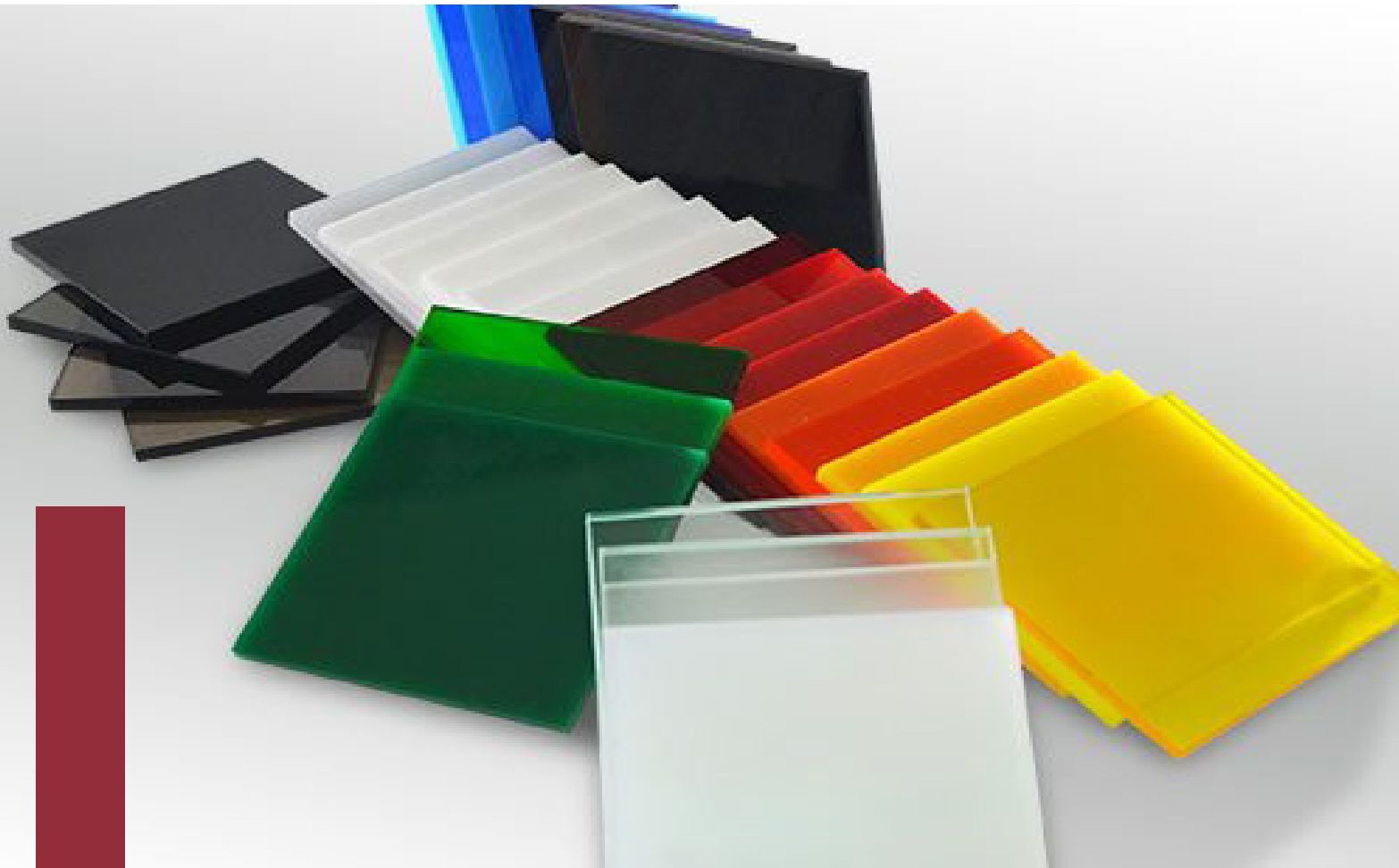


**CHEMCAST**<sup>®</sup>  
The all purpose cell-cast acrylic sheet



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 **Piedmont Plastics**<sup>®</sup>

# CHEMCAST®

The all purpose cell-cast acrylic sheet



CHEMCAST® GP is the designation for a wide range of products that include clear, standard colors, custom colors, P-95, DP-95, marbles and fluorescents produced in several sizes and thickness from 0.060" up to 2.00"

CHEMCAST® is the only high-quality acrylic sheet that can provide you with short runs capability and color selection to fit your specific needs.

CHEMCAST® is the product of a vertically integrated industry that has been manufacturing cell-cast acrylic sheets for over 60 years in Mexico; this includes full control of raw material and distribution each step of the way.

Quality control and product reliability are also an integrated process. Both are scientifically applied and carefully monitored throughout the entire process under the direction of highly competent employee group.

