

CHEMCAST[®]
The all purpose cell-cast acrylic sheet




SENSACRYL[®]
CELL CAST ACRYLIC SHEET



Sensacryl[®] Ultra is a trade mark of acrylic cell cast manufactured in Mexico by Plastiglas.

Sensacryl[®] Ultra sheets are recognized for its resistant properties and cosmetic brightness, that can be used for different applications. These acrylic sheets allow thermoformers to get sanitary results such as bathtubs, shower pans and bases, spas, sinks, etc.

This acrylic has more resistance to impacts, to chemical products and satins than any other acrylic of its type.

PRODUCT INFORMATION

Sensacryl® Ultra, cell cast acrylic sheet is validated by an external laboratory that meets American Standards ANSI-Z-124.1 and EN263:1997 for plastic bathtubs. Which means that guarantees chemical resistance, low water absorption, among other properties.

All sheets are protected with a thermoformable film to avoid quality damages during production. Material is packed with corrugated cardboard. Delivery quantity is subject to +/-10% from original ordered quantity.

To satisfy customer's requirements due innovation and designs, Plastiglas de Mexico offers customers color match service.

For more information about this, please look for the "Custom Color Matching Policy" and "Development of available colors Policy"

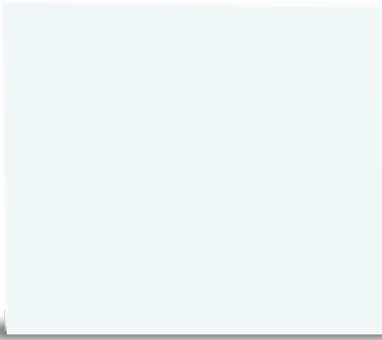


PHYSICAL AND MECHANICAL PROPERTIES

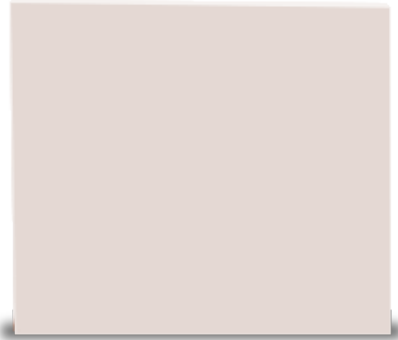
PROPERTY	TYPICAL VALUE (1)	TEST METHOD
MECHANICAL		
Tensile Strength minimum (mpa %)	60 3 - 7	ASTM D638
Elongation at Rupture (mpa)	3000 - 4000	ASTM D638
Modulus of Elasticity in Tension (lb /in)	19	ASTM D638
Impact Resistance Gardner (lb-ft/inch)	0.4 - 0.6	ASTM D5420
Impact Resistance Izod (kpsi)	0.4 - 0.6	ASTM D256
Flexural Strength (mpa)	14 - 16	ASTM D790
Modulus of Elasticity in Flexion (mpa)	1000 - 2000	ASTM D790
Rockwell Hardness	90 - 92	ASTM D785
Barcol Hardness	38 - 40	ASTM D2583
Specific Gravity (gr/cm ³)	1.19	ASTM D792
THERMAL		
Minimum recommended Vicat softening point	105 221(°F)	ISO 306 (A)
Forming Temperature	180 - 210 (°C) 356 - 410 (°F)	
Detection Temperature under load (264 psi) (°C) / (°F)	91 196	ASTM D648
MISCELLANEOUS		
Flamability (mm/min)	15 94 HB	ASTM D635
Chemical resistance	Ok	UL94
Cigarettes burn resistance	Ok	ANSI Z 124.1
Stain resistance	Ok	ANSI Z 124.1
Weather resistance (1000 hrs. tests of Xenon)	No evidence of degradation	ANSI Z 124.1
Water absorption (24 hrs.-23°C-73°F) (%)	0.2 - 0.3	ISO 62
Resistance to hot water	No evidence of blisters, fissures, cracks or discoloration	EN263:1997 section 9

These values are typical and should not be taken as specification.

