

Technical Information



PLEXIGLAS® V825-UVA5A

Overview

Plexiglas® V825-UVA5A is a thermoplastic acrylic resin formulated for injection molding and extrusion applications. It is formulated for specialty lighting packages requiring specific UV transmission requirements. Plexiglas® V825-UVA5A has excellent weatherability and optical properties allowing it to excel in applications requiring outdoor stability, stability in high intensity discharge lighting environments, high quality surface appearance and/or precision optics. Plexiglas® V825-UVA5A is easy to process due to its exceptional thermal stability, extrusion melt strength, and excellent tool surface reproduction and release properties. It has excellent resistance to many chemicals including solutions of inorganic acids, alkalis and aliphatic hydrocarbons such as VM&P naphtha and heptane. Additionally, it is virtually unaffected by a wide range of commercial products including many beverages, foodstuffs, detergent solutions and cleaners.

Automotive Specifications

- CHRYSLER MS-DB-14
- GM GMP.PMMA.012

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.18 g/cm ³	1.18 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.7 g/10 min	3.7 g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0E-3 to 6.0E-3 in/in	0.20 to 0.60 %	ASTM D955
Water Absorption (24 hr)	0.30 %	0.30 %	ASTM D570
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	450000 psi	3100 MPa	ASTM D638
Tensile Strength (Break)	10200 psi	70.3 MPa	ASTM D638
Tensile Elongation (Break)	6.0 %	6.0 %	ASTM D638
Flexural Modulus	450000 psi	3100 MPa	ASTM D790
Flexural Strength (Break)	15000 psi	103 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	0.30 ft-lb/in	16 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (M-Scale)	93	93	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load ¹			ASTM D648
66 psi (0.45 MPa), Annealed	221 °F	105 °C	
264 psi (1.8 MPa), Annealed	208 °F	98.0 °C	
Vicat Softening Temperature			
--	232 °F	111 °C	ASTM D1525 ²
--	219 °F	104 °C	ASTM D1525 ³
Thermal Conductivity	1.3 Btu-in/hr/ft ² /°F	0.19 W/m/K	ASTM C177
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating	HB	HB	UL 94
Optical	Nominal Value (English)	Nominal Value (SI)	Test Method
Refractive Index ⁴	1.490	1.490	ASTM D542
Light Transmittance (125.0 mil (3175 µm))	92.0 %	92.0 %	ASTM D1003
Haze (125.0 mil (3175 µm))	< 1.00 %	< 1.00 %	ASTM D1003
Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
ASTM Classification	PMMA 0133V3	PMMA 0133V3	ASTM D788
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	190 to 200 °F	88 to 93 °C	

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	< 0.10 %	< 0.10 %
Suggested Shot Size	50 %	50 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	420 °F	216 °C
Middle Temperature	430 °F	221 °C
Front Temperature	440 °F	227 °C
Nozzle Temperature	430 °F	221 °C
Processing (Melt) Temp	< 520 °F	< 271 °C
Mold Temperature	150 to 200 °F	66 to 93 °C
Injection Rate	Moderate	Moderate
Back Pressure	100 psi	0.689 MPa
Screw Speed	50 to 100 rpm	50 to 100 rpm
Screw L/D Ratio	15.0:1.0 to 20.0:1.0	15.0:1.0 to 20.0:1.0
Screw Compression Ratio	2.0:1.0 to 2.5:1.0	2.0:1.0 to 2.5:1.0
Vent Depth	2.0E-3 in	0.051 mm

Notes

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

¹ Annealing cycle: 4hrs @ 203°F

² Rate A (50°C/h), Loading 1 (10 N)

³ Rate A (50°C/h), Loading 2 (50 N)

⁴ ND @ 72°F

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