



Designation: D 5436 – 99

Standard Specification for Cast Poly(Methyl Methacrylate) Plastic Rods, Tubes, and Shapes¹

This standard is issued under the fixed designation D 5436; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope *

1.1 This specification covers poly(methyl methacrylate) rods, tubes, and other shapes produced by casting or machining cast blanks. This specification does not apply to heat-formed and molded or extruded parts and shapes, or sections that are made by assembling or joining two or more pieces.

NOTE 1—The properties included in this specification are those required to identify the types and grades of materials covered. There may be other requirements necessary to identify particular characteristics.

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 2—There is no known ISO equivalent to this standard.

2. Referenced Documents

2.1 ASTM Standards:

- D 542 Test Method for Index of Refraction of Transparent Organic Plastics²
- D 570 Test Method for Water Absorption of Plastics²
- D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing²
- D 638 Test Method for Tensile Properties of Plastics²
- D 648 Test Method for Deflection Temperature of Plastics Under Flexural Load²
- D 792 Test Methods for Specific Gravity (Relative Density) and Density of Plastics by Displacement²
- D 883 Terminology Relating to Plastics²
- D 1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics²
- D 1600 Terminology of Abbreviated Terms Relating to Plastics²
- D 3892 Practice for Packaging/Packing of Plastics³
- E 29 Practice for Using Significant Digits in Test Data to

Determine Conformance with Specifications⁴

3. Terminology

3.1 The terminology used in this specification is in accordance with Terminology D 883 and Terminology D 1600.

4. Classification

4.1 *Types*—This specification covers two types of cast methacrylate plastics:

4.1.1 *Type UVA*—Material having ultraviolet-lightabsorbing properties as shown in Table 1.

4.1.2 *Type UVT*—Material not subject to the light-absorbing properties shown in Table 1.

4.2 *Finish*—Castings may be specified with the following finishes:

4.2.1 *Finish 1*—Rods, tubes, and shapes having a smooth surface finish obtained either in the casting process or by highly polishing the surface.

4.2.2 *Finish 2*—Rods, tubes, and shapes having a rough, unfinished surface which may be frosted, abraded, sanded, machined, or as-cast.

NOTE 3—The sawed ends of Finish 1 and Finish 2 rods, tubes, and shapes are not polished.

5. General Requirements

5.1 Finish 1 and Finish 2 cast tubes are subject to the following permissible variations from the specified dimensions:

5.1.1 Cast tubes may be specified with either Type A or Type B wall thickness tolerances as listed in Table 2. Type A tolerances are specified for applications where wall thickness is critical to performance, otherwise Type B is generally specified.

5.1.2 Cast tubes are subject to the outside-diameter tolerances listed in Table 3.

5.1.3 Cut-to-size lengths of cast tube are subject to the length tolerances listed in Table 4.

5.2 Finish 1 and Finish 2 cast rods are subject to the following dimensions and tolerances.

5.2.1 Cast rods are subject to the diameter tolerances listed in Table 5.

¹ This specification is under the jurisdiction of ASTM Committee D-20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

Current edition approved Nov. 10, 1999. Published February 2000. Originally published as D 5436 – 93. Last previous edition D 5436 – 93.

² *Annual Book of ASTM Standards*, Vol 08.01.

³ *Annual Book of ASTM Standards*, Vol 08.02.

⁴ *Annual Book of ASTM Standards*, Vol 14.02.

*A Summary of Changes section appears at the end of this standard.



TABLE 1 Detail Requirements for Cast Methacrylate Rods, Tubes, and Shapes

	Type UVA	Type UVT
Index of refraction, n_D , 23°C		
min:	1.48	1.48
max:	1.50	1.50
Specific gravity, 23/23°C (73.4/73.4°F)		
min:	1.18	1.18
max:	1.20	1.20
Spectral transmittance, %, max		
270 nm:	5	...
280 nm:	5	...
290 nm:	5	...
310 nm:	5	...
340 nm:	5	...
Luminous transmittance, %, min		
up to 4.7 mm (0.187 in.) thickness:	91	91
25.4 mm (1.00 in.) thickness:	89	89
greater than 25.4 mm (1.00 in.) thickness:	87	87
Haze, %, max	3.0	3.0
Deflection temperature under load at 1820 kPa (264 psi), °C	see Fig. 1	see Fig. 1
Water absorption at 23°C		
Gain in weight, 3.2 mm (0.125 in.) thick, %, max	0.8	0.8
Tensile strength at 23°C (73.4°F), min, MPa (psi)	55 (8000)	55 (8000)
Elongation at break, %, min	2	2

