Application: injection molding of thin-walled parts with long flow paths

PLEXIGLAS® 7N
FOR INJECTION-MOLDED OPTICAL AND TECHNICAL ITEMS
- Molding compound with good flow (somewhat inferior to PLEXIGLAS® 6N) and an adequate heat deflection temperature under load
- Application: injection molding of optical and technical items such as nameplates, covers, magnifying glasses, lenses, housewares and many other uses

PLEXIGLAS® 8N
FOR INJECTION-MOLDED ADVANCED TECHNICAL ITEMS
- Molding compound with a high heat deflection temperature under load
- Slightly inferior flow to PLEXIGLAS® 7N
- Application: injection molding of technical items to satisfy higher demands on heat deflection temperature under load, e.g. lighting industry, automotive industry (taillights, etc.)
- Retains optical properties permanently even at high operating temperatures

PLEXIGLAS® 7H
FOR EXTRUSION OF PROFILES AND SHEETS (LIGHTING ENGINEERING)
- Variant of PLEXIGLAS® 7N with higher molecular weight and improved stress crack resistance. Somewhat tougher than PLEXIGLAS® 7N at the same heat deflection temperature under load
- Application: extrusion of profiles and sheets for lighting engineering

PLEXIGLAS® 7M
FOR EXTRUSION OF PROFILES AND SHEETS (LIGHTING ENGINEERING)
- Variant of PLEXIGLAS® 7H with improved flow
- Application: extrusion of profiles and sheets for lighting engineering

PLEXIGLAS® 8H
FOR EXTRUSION OF PROFILES AND SHEETS (LIGHTING ENGINEERING)
- Variant of PLEXIGLAS® 8N with higher molecular weight and improved stress crack resistance. Somewhat tougher than PLEXIGLAS® 8N at the same heat deflection temperature under load
- Application: extrusion of profiles and sheets for lighting engineering
- Retains optical properties permanently even at high operating temperatures
PLEXIGLAS® Resist – IMPACT-MODIFIED

Depending on the standard molding compound, the impact-modified grades differ in their key properties, such as optimized flow or stress crack resistance. They are suitable for extruding and coextruding profiles and sheets and for injection molding.

PLEXIGLAS® Resist zkBR
HIGH IMPACT STRENGTH

With its special optical characteristics and balanced property spectrum, the zkBR series is the basis for impact-modified PLEXIGLAS® molding compounds.

PLEXIGLAS® Resist zkHC
HIGH IMPACT STRENGTH

This series is characterized by even higher stress crack resistance than that of PLEXIGLAS® zkBR molding compounds.

PLEXIGLAS® Resist zkHF
HIGH IMPACT STRENGTH

The special feature of this series of PLEXIGLAS® molding compounds as compared with other impact-modified grades is its excellent flow.

PLEXIGLAS® Resist AG 100
VERY HIGH IMPACT STRENGTH

Very high impact strength combined with a high heat deflection temperature.

A typical feature of this product is the clear reduction in reversible haze at very high and low temperatures.

PLEXIGLAS® Heatresist AND PLEXIMID®

Products of the PLEXIGLAS® Heatresist and PLEXIMID® groups are crystal-clear molding compounds with different heat deflection temperature under load.

PLEXIGLAS® Heatresist FT15
HIGH HEAT DEFLECTION TEMPERATURE UNDER LOAD

PLEXIGLAS® Heatresist FT15 is a molding compound based on PMMA with a higher heat deflection temperature under load combined with improved flow.

PLEXIGLAS® Heatresist FT15 is suitable for injection-molding and extrusion applications with stringent requirements in terms of heat deflection temperature and flow. The special property profile offers benefits particularly when it comes to designing moldings with challenging wall thickness/flow path ratios (e.g. multi-component injection moulding).

PLEXIGLAS® Heatresist hw55
HIGH HEAT DEFLECTION TEMPERATURE UNDER LOAD

PLEXIGLAS® Heatresist hw55 is particularly suited for injection-molded technical parts and for applications subjected to high thermal stress.

PLEXIGLAS® Heatresist hw55 is a copolymer based on methyl methacrylate (MMA) with comonomer constituents. These provide a high heat deflection temperature under load for a PMMA molding compound, combined with high chemical resistance and ease of processing.

PLEXIMID® TT50 • PLEXIMID® TT70
VERY HIGH HEAT DEFLECTION TEMPERATURE UNDER LOAD

PLEXIMID® products are polymethyl methacrylimide molding compounds that combine an extremely high heat deflection temperature with very high resistance to chemicals and stress cracking.

