Delivery

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

Terms of Delivery
For information about minimum order quantities of our molding compounds please refer to our separate booklet “Terms of Delivery”, which we will be pleased to send you on request. Email: plexiglas.polymers@evonik.com

Packaging
- 25 kg, two-ply polyethylene bag
- 500 kg carton with polyethylene lining
- Further forms of packaging, such as silos, on request

No charge is made for standard packaging.

All forms of packaging ensure that the molding compound is delivered in such a way that it is ready for processing. If correctly stored, the protection offered by the packaging means that very little moisture is absorbed even after several months’ storage.

Inspection and Other Certificates
An inspection certificate in line with DIN EN 10204-3.1 can be provided on request for orders under our terms of delivery.

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.
General Remarks

Product Overview

PLEXIGLAS® Molding Compounds

(Impact-Modified)

PLEXIGLAS® Molding Compounds

(Enhanced Heat Resistance)

PLEXIGLAS® df Molding Compounds

(Light-Diffusing)

PLEXIGLAS® Molding Compounds

Optical Quality

PLEXALLOY® Molding Compounds

Special Grades

PLEXIGLAS® CoolTouchTM Infrared-Reflecting Molding Compound

PLEXIGLAS® le Molding Compound for Easy Mold Release

CYROLITE® Medical Technology Grades

PLEXIFIX® sp Cylinder/Barrel Cleaning Agent

Standard Colors

Properties of Selected

Mechanical, thermal, optical

Molding Compounds

and other properties

Delivery

Physical forms, terms of delivery, packaging, inspection and other certifiers, availability

Table of Contents

2

3

4

5

6

7

8

9

10

11

12

13

14

15

* R.I. = refractive index
PLEXIGLAS® molding compounds
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 which are indispensable for manufacturing high-quality parts by injection molding, injection blow molding and extrusion.

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%, i.e. show only 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. In white and other colors, this in turn provides properties of unparalleled quality for lighting engineering, such as excellent diffusion combined with relatively low light loss.

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.

Recyclable
Owing to their chemical composition, PLEXIGLAS® molding compounds are uniquely suitable for chemical recycling and materials 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 mar resistance of all thermoplastics. This enables them to conserve their high gloss even after prolonged use.

Food contact approvals

Please consult us on other grades and on colored molding compounds.

Certified quality
Evonik Röhm GmbH has combined its management systems for environmental protection, safety, health and quality in an integrated management system and is certified in accordance with DIN EN ISO 9001:2000 and ISO 14001:2004. Moreover the quality management system of the Molding Compounds Product Line has satisfied the stringent automotive standards ISO TS 16949:2002 (of the Association of the German 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.
PLEXIGLAS® Molding Compounds

PLEXIGLAS® 6N
• molding compound with good flow and a low heat deflection temperature under load
• application: injection molding of thin-walled parts with long flow paths

PLEXIGLAS® 7N
• 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
• 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 [tail-lights, etc.])
PLEXIGLAS® 7H
- 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
- variant of PLEXIGLAS® 7H with improved flow
- application: extrusion of profiles and sheets for lighting engineering

PLEXIGLAS® 8H
- 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

Molding Compounds with Special Additives
Standard molding compounds with special properties such as increased UV absorption or UV transmission are available on request.
PLEXIGLAS® zk Molding Compounds (Impact-Modified)

PLEXIGLAS® zk molding compounds are suitable for extruding and coextruding profiles and sheets, as well as for injection molding.

zkBR Series
With its special optical characteristics and balanced property spectrum, the zkBR series is the basis for impact-modified PLEXIGLAS® molding compounds.
PLEXIGLAS® zk4BR
PLEXIGLAS® zk5BR
PLEXIGLAS® zk6BR
zkHC Series
This series is characterized by even higher stress crack resistance than that of PLEXIGLAS® zk8R molding compounds.
PLEXIGLAS® zk4HC
PLEXIGLAS® zk5HC
PLEXIGLAS® zk6HC

zkHF Series
The special feature of this series of PLEXIGLAS® molding compounds as compared with other impact-modified grades is its excellent flow.
PLEXIGLAS® zk5HF
PLEXIGLAS® zk6HF

zk Series
These grades show much higher impact strength than the above-mentioned molding compounds.
PLEXIGLAS® zk20
PLEXIGLAS® zk30
PLEXIGLAS® zk40
PLEXIGLAS® zk50
PLEXIGLAS® Molding Compounds  
(High Heat Deflection Temperature under Load)

PLEXIGLAS® FT15
PLEXIGLAS® FT15 is a new molding compound based on PMMA with a higher heat deflection temperature (Vicat softening temperature: 115 °C) combined with improved flow.
PLEXIGLAS® FT15 is particularly 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.