TABLE 4 Sizes and Permissible Length Tolerances for Cut-to-Length Cast Rod and Tube

Nominal Outside Diameter, mm (in.)	Permissible Length Tolerances, ±, mm (in.)
up to 76 (3.0)	2 (0.079)
up to 280 (11.0)	3 (0.118)
greater than 280 (11.0)	6 (0.236)

TABLE 5 Size and Permissible Tolerances for Diameter of Cast Rods

Size, Diameter, mm (in.)	Diameter Tolerances, ±, mm (in.)
up to 9.5 (0.375)	0.1 (0.005)
up to 25.4 (1.00)	0.2 (0.010)
up to 50.8 (2.00)	0.4 (0.015)
up to 76.2 (3.00)	0.8 (0.030)
up to 152.4 (6.00)	1.1 (0.045)
up to 304.8 (12.00)	1.5 (0.060)
greater than 304.8 (12.00)	2.5 (0.100)

TABLE 2 Sizes and Permissible Tolerances for Wall Thickness of Cast Tube

Nominal Wall Thickness, mm (in.)	Permissible Wall Thickness Tolerances, ±, mm (in.)	
	Type A	Type B
up to 4.7 (0.187)	0.5 (0.020)	not applicable
up to 6.4 (0.250)	0.6 (0.025)	1.1 (0.045)
up to 9.5 (0.375)	0.9 (0.035)	1.4 (0.055)
up to 12.7 (0.550)	1.1 (0.045)	1.5 (0.060)
up to 19.0 (0.750)	1.5 (0.060)	2.3 (0.090)
up to 25.4 (1.00)	3.8 (0.150)	not applicable
greater than 25.4 (1.00)	6.4 (0.250)	not applicable

TABLE 3 Sizes and Permissible Tolerances for Outside Diameter of Cast Tubes

Nominal Outside Diameter, mm (in.)	Outside Diameter Tolerances, ±, mm (in.)	Difference Between Maximum and Minimum Outside Diameter (One Tube), Not to Exceed, mm (in.)
up to 76.2 (3.0)	0.5 (0.020)	0.6 (0.025)
up to 98.4 (3.875)	0.8 (0.030)	1.0 (0.040)
up to 152.4 (6.00)	1.1 (0.045)	1.5 (0.060)
up to 304.8 (12.00)	1.6 (0.065)	2.0 (0.080)
greater than 304.8 (12.00)	3.2 (0.125)	not applicable

5.2.2 Cut-to-size lengths of cast rod are subject to the length tolerances listed in Table 4.

5.3 Tolerances for shapes other than simple rods and tubes depend upon the shapes themselves. Tolerances for these cast shapes are to be specified independently.

6. Detail Requirements

6.1 The following applies to all specified limits in this specification: For purposes of determining conformance with this specification an observed value or a calculated value shall be rounded to the nearest 1 MPa (100 psi) for tensile strength,

and for all other properties shall be rounded to the nearest unit in the last righthand place of figures used in expressing the limiting value, in accordance with the rounding method of Practice E 29.

6.2 The physical and optical properties in this specification are based on Finish 1 material unless otherwise specified.

6.3 Rods, tubes, and shapes shall conform to the detail requirements prescribed in Table 1 and, in addition, shall be so prepared as to conform to the following properties:

6.3.1 Bubbles or inclusions in cast rods, tubes, and shapes shall not exceed 3.96 mm (0.156 in.) in any dimension. No more than three such defects are permissible in any standard length greater than 122 cm (48 in.), or an outside diameter greater than 76.2 mm (3 in.). Bubbles or inclusions are not permitted in rods, tubes, or shapes less than 122 cm (48 in.) in length and less than 76.2 mm (3 in.) in outside diameter. Defects less than 1 mm (0.039 in.) shall be disregarded, unless grouped to form an objectionable pattern.

7. Number of Tests

7.1 The number of tests shall be consistent with the requirements of Sections 8 and 10.

8. Sampling and Specimen Preparation

8.1 Sampling shall be statistically adequate to satisfy the requirements of Section 10.

8.2 In the case of rods, tubes, or special shapes from which the required test specimens cannot be cut, the test specimens shall be prepared specially from the same raw materials and under conditions simulating the manufacture of the special size or shape. Otherwise a unit of the manufactured product shall be used for testing.

8.3 A batch or lot shall be constituted as a unit of manufacture as prepared for shipment, and may consist of product from two or more production runs.

9. Test Methods

9.1 The properties enumerated in this specification shall be determined in accordance with the following test methods: