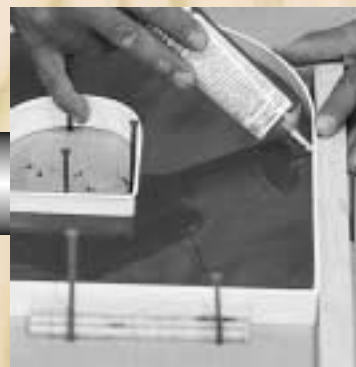
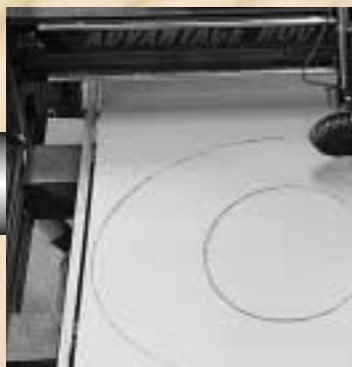


Physical Properties of Acrylite[®] SG ACRYLIC SHEET



CYRO

Physical Properties of ACRYLITE® SG Acrylic Sheet

ACRYLITE SG ACRYLIC SHEET

ACRYLITE® SG acrylic sheet is a continuously manufactured, thermoplastic sheet product developed specifically for the sign market. It is produced utilizing innovative polymers and the same proprietary technology used when manufacturing ACRYLITE® FF acrylic sheet. ACRYLITE SG sheet is the universal sign product which combines light weight and high optical quality with outstanding ease of fabrication and greater impact strength than standard acrylic sheet.



CHARACTERISTICS

ACRYLITE SG sheet is a versatile thermoplastic sheet that is rigid, tough, lightweight, and offers ease of fabrication and machining. Cutting, routing, drilling, forming and cementing can be performed on ACRYLITE SG sheet. Specifically designed for the sign industry, ACRYLITE SG sheet is ideal for use in channel letters, formed letters and shapes as well as back-painted signs. ACRYLITE SG sheet offers the look of acrylic with the impact strength required for fabrication, handling, shipping and sign installation.

AVAILABILITY

ACRYLITE SG sheet is available in 3.0 mm (0.118") and 4.5 mm (0.177") thicknesses. Standard sheet sizes are 51" x 100" and 75" x 100". Custom sizes are available upon request. White, colorless and some colors are available in 4.5 mm (0.177") thickness, in sizes of 75" x 125". All sheets are protected with paper masking. ACRYLITE SG sheet is also available on reels in 4', 5', 6', and 8' widths in several thicknesses.

IMPACT STRENGTH

ACRYLITE SG sheet is a modified acrylic sheet with much higher impact strength than glass or standard acrylic sheet. (Testing per ASTM D 5420).

LIGHTWEIGHT

ACRYLITE SG sheet weighs about half as much as glass.

RIGIDITY

ACRYLITE SG sheet is more rigid than many other plastics including polycarbonates, co-polyesters and vinyls. ACRYLITE SG sheet has greater surface hardness than polycarbonates and is less susceptible to surface marring during fabrication, installation and sign usage.



WEATHER RESISTANCE

ACRYLITE SG sheet offers excellent weatherability. It will withstand most outdoor conditions for many years without significant deterioration of clarity, color or physical properties. Actual results will vary due to differences in exposure to sunlight, moisture, heat and environmental pollutants.

STRENGTH AND STRESSES

Tensile strength of ACRYLITE SG sheet is 8,800 psi at room temperature (ASTM D 638). Continuous loads well below 8,800 psi will lead to stress crazing and eventual failure. For applications subject to continuous loadings, the design should allow for a load that will not exceed 600 psi at 23°C (73°F).

EXPANSION AND CONTRACTION

Like most other plastics, ACRYLITE SG sheet will expand and contract due to temperature changes. Its coefficient of thermal expansion is about 3 times greater than that of metal and about 8 times greater than that of glass. The fabricator must be aware of this and make appropriate provisions. A 48" panel will expand and contract approximately 0.002" for each °F change in temperature. In outdoor use, where summer and winter conditions differ as much as 100 °F, a 48" sheet will expand and contract approximately 1/4".