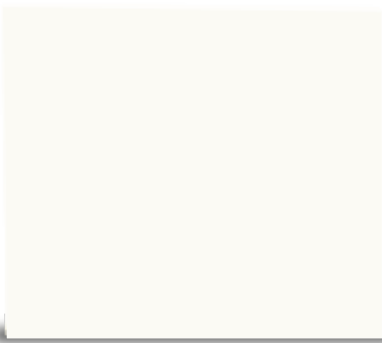
COLORS



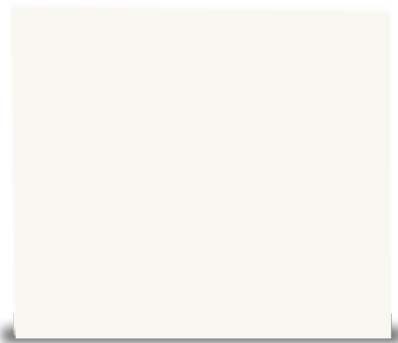
F-208
WHITE



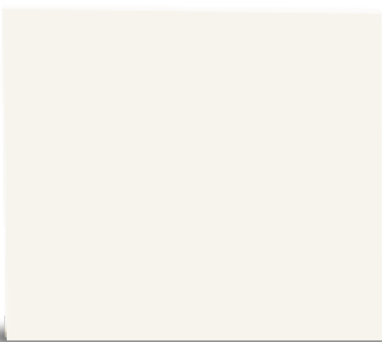
F-255
VISON



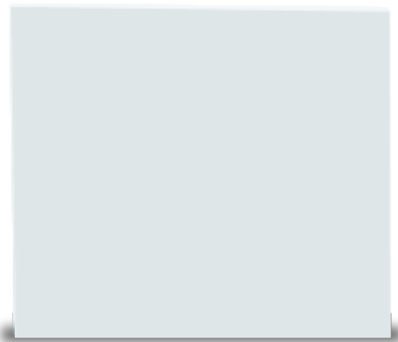
F-252
SOFT CREAM



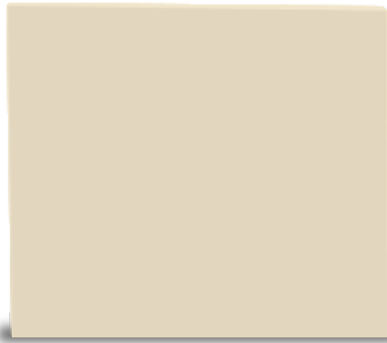
F-192
PERGAMON



F-141
MISTY PEACH



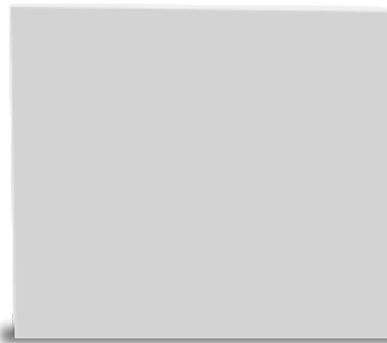
F-207
WHITE (IW28)



