

# ASTERITE<sup>®</sup> Acrylic Sheet

## Technical Data Sheet

### Masking

ASTERITE<sup>®</sup> Acrylic Sheet is supplied with a protective polyethylene film on the show face only. The back surface is not masked, so full benefit can be gained from vacuum-forming processes with automatic sheet loading facilities; in addition, static generation by removal of the bottom film is eliminated. It is possible to mould with the thermoformable show face film in place (except for ASTERITE<sup>®</sup> Velours and ASTERITE<sup>®</sup> Metal colours), this helps to protect the surface during subsequent reinforcement and trimming.

### Thermoforming Recommendations for ASTERITE<sup>®</sup> Acrylic Sheet

The recommended forming temperature for ASTERITE<sup>®</sup> Acrylic Sheet is in the range 150-170°C and ovens should be run 10-15°C above this.

If the sheet is too cold the desired shape will not be achieved, whilst over-heating can cause a reduction in the physical properties of the sheet. Extreme over-heating will cause degradation with blistering of the surface or splitting of the sheet during forming and must be avoided. It is recommended that some means of checking sheet, oven and mould temperatures is available in the moulding area.

### External Specifications

ASTERITE<sup>®</sup> Acrylic Sheet complies with ISO 7823-1 and EN 263.  
ASTERITE<sup>®</sup> Acrylic Sheet is approved by the French AFNOR "NF" quality mark.  
Perspex International Ltd is registered to ISO 9001 and ISO 14001.

### Table of Properties

Values quoted for properties of ASTERITE<sup>®</sup> Acrylic Sheet are the results of tests on representative samples and do not constitute a specification.

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Property	Test Method	Unit	Value
<b>General</b>			
Density	ISO 1183/A	g cm <sup>-3</sup>	1.2
Water Absorption	ISO 62/1	mg	29
Rockwell Hardness	(50mm <sup>2</sup> Sample)	M Scale	98
Colour Fastness - UV	ISO 2039/2	Grey Scale	5
Colour Fastness – Hot Water	ISO 4892-2	Grey Scale	5
<b>Thermal Properties</b>			
Specific Heat		Cal / g °C	0.35
Vicat Softening Point	BS2782 : 120 C	°C	> 105
Deflection Temperature Under Load	ISO 75 Method A	°C	98
Shaping Temperature (Optimum)		°C	150 - 170
Coefficient of Thermal Expansion - Linear	Din 5372 (0-50°C)	Mm K <sup>-1</sup>	7.7 x 10 <sup>-5</sup>
<b>Mechanical Properties</b>			
Tensile Strength	ISO R527 (5 mm/min)	MPa	70
Tensile Modulus	ISO R527 (5 mm/min)	MPa	3200
Flexural Strength	ISO 178 (2 mm/min)	MPa	120
Impact Strength – Charpy (unnotched)	ISO 179/1D	kJ M <sup>-2</sup>	12

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