Besides their high light transmission and clarity, and good strength and rigidity, the specialty grades are characterized by extremely stable optical values upon prolonged exposure to heat. They can be used as films, headlamp lenses, drum lenses, light guides and ancillary lenses for high-power LEDs.
In all production processes, bead-shaped polymer particles impart light-diffusing properties to products made of PLEXIGLAS® Satinice, with minimal loss of transmitted light. Furthermore, in extrusion processes, matt surfaces can be obtained.

**PLEXIGLAS® Satinice df20–23**

**HOMOGENEOUS ILLUMINATION**

Products from the PLEXIGLAS® Satinice range are specialty molding compounds used for lighting fixture covers or short light guides for ambient lighting and for the homogeneous illumination of small displays. They diffuse the light evenly towards the viewer. Available in grades PLEXIGLAS® 7H, 7N, 8N and zk6BR.

**PLEXIGLAS® Satinice df23**

**PLEXIGLAS® Satinice df22**

**PLEXIGLAS® Satinice df21**

**PLEXIGLAS® Satinice df20**

**PLEXIGLAS® LED – FOR LED LIGHTING**

Specialty molding compounds for efficient lighting engineering applications in combination with LEDs. There is a choice of products either for edge or backlighting without any disturbing hot spots.

**FOR EDGE LIGHTING**

Components made from the molding compounds of the LD range appear crystal-clear and transparent when unlit. These molding compounds have been optimized for edge lighting and for guiding light across differently sized areas. No additional diffusion films or microstructures are required on the component surface in order to achieve uniform light output over the entire surface.

Possible applications are ambient lighting, light guides without a decoupling structure, area lighting and light curtains.

**PLEXIGLAS® LED LD**

**LIGHT GUIDING OVER LARGE AREA WITH LIGHT INPUT FROM ONE OR TWO SIDES**

Available as PLEXIGLAS® molding compound 8N.

**PLEXIGLAS® LED LD96**

**PLEXIGLAS® LED LD48**

**PLEXIGLAS® LED LD24**

**PLEXIGLAS® LED LD12**

**FOR BACKLIGHTING**

Molding compound colors for uniform light distribution when backlit with strong LED light, combined with high transmission, and without any disturbing hotspots (spots of light). These properties make it possible to reduce the spacing required between the cover and the LED light source, and to optimize the wall thickness of the component.

**PLEXIGLAS® LED White OV606**

**FOR BACKLIGHTING**

Molding compounds made from this special color appear white in incident light and create a satiniced surface in extruded parts. Available in grades PLEXIGLAS® 7N, 7H and zk6BR.

**PLEXIGLAS® LED White OV200**

**FOR BACKLIGHTING**

Special color for higher transmission, while retaining the light-diffusing properties. Available in grades PLEXIGLAS® 7N, 7H and 8N zk6BR.
Molding compounds of the PLEXIGLAS® Hi-Gloss family are particularly suitable for injection-molding. Their high brilliance makes it possible to manufacture high-gloss, Class A surfaces. The color Black 9V022 was specially developed for so-called piano black applications. This grade offers an extremely intensive degree of blackness as well as outstanding weather resistance.

Applications: add-on automotive body parts (e.g., pillar panels, spoilers, roof elements), decorative trim in car interiors and exteriors, mirror housings etc.

### PLEXIGLAS® Hi-Gloss 8N HIGH BRILLIANCE
- Molding compound with high heat deflection temperature under load
- Good flow and melt viscosity

### PLEXIGLAS® Hi-Gloss zk6BR HIGH BRILLIANCE
- Impact-modified compound based on polymethyl methacrylate (PMMA)

### PLEXIGLAS® Hi-Gloss FT15 HIGH BRILLIANCE
- High heat deflection temperature under load combined with good flow

### PLEXIGLAS® Hi-Gloss NTA-1 HIGH BRILLIANCE
- Slightly impact-modified molding compound with high heat deflection temperature under load based on polymethyl methacrylate (PMMA)

### PLEXIGLAS® Hi-Gloss NTA-3 HIGH BRILLIANCE
- Molding compound with higher heat deflection temperature under load based on polymethylmethacrylate (PMMA)

### PLEXIGLAS® Hi-Gloss NTA-5 HIGH BRILLIANCE
- Highly impact-modified compound based on polymethyl methacrylate (PMMA) that simultaneously offers a higher heat deflection temperature

### PLEXIGLAS® Hi-Gloss NTX-8 • PLEXIGLAS® Hi-Gloss NTX-15 HIGH BRILLIANCE
- Molding compounds with improved wipe resistance
- Significantly increased ease of flow
- Improved demolding behavior
- Less tendency to form weld lines
### Special Grades

#### OPTICAL GRADES

Depending on requirements for optical applications different product grades are available.

**PLEXIGLAS® eq**

For premium articles the molding compounds PLEXIGLAS® 7N and 8N can be supplied on request in “tested optical quality”.

**PLEXIGLAS® 8N SuPure**

PLEXIGLAS® SuPure is available for the production of optical parts which have to fulfill highest requirements. Specific features of PLEXIGLAS® 8N SuPure are its optimized pellet shape and the fact that it undergoes extended quality assurance tests.

#### MEDICAL TECHNOLOGY GRADE

CYROLITE® products are impact-resistant thermoplastic molding compounds based on methacrylate. They show remarkable clarity and light transmission for a multiphase polymer. Their melt viscosity is similar to that of standard PLEXIGLAS® molding.

#### AUXILIARY AGENTS

**ACRIFIX® sp**

- ACRIFIX® sp is a cylinder/barrel cleaning agent of high molecular weight, based on polymethyl methacrylate (PMMA).
- ACRIFIX® sp is used both for switching from one type of plastic to another and for changing colors. It remains rubbery-elastic even at high temperatures.

#### MOLDING COMPOUNDS WITH SPECIAL ADDITIVES

Standard molding compounds with special properties are available on request. These include:

- Increased UV absorption
- UV transmission
- Easy mold release, especially for particularly complex shapes to minimize the risk of demolding fracture. The mold release agent causes no haze.
SPECIAL COLORS

We offer a variety of special colors. Among others, these include further colors for signal applications and lighting engineering, as well as ones with good hiding power for coextrusion. Further information on the availability of special colors is available on request.

AMECA*-listed colors are available that can be employed for automotive signal purposes. They meet the requirements of SAE J 576.

*Automotive Manufacturers Equipment Compliance Agency

COLORS

PLEXIGLAS® COLORS

Standard colors are identified by a five-digit number after the color name. The 1st digit stands for the main color (in analogy to RAL):

0 = White
1 = Yellow
2 = Orange
3 = Red
4 = Purple
5 = Blue
6 = Green
7 = Gray
8 = Brown
9 = Black and Clear

DELIERY

PHYSICAL FORMS

PLEXIGLAS® molding compounds are supplied in injection molding and extrusion quality as pellets of uniform size.

PACKAGING

No charge is made for standard packaging. All forms of packaging ensure that the molding compound is delivered in such a way that it normally requires no predrying. If correctly stored, the protection offered by the packaging means that very little moisture is absorbed even after several months’ storage.

Despite the described protection of the molding compound by our specific packaging predrying is recommended for usage in regions with high humidity.

INSPECTION AND OTHER CERTIFICATES

An inspection certificate in line with EN 10204-3.1 can be provided on request.

AVAILABILITY

PLEXIGLAS® molding compound in crystal-clear and standard colors is normally available at short notice. All other molding compounds are manufactured to order, subject to certain minimum quantities. Color matching and new colors on request, at a charge.
# Mechanical properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Standard ISO 527</th>
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<th>Standard ISO 527</th>
<th>Standard ISO 179/14U</th>
<th>Vicat softening temperature (180°C)</th>
<th>Temp. of deflection under load (0.45 MPa)</th>
<th>Flammability UL 94 (1.6 mm thickness)</th>
<th>Melt volume rate, MVR (260/10)</th>
<th>Transmittance, ( \tau ) (3 mm)</th>
<th>Refractive index (3 mm)</th>
<th>Density (g/cm³)</th>
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# Other properties

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## Properties of selected molding compounds

All listed technical data are typical values intended for your guidance. They are given without obligation and do not constitute a materials specification. We will be pleased to state the properties of other grades of PLEXIGLAS® molding compound on request. The properties of PLEXIGLAS® molding compounds are available at www.campusplastics.com.
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® = registered trademark

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properties in the legal sense is intended or implied. We reserve the right to make any
changes according to technological progress or further developments. The customer is
not released from the obligation to conduct careful inspection and testing of incoming
goods. Performance of the product described herein should be verified by testing, which
should be carried out only by qualified experts in the sole responsibility of a customer.
Reference to trade names used by other companies is neither a recommendation, nor
does it imply that similar products could not be used.

Sales Range and technical data subject to alteration.

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