PLEXIGLAS® hw55
PLEXIGLAS® hw55 is particularly suited for injection-molded technical parts for applications subjected to high thermal stress.
PLEXIGLAS® 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 ease of processing.

PLEXIMID®
PLEXIMID®, a product based on polymethyl methacrylimide (PMMI) is available on request for applications that call for a particularly high heat deflection temperature under load.
PLEXIGLAS® df Molding Compounds (Light-Diffusing)

Molding compounds with very good light diffusion at minimum light loss.
PLEXIGLAS® df21
PLEXIGLAS® df22
PLEXIGLAS® df23
Available in grades PLEXIGLAS® 7H, 7N, 8N and zk6BR.
Application: P-O-P displays, lighting, advertising and decorative items, and many other uses

PLEXIGLAS® Molding Compounds – Optical Quality

PLEXIGLAS® oq
On request, molding compounds PLEXIGLAS® 7N and 8N are supplied in „tested optical quality” for premium articles.
PLEXIGLAS® POQ

Specialty molding compound of high optical purity for applications that call for particularly high transmission efficiency in long light paths. One example is the manufacture of optical lightguides for backlight units in TFT-LCD displays.

The products of the POQ range differ in their flow properties, which are adjusted to the desired processing technology.

PLEXIGLAS® POQ66

Suitable for extrusion due to its...
- balanced combination of melt elasticity and flow properties
- high heat deflection temperature under load
- good mechanical properties for post-treatment of extruded sheets

PLEXIGLAS® POQ64

Suitable for injection molding and injection-compression molding due to its...
- excellent flow properties
- optimized demolding behavior
- accurate reproduction of mold surfaces

PLEXIGLAS® POQ62

Suitable for injection molding, injection-compression molding and coextrusion due to its...
- outstanding flow properties
- highly accurate reproduction of microstructures
PLEXALLOY® Molding Compounds

PLEXALLOY® molding compounds are particularly suitable for injection molding technical parts. Owing to their superior brilliance, high-gloss (Class A) surfaces can be obtained. They are normally supplied in opaque colors.
Applications: Automotive body parts (e.g. pillar covers, spoilers, mirror housings etc.)

PLEXALLOY® NTA-1
- Impact-modified compound based on polymethyl methacrylate (PMMA) with a high heat deflection temperature under load

PLEXALLOY® NTA-3
- Slightly impact-modified compound based on polymethyl methacrylate (PMMA) with a higher heat deflection temperature under load
Special Grades

Infrared-Reflecting Molding Compound:
PLEXIGLAS® CoolTouch™
- Molding compound that reflects heat rays directly at the surface. That reduces heat buildup in dark plastic components used outdoors by 15 to 20 percent.
- PLEXIGLAS® CoolTouch™ is suitable for all thermoplastic processing methods, including coextrusion.
Colors on request (email: cooltouch@evonik.com)

Molding Compound for Easy Mold Release:
PLEXIGLAS® le
- Molding compound used for particularly complex mold shapes to minimize the risk of demolding fracture
- The mold release agent causes no haze.

Medical Technology Grades:
CYROLITE®
CYROLITE® products are impact-resistant thermoplastic molding compounds based on methacrylate. They show remarkable clarity and light transmission for a multiphase polymer. The melt viscosity is similar to that of standard PLEXIGLAS® molding compound. CYROLITE® can be injection molded, extruded, injection blow-molded and extrusion blow-molded. Please address your inquiries to: cyrolite@evonik.com

Auxiliary Agents:
PLEXIFIX® sp Cylinder/Barrel Cleaning Agent
- PLEXIFIX® sp is a cylinder/barrel cleaning agent of high molecular weight, based on polymethyl methacrylate (PMMA).
- PLEXIFIX® 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.
- PLEXIFIX® sp can be used sparingly because of its good cleaning effect.
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

AMECA
(Automotive Manufacturers Equipment Compliance Agency)

The marked grades and colors are listed with AMECA and can therefore be employed for automotive signal purposes. They meet the requirements of SAE J 576.

Special Colors

We offer a variety of special colors. Among others, these include further colors for signalling 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 (email: plexiglas.polymers@evonik.com).

