

# Product Information

## PLEXIGLAS® Molding Compound: Recommendations on Materials for Extrusion Processing

### 1. Extrusion Lines

PLEXIGLAS® molding compound can be processed on all commercially available extrusion lines. General-purpose screws and barrels which are also suitable for other thermoplastics (e.g. PC, ABS etc.) can be used.

### 2. Screws

#### Standard steel grades:

Matl. No.	Abbreviation	Cr content [%]
1.8519	31CrMoV9	2.5
1.8550	34CrAlNi7	0.4-0.65

Proven treatment:

- Tempering to 1000-1200 N/mm<sup>2</sup>
  - Wearing surface and main flight nitrided.
- Chromium-plated screws (Cr layer thickness approx. 30 µ) can be advantageous for special

applications (e.g. extreme cleanliness requirements).

### 3. Barrels

Both nitrided barrels and bimetallic barrels are used.

#### Standard steel grades:

Matl. No.	Matl. No.	Matl. No.
1.8550	34CrAlNi7	0.4-0.65

### 4. Dies

Standard grades of PLEXIGLAS® do not cause any corrosion. The standard steel grades used in tool construction can therefore be used. Good polishability is an essential requirement. For this reason, high-purity, vacuum-melted chromium steels are generally used.

#### übliche Stahlsorten:

Stoff-Nr.	Kurzname	Cr-Gehalt [%]
1.2083	X40 Cr13	12.5-13.5
1.2379	X155CrVMo121	11-12
1.2343	X38CrMoV51	4.8-5.5
1.2344	X40CrMoV51	4.8-5.5

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