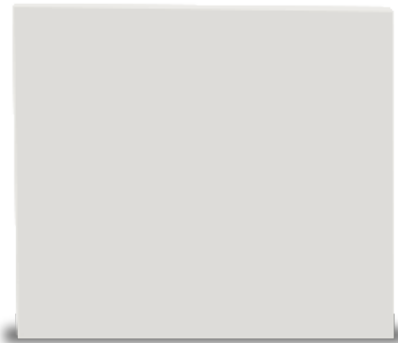
F-157
INDIAN IVORY



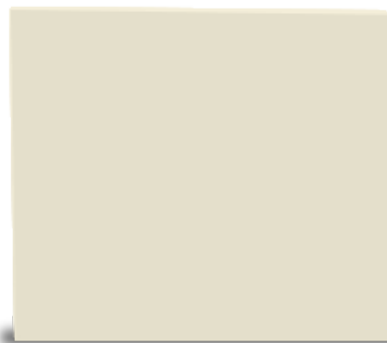
F-179
GRIS



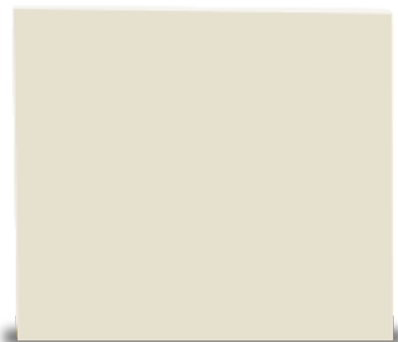
F-176
GRAY



F-180
EURO WHITE



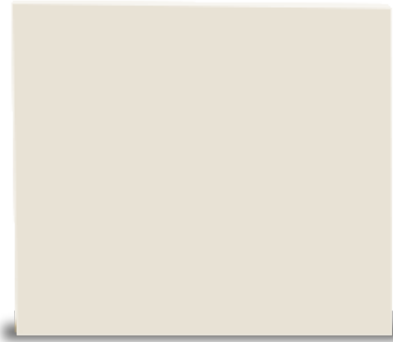
F-156
CHAMPAGNE



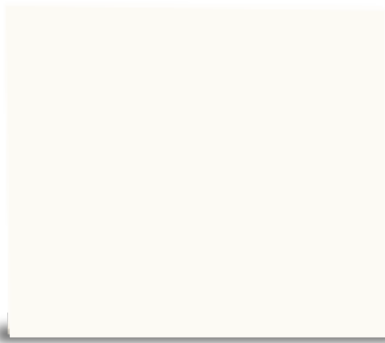
F-253
BONE



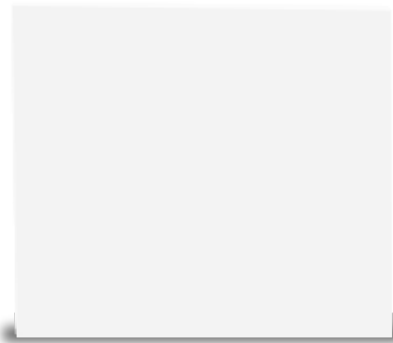
F-095
AGUAMAR



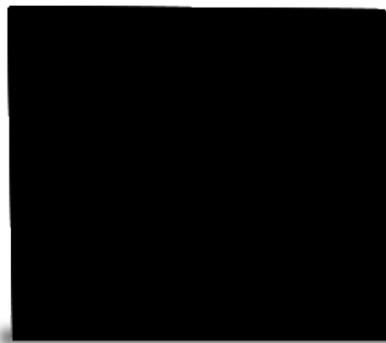
F-259
BISCUIT



F-198
ALMOND



F-209
WHITE

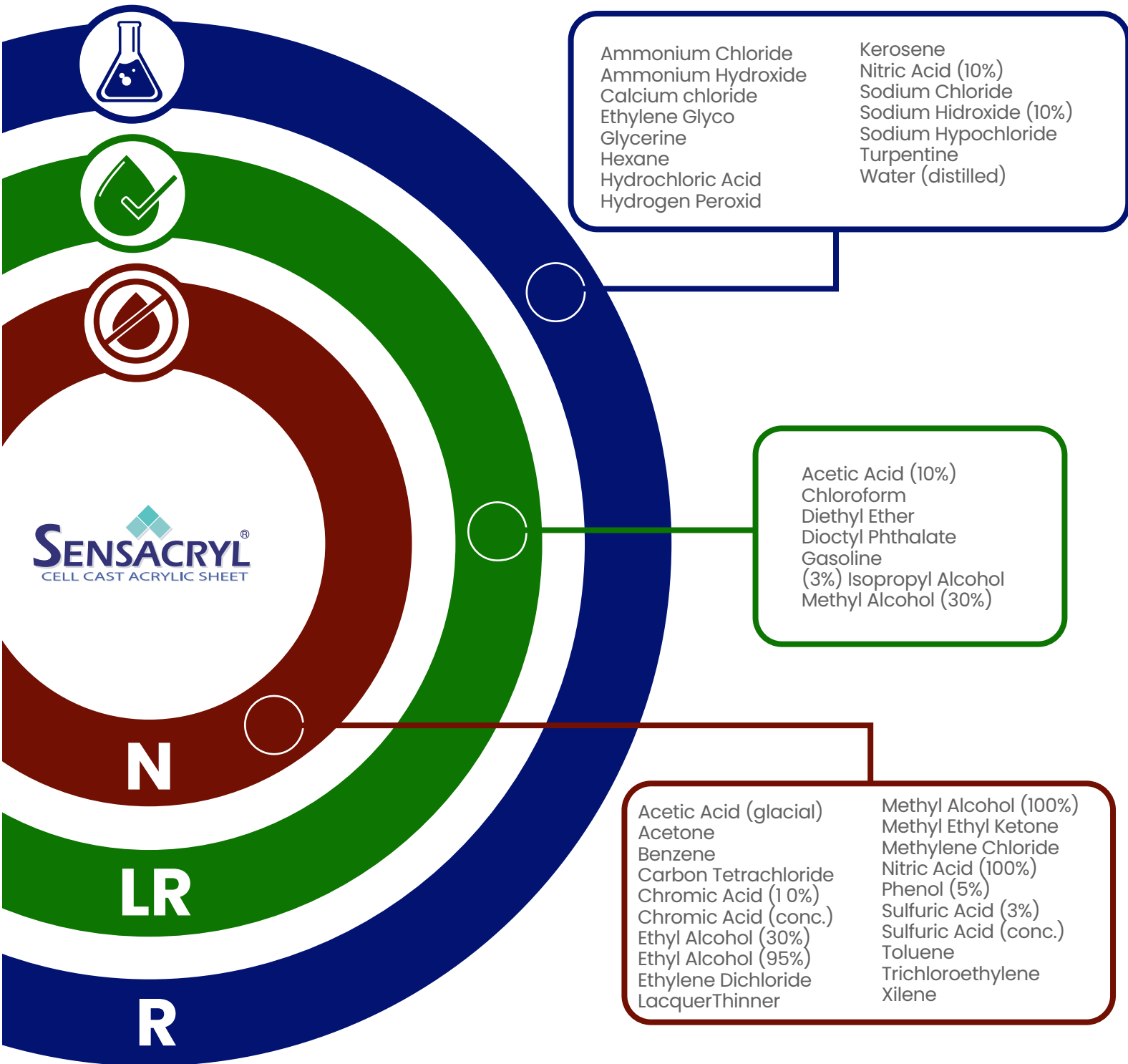


F-136
BLACK

SIZE AND THICKNESESS AVAILABLE

BASIC SIZES (in)	THICKNESS (in)
72"X 48"	0.125"