HEAT RESISTANCE

ACRYLITE SG sheet can be used at temperatures up to 160° F. When colorless sheet is exposed to temperature extremes, as in the case of thermoforming, it will take on a white, translucent appearance. Once the sheet is allowed to return to room temperature, it will return to its original, high light transmitting clarity. Typical outdoor temperature variations encountered in use will cause little or no visible changes in the material's appearance.

LIGHT TRANSMISSION

Colorless ACRYLITE SG sheet has a light transmittance of greater than 87%.

CUTTING & MACHINING

ACRYLITE SG sheet has outstanding cutting and machining properties and can be cut by a variety of methods. All of the same type of machining operations that are used with standard acrylic sheet can be performed on ACRYLITE SG sheet. Due to its proprietary formulation, ACRYLITE SG acrylic sheet provides opportunities for increased production efficiencies in cutting, routing and drilling.

FORMABILITY

ACRYLITE SG sheet will soften as the temperature is increased above 220° F. As the temperature is increased, the sheet passes through a thermoelastic state to the thermoplastic state. The change is gradual rather than sharply defined. Forming temperatures range from 270° F to 350° F. Because the sheet gradually becomes thermoplastic, certain procedures should be considered during thermoforming. If the sheet is to be hung in an oven, it is necessary to use a continuous clamp rather than several individual clamps. This will prevent permanent deformation of the sheet between the clamps. If the sheet is heated by infrared heaters supported in a horizontal frame, it may be necessary to have control of the heaters positioned over the center of the sheet. This will prevent overheating in the center of the sheet, which could cause an excessive amount of sagging of the sheet. Shrinkage will occur in the machine direction when heating is performed without clamping. Shrinkage will range from 1-5%, depending on the thickness and forming temperature. Expansion can be expected in the cross machine direction. This will range from 0-2%, again depending on the thickness and forming temperature.



CEMENTING

Common solvent cements or polymerizable cements work well for joining ACRYLITE SG sheet to itself, other acrylic sheet materials and to trim caps for channel letters. Care must be taken to provide a sheet edge that is machined properly and that contains low stress. A generous quantity of cement should be applied to ensure the surfaces being cemented are completely wetted. Avoid cement contact with polished edges.



ANNEALING

ACRYLITE SG sheet may be annealed at 180°F with the heating and cooling times dependent on the thickness of the sheet. An approximate guideline is as follows: annealing time in hours equals the sheet thickness in millimeters, and the cool down period in hours also equals sheet thickness in millimeters.

FLAMMABILITY

ACRYLITE SG sheet is a combustible thermoplastic. Precautions should be taken to protect this material from flames and high heat sources. ACRYLITE SG sheet usually burns rapidly to completion if not extinguished. The products of combustion, if sufficient air is present, are carbon dioxide and water. However, in many fires, sufficient air is not available and toxic carbon monoxide will be formed, as it will when other common combustible materials are burned. We urge good judgment in the use of this versatile material.

PROPERTY	ASTM METHOD	TYPICAL VALUE 3.0mm THICKNESS	
Mechanical	Specific Gravity	D 792	1.17
	Tensile Strength	D 638	8,900 psi
	Elongation, Yield	D 638	4.8%
	Modulus of Elasticity (tensile)	D 638	350,000 psi
	Flexural Strength	D 790	14,000 psi
	Modulus of Elasticity (flexural)	D 790	330,000 psi
	Rockwell Hardness	D 785	70 "M" scale
	Impact Strength Izod milled notch	D 256	0.63 lbs/in of notch
	Gardner Impact (B)	D 5420	20 in-lbs
	Instrumented Dart	D 3763	4.6 ft. lbs (total energy)
Optical	Refractive Index	D 542	1.49
	Gloss 20°	D 523	125
	Light Transmission	D 1003	90%
Thermal	Forming Temperature	—	270-350°F (135-175°C)
	Deflection Temperature Under Load, 264 psi	D 648	199°F (93°C)
	Vicat Softening Point	D 1525	223°F (106°C)
	Maximum Recommended Service Temperature		160°F (71°C)
	Coefficient of Linear Thermal Expansion	D 696	.00004 in/in°F
Water Absorption	24 hours at 73°F	D 570	0.3%

Typical values of properties listed not to be construed as specifications

Chemical Resistance of ACRYLITE SG Sheet

Chemical resistance was determined at a test temperature of 68°F (20°C), and a relative humidity of 50%. Care should be taken when using this table as chemical resistance is very dependent on temperature and the material's moisture content. In practice, chemical resistance is dependent not only on internal and external stresses, but also to a large extent on the method of fabrication. We recommend that appropriate testing be carried out in doubtful cases and technical advice be requested from CYRO Industries Technical Center by calling 203-795-6081.