<table>
<thead>
<tr>
<th>Color</th>
<th>No.</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>White</td>
<td>06230</td>
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</tr>
<tr>
<td>White</td>
<td>06501</td>
<td></td>
</tr>
<tr>
<td>White</td>
<td>06521</td>
<td></td>
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<tr>
<td>White</td>
<td>06531</td>
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<tr>
<td>Yellow</td>
<td>13115</td>
<td>AMECA</td>
</tr>
<tr>
<td>Orange</td>
<td>23085</td>
<td>AMECA</td>
</tr>
<tr>
<td>Orange</td>
<td>23105</td>
<td>AMECA</td>
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<tr>
<td>Red</td>
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<tr>
<td>Red</td>
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<tr>
<td>Gray</td>
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<td>Gray</td>
<td>7V274</td>
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<tr>
<td>Black</td>
<td>90114</td>
<td>IR-transmitting</td>
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<tr>
<td>Black</td>
<td>9V022</td>
<td>Piano Black</td>
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</table>
## Typical Properties

<table>
<thead>
<tr>
<th>Physical Property</th>
<th>Unit</th>
<th>PLEXIGLAS® 6N</th>
<th>PLEXIGLAS® 7N</th>
<th>PLEXIGLAS® 8N</th>
<th>PLEXIGLAS® 7H</th>
<th>PLEXIGLAS® 8H</th>
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</thead>
<tbody>
<tr>
<td><strong>Mechanical</strong></td>
<td></td>
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<td></td>
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</tr>
<tr>
<td>Tensile modulus (1 mm/min)</td>
<td>MPa</td>
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<td>3200</td>
<td>3300</td>
<td>3200</td>
<td>3300</td>
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<tr>
<td>Yield stress (50 mm/min)</td>
<td>MPa</td>
<td>ISO 527</td>
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<tr>
<td>Yield strain (50 mm/min)</td>
<td>%</td>
<td>ISO 527</td>
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<tr>
<td>Nominal strain at break</td>
<td>%</td>
<td>ISO 527</td>
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</tr>
<tr>
<td>Stress at break (5 mm/min)</td>
<td>MPa</td>
<td>ISO 527</td>
<td>67</td>
<td>73</td>
<td>77</td>
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<tr>
<td>Stress at break (5 mm/min)</td>
<td>%</td>
<td>ISO 527</td>
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<td>3,5</td>
<td>5,5</td>
<td>5,5</td>
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<tr>
<td>Charpy impact strength (23 °C)</td>
<td>kJ/m²</td>
<td>ISO 179/1eU</td>
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<tr>
<td><strong>Thermal</strong></td>
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<tr>
<td>Vicat softening temperature (B/50)</td>
<td>°C</td>
<td>ISO 306</td>
<td>96</td>
<td>103</td>
<td>108</td>
<td>103</td>
</tr>
<tr>
<td>Temp. of deflection under load (0,45 MPa)</td>
<td>°C</td>
<td>ISO 75</td>
<td>100</td>
<td>103</td>
<td>100</td>
<td></td>
</tr>
<tr>
<td>Flammability UL 94 (at 1.6 mm nom. thickn.)</td>
<td>Class</td>
<td>IEC 707</td>
<td>HB</td>
<td>HB</td>
<td>HB</td>
<td>HB</td>
</tr>
<tr>
<td><strong>Rheological</strong></td>
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<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>Melt volume rate, MVR (230/3,8)</td>
<td>cm³/10 min</td>
<td>ISO 1133</td>
<td>12</td>
<td>6</td>
<td>3</td>
<td>1,4</td>
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<tr>
<td><strong>Optical</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Transmittance, $\tau_{\text{D65}}$</td>
<td>%</td>
<td>DIN 5036</td>
<td>92</td>
<td>92</td>
<td>92</td>
<td>92</td>
</tr>
<tr>
<td>Refractive index</td>
<td></td>
<td>ISO 489</td>
<td>1,49</td>
<td>1,49</td>
<td>1,49</td>
<td>1,49</td>
</tr>
<tr>
<td><strong>Other</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Density</td>
<td>g/cm³</td>
<td>ISO 1183</td>
<td>1,19</td>
<td>1,19</td>
<td>1,19</td>
<td>1,19</td>
</tr>
</tbody>
</table>

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 on CAMPUS diskettes.
Table of Contents

General Remarks 3
Product Overview 4
PLEXIGLAS® Molding Compounds 6
PLEXIGLAS® Molding Compounds (Impact-Modified) 8
PLEXIGLAS® Molding Compounds (High Heat Deflection Temperature under Load) 9
PLEXIGLAS® df Molding Compounds (Light-Diffusing) 9
PLEXIGLAS® Molding Compounds Optical Quality 11
PLEXALLOY® Molding Compounds Special Grades 12
PLEXIGLAS® CoolTouch™ Infrared-Reflecting Molding Compound 12
PLEXIGLAS® le Molding Compound for Easy Mold Release 12
CYROLITE® Medical Technology Grades 12
PLEXIFIX® sp Cylinder/Barrel Cleaning Agent 12
Standard Colors 13
Properties of Selected Molding Compounds 14
Mechanical, thermal, optical and other properties 14
Delivery 17
Physical forms, terms of delivery, packaging, inspection and other certificates, availability