72"X 72"	0.157"
72"X 96"	

CHEMICAL RESISTANCE



The code is used to describe chemical resistance as follows:

R = RESISTANT

Acrylic cast withstand this substance for long periods and at temperature up to 120°F

LR = LIMITED RESISTANCE

Acrylic only resists the action of this substance for short periods at room temperature.

N = NOT RESISTANT

Acrylic is not resistant to this substance. It is swelled, attacked, dissolved or damaged in

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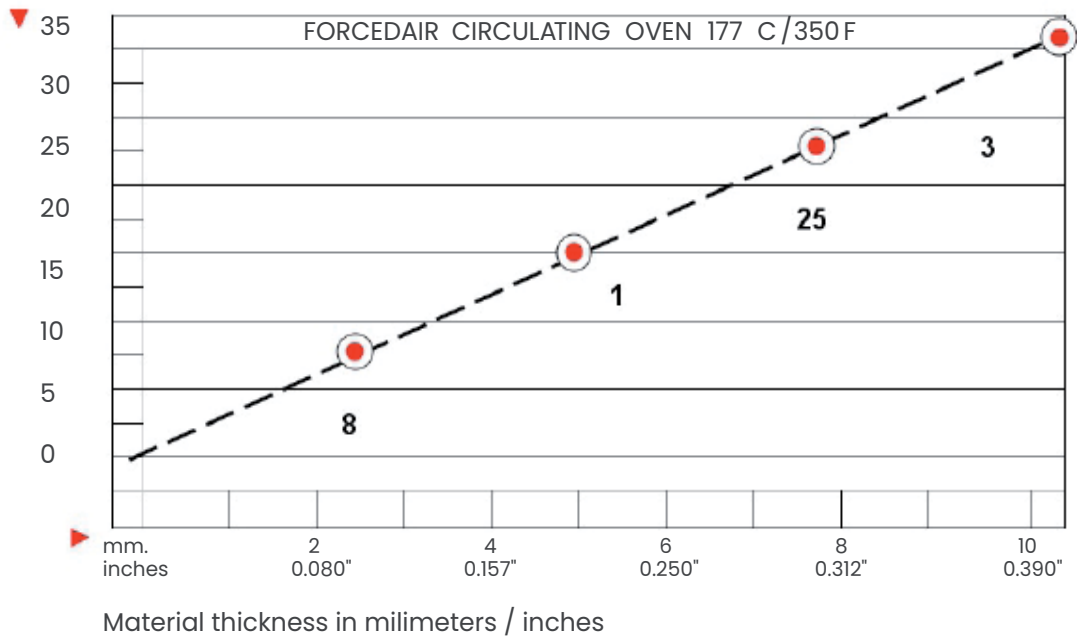
THERMOFORMING TROUBLE SHOOTING GUIDE FOR FIBER GLASSING