⊕ = Resistant

✕ = Limited Resistance

— = Susceptible

<i>Drinks and Edible Liquids</i>		<i>Disinfectants</i>			
⊕	Beer, wine, fruit juices	⊕	Bleaching powder	⊕	Cyclohexane
⊕	Coffee, tea	⊕	Bleaching powder solution, up to 20%	—	Diacetone alcohol
✕	Cooking oil	—	Carbolic acid	—	Dibutyl Phthalate
✕	Liqueurs, see alcohol	⊕	Hydrogen peroxide, up to 40%	⊕	Diethylene glycol
⊕	Milk, chocolate	—	Tincture of iodine, 5%	—	Diocane
⊕	Vinegar	<i>Greases and Oils without additives</i>		—	Ether
⊕	Water, mineral water	⊕	Animal	—	Ethyl acetate
<i>Spices</i>		⊕	Mineral	⊕	Ethyl alcohol, up to 30%
⊕	Aniseed, bay leaves, nutmeg	✕	Vegetable	—	Ethyl alcohol, over 30%
—	Cloves	<i>Paints, Waxes, Etc...</i>		—	Ethyl bromide
⊕	Pepper, cinnamon, onions	✕	Acrylic paints	—	Ethyl butyrate
<i>Inorganic Substances</i>		—	Cellulose paints	—	Ethylene bromide
✕	Chromic acid	—	Paint thinners	✕	Ethylene glycol
⊕	Calcium hypochlorite	⊕	Pure-oil paints	⊕	Heptane
—	Hydrochloric acid	✕	Wax polish	⊕	Hexane
⊕	Nitric acid, up to 20%	<i>Alkalis</i>		✕	Isopropyl alcohol
✕	Nitric acid, 20 to 70%	⊕	Caustic potash	—	Lactic acid butyl ester
⊕	Phosphoric acid, up to 10%	⊕	Soap suds	—	Methyl ethyl ketone
⊕	Sulfuric acid, up to 30%	⊕	Soda	✕	Methanol, up to 30%
✕	Sulfurous acid, conc.	<i>Organic Solvents and Plasticizers</i>		—	Methanol, over 30%
⊕	Sulfurous acid, up to 5%	—	Amyl acetate	—	Motor fuel mixture, with benzene
<i>Gases</i>		—	Aniline	✕	Motor fuel mixture, w/o benzene
⊕	Ammonia	—	Benzaldehyde	✕	Parafin
✕	Bromine	✕	Benzene	✕	Perchloroethylene
⊕	Carbon dioxide	✕	Butanol	—	Phenols
✕	Chlorine	—	Carbon disulfide	—	Pyridine
⊕	Methane	—	Chlorinated hydrocarbons	⊕	Tricresyl phosphate
⊕	Natural gas	<i>General</i>		⊕	Triethyl amine
⊕	Nitrogen dioxide	—	Chlorophenol	—	Toluene
⊕	Nitrogen monoxide	—	Cresol	—	Xylene
⊕	Sulfur dioxide (dry)				

CYRO Locations

Headquarters:

Rockaway, NJ

100 Enterprise Drive
P.O. Box 5055
800-631-5384
973-442-6000

Sales Offices:

Plano, TX

101 East Park Boulevard
Suite 1039
972-424-6830

San Ramon, CA

3180 Crow Canyon Place
Suite 240
925-866-9300

Mississauga, Ontario

6285 Northam Drive
Suite 100
905-677-1388
800-268-4743

Technical Center:

Orange, CT

25 Executive Boulevard
P.O. Box 550
203-795-6081

International Sales:

Rockaway, NJ

100 Enterprise Drive
P.O. Box 5055
FAX: 973-442-6083

Visit our website @ www.cyro.com