* o. B. = on request

Table of Contents
## General Remarks

3

## Product Overview

4

PLEXIGLAS® Molding Compounds

6

PLEXIGLAS® Molding Compounds (Impact-Modified)

8

PLEXIGLAS® Molding Compounds (High Heat Deflection Temperature under Load)

8

PLEXIGLAS® df Molding Compounds (Light-Diffusing)

9

PLEXIGLAS® Molding Compounds: Optical Quality

11

PLEXALLOY® Molding Compounds

Special Grades

PLEXIGLAS® CoolTouch® Infrared-Reflecting Molding Compound

12

PLEXIGLAS® le Molding Compound for Easy Mold Release

12

CYROLITE® Medical Technology Grades

12

PLEXIFIX® sp Cylinder/Barrel Cleaning Agent

12

Standard Colors

13

Properties of Selected Mechanical, thermal, optical and other properties

14

Molding Compounds

Delivery

Physical forms, terms of delivery, packaging, inspection and other certificates, availability

## Table of Contents

| PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® | PLEXIGLAS® |
|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds | Molding Compounds |
| CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® |
| CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® | CoolTouch® |
| Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades | Medical Technology Grades |
| Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent | Cylinder/Barrel Cleaning Agent |

* HB = holographic
## Delivery

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

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For information about minimum order quantities of our molding compounds please refer to our separate booklet "Terms of Delivery", which we will be pleased to send you on request. Email: plexiglas.polymers@evonik.com

### Packaging
- 25 kg, two-ply polyethylene bag
- 500 kg carton with polyethylene lining
- Further forms of packaging, such as silos, on request

No charge is made for standard packaging.

All forms of packaging ensure that the molding compound is delivered in such a way that it is not required for predrying. If correctly stored, the protection offered by the packaging means that very little moisture is absorbed even after several months’ storage.

### Inspection and Other Certificates
An inspection certificate in line with DIN 19234-3.1 can be provided on request for orders under our terms of delivery.

### Availability
PLEXIGLAS® molding compound is 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.

---

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telefax: +49 6151 18-3177
plexiglas.polymers@evonik.com
www.plexiglas.net
www.evonik.com

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Evonik Industries’ Business Unit Performance Polymers consists of three world market leaders: PLEXIGLAS® molding compounds sold under the PLEXIGLAS® trademark in the European, Asian, African and Australian Continents,再加上下列注册商标：PLEXALLOY®、PLEXIFIX®、PLEXIMID® and CYROLITE® in the Americas. This information and all further technical advice is based on our present knowledge and experience. However, it implies no liability or other legal responsibility on our part, also with regard to the licensing third party intellectual property rights, especially patent rights. It is understood that the user assumes the legal risk in respect of the protection of any intellectual property rights. The use of the information and advice is at the user’s own risk. All data and advice are subject to change without notice, which shall be our sole and exclusive liability for such responsibility or guidance. Reference to trade names does not imply any guarantee, quality or approval by Evonik Industries. No liability can be assumed.

Sales Range and technical data subject to alteration.

March 2008
15/0808/03995 (en)
Sales Range

Molding Compounds

PLEXIGLAS® • PLEXALLOY® • PLEXIFIX® • PLEXIMID® • CYROLITE®

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Evonik Röhm GmbH, Darmstadt, Germany
Evonik Industries’ Business Unit Performance Polymers is a worldwide manufacturer of PMMA molding compounds sold under the PLEXIGLAS® trademark on the European, Asian, African and Australian Continents and under the trademark ACRYLITE® in the Americas.

This information and all further technical advice is based on our present knowledge and experience. However, it implies no liability or other legal responsibility on our part, also with regard to existing third party intellectual property rights, especially patent rights. Without this qualification, all statements, especially with regard to the accuracy of the information and the correctness of the technical advice, are subject to change.

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.

March 2008

15/0308/06095 (en)

Delivery

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

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Packaging
- 25 kg, two-ply polyethylene bag
- 500 kg carton with polyethylene lining
- Further forms of packaging, such as silos, on request

No charge is made for standard packaging.

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

Inspection and Other Certificates
An inspection certificate in line with EN 10204-3.1 can be provided on request for orders under our terms of delivery.

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 price.

Terms and Conditions

March 2008

15/0308/06095 (en)

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