PROBLEM	CAUSE	SOLUTION
Cracking and swelling.	<ul style="list-style-type: none"> • Air bubble between the acrylic and polyester resin. • High temperature in polymerization of the resin. 	<ul style="list-style-type: none"> • Use multiple thin layers of fiberglass • Remove trapped air by rolling out layers. • Use suitable polyester resin for each season. • Adjust the catalyst concentration.
Bad mixing of resin and fiberglass.	<ul style="list-style-type: none"> • Shortage of polyester resin. • Viscosity of the resin too high. • Wrong type of glass roving. 	<ul style="list-style-type: none"> • Adjust the concentration of fiberglass against resin to 20-35%. • Select a fiberglass treated with a silene that is compatible with the polyester resin. • Adjust the viscosity of the
Insufficient polymerization.	<ul style="list-style-type: none"> • Concentration of catalyst too low. • Atmospheric temperature too low. 	<ul style="list-style-type: none"> • Increase catalyst concentration. • Raise and control atmospheric temperature.
Pits or pimples.	<ul style="list-style-type: none"> • Vacuum holes too large. • Vacuum rate too high. • Dirt or mold or sheet. 	<ul style="list-style-type: none"> • Use smaller holes. • Decrease vacuum rate or level. • Clean mold and/or sheet.
Mark-off.	<ul style="list-style-type: none"> • Dirt on sheet. • Dirt on mold. • Dirt in atmosphere. 	<ul style="list-style-type: none"> • Clean sheet. • Clean mold. • Clean vacuum forming area. • Isolate area if necessary and supply filtered air.
Distortion in finished part.	<ul style="list-style-type: none"> • Part removed too hot. • Uneven heating. • Mold design. 	<ul style="list-style-type: none"> • increase cooling time before Removing part. • Check temperature profile. • Correct mold design-stiffen to eliminate.

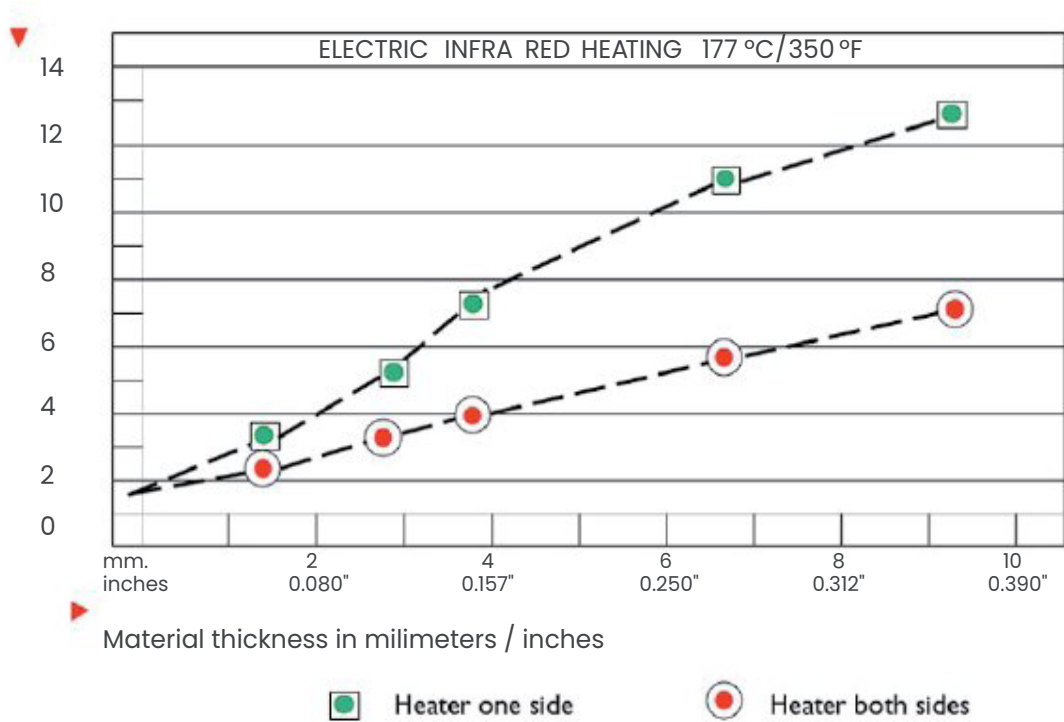
THERMOFORMING TROUBLE SHOOTING GUIDE FOR FIBER GLASSING

PROBLEM	CAUSE	SOLUTION
Tearing of part	<ul style="list-style-type: none"> • Mold design. • Sheet too hot. 	<ul style="list-style-type: none"> • Increase radius of corner. <p>Decrease heating time or temperature.</p>
Bridging	<ul style="list-style-type: none"> • Mold design. • Sheet too hot. 	<ul style="list-style-type: none"> • Add take-up blocks to pull out wrinkles. • Reduce time heaters, heating temperature, or reduce voltage. Move heater further away. Use screening if localized.
Poor definition of detail.	<ul style="list-style-type: none"> • Sheet too cold. 	<ul style="list-style-type: none"> • Increase heat input to
Incomplete forming.	<ul style="list-style-type: none"> • Low vacuum • Low air pressure. 	<ul style="list-style-type: none"> • Check for leaks in vacuum system. Increase number and/or size of vacuum holes. Add vacuum capacity • Increase volume and/or
Extreme wall thickness.	<ul style="list-style-type: none"> • Uneven sheet heating • Mold too cold • Sheet slipping • Stray air currents. 	<ul style="list-style-type: none"> • Check temperature profile • Change heaters to provide higher uniform mold surface temperature • Check cooling system for scale or plugs • Adjust clamping frame to provide uniform pressures • Provide protection to
Excessive sag .	<ul style="list-style-type: none"> • Sheet too hot. 	<ul style="list-style-type: none"> • Reduce time or tempera-
Part sticking to mold.	<ul style="list-style-type: none"> • Rough mold surface • Undercuts too deep • Not enough draft 	<ul style="list-style-type: none"> • Polish mold • Reduce undercut • Increase draft of mold

• FIGURE 1



• FIGURE 2



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LIMITED WARRANTY

Plastiglas de Mexico warrants its Sensacryl® Ultra cell cast acrylic sheets against any origin manufacture defect. Warranty also covers properties and characteristics expressed on the catalogs of product. This is a limited warranty only for the Sensacryl® Ultra cell cast acrylic sheets. No transformation or installation jobs are considered.

This limited warranty does not consider any fault or damage during sheet transformation or installation. Customer should follow technical recommendations for processing Sensacryl® Ultra cell cast acrylic sheets.

This limited warranty does not consider any damage caused for the excessive heat exposure and or any non-recommended chemical agents used for cleaning and maintenance.

Customer should read Plastiglas de Mexico's recommended maintenance methods.

Plastiglas de Mexico has no liability under any circumstance for the cost of removal a defective sheet or the installation for a sheet of replacement or for indirect incidental or consequential damage.

In order to make a claim under the foregoing warranty, please contact Plastiglas de Mexico or one of our sales representatives. You will be required to show a representative evidence of the problem and provide

a purchase order number and or information regarding batch number printed on the label of the acrylic sheet.

WWW.CHEMCAST.COM.MX

CHEMCAST[®]
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