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 **Piedmont Plastics®**

# STANDARD SIZES AND THICKNESSES AVAILABLE

## A) SIZES

(in)	(mm)
48"x72"	1220 X 1830
48"x96"	1220 X 2440
51"x100"	1295 X 2540
60"x96"	1524 X 2440
72"x96"	1830 X 2440
75"x100"	1905 X 2540
51"x125"	1295 X 3175
63"x125"	1600 X 3175
75"x125"	1905 X 3175
48"x120"	3050 X 1220
60"x120"	3050 X 2440
72"x120"	3050 X 1830
80"x120"	3050 x 2030

There are other special sizes available like 72"x72" (1830mm x 1830mm), 78"x78" (2.00m x 2.00m), 64"x64" (1.60m x 1.60m), 78"x39" (2.00m x 1.00m).

## NET GUARANTEED TRIMMED SIZE

	in	mm
1.5mm -50.0mm (0.060" -2.00")	48" X 72"	1220X1830
	48"X 96"	1220X2440
	51"X 100"	1295X2540
	48"x120"	1220x3050
	60"x120"	1524x3050
	72"x120"	1830x3050
	80"X 120"	2030X3050
	51"x 125"	1295X3175
	63"x 125"	1600X3175
	75"x 125"	1905X3175

Untrimmed size could be larger, but high quality is only guaranteed for net size. In the case of 80"x120" in 0.708" and 0.944" thickness, net real size is 80"x119".

Tolerance on trimming 0 / +0.118"

Please contact us for thicknesses and sizes not included in this table.

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## B) THICKNESESS

Nominal Thickness	
(in)	(mm)
0.060"	1.50
0.080"	2.00
0.100"	2.50
0.110"	2.80
0.118"	3.00
0.125"	3.20
0.157"	4.00
0.177"	4.50
0.197"	5.00
0.220"	5.60
0.236"	6.00
0.250"	6.25
0.315"	8.00

Nominal Thickness	
(in)	(mm)
0.354"	9.00
0.394"	10.00
0.472"	12.00
0.500"	12.70
0.590"	15.00
0.708"	18.00
0.825"	21.00
0.944"	24.00
1.00"	25.00
1.25"	32.00
1.50"	38.00
2.00"	50.00

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# THICKNESS TOLERANCES – SECTION A

Nominal Sheet Size		Nominal Thickness		Tolerance (+ / -)	Control Limits	
(in)	(m)	(in)	(mm)		(mm)	(in)
48"X72"	1.80X1.20	0.060"	1.50	20	1.20 - 1.80	0.047 - 0.071
48"X72 "	1.80X1.20	0.080"	2.00	16	1.68 - 2.32	0.066 - 0.091
48"X96"	2.40X1.20	0.100"	2.50	15	2.12 - 2.88	0.083 - 0.113
50"X82"	2.10X1.30	0.110"	2.80	12	2.46 - 3.14	0.097 - 0.124
51"X100"	2.50X1.30	0.118"	3.00	10	2.70 - 3.30	0.106 - 0.130
54"X99"	2.50X1.40	0.125"	3.20	10	2.88 - 3.52	0.113 - 0.139
60"X96"	2.40X1.50	0.157"	4.00	10	3.60 - 4.40	0.142 - 0.173
78"X39"	2.00X1.00	0.177"	4.50	10	4.05 - 4.95	0.159 - 0.195
		0.197"	5.00	10	4.50 - 5.50	0.177 - 0.217
		0.220"	5.60	10	5.04 - 6.16	0.198 - 0.243
		0.236"	6.00	10	5.40 - 6.60	0.213 - 0.260
		0.250"	6.25	10	5.40 - 6.60	0.213 - 0.260
		0.31 5"	8.00	8	7.36 - 8.64	0.290 - 0.340
		0.354"	9.00	8	8.28 - 9.72	0.326 - 0.383
		0.394"	10.00	8	9.20 - 10.80	0.362 - 0.425
		0.472"	12.00	-8 / +6	11.04 - 12.72	0.435 - 0.501
		0.500"	12.70	-8 / +6	11.68 - 13.45	0.460 - 0.530
		0.590"	15.00	-8 / +6	13.80 - 15.90	0.543 - 0.626
		0.708"	18.00	-6 / +4	16.92 - 18.72	0.666 - 0.737
		0.825"	21.00	-6 / +6	19.74 - 22.26	0.777 - 0.880
		0.944"	24.00	-6 / +5	22.56 - 24.48	0.888 - 0.964
		1.00"	25.00	-6 / +6	23.50 - 26.50	0.925 - 1.043
		1.25"	32.00	-6 / +4	30.08 - 33.28	1.184 - 1.310
		1.50"	38.00	-5 / +5	36.10 - 39.90	1.421 - 1.571
		2.00"	50.00	-5 / +5	47.50 - 52.50	1.870 - 2.067

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# THICKNESS TOLERANCES – SECTION B

Nominal Sheet Size		Nominal Thickness		Tolerance	Control Limits	
(in)	(m)	(in)	(mm)	(+ / -)	(mm)	(in)
78"X78"	200X200	0.100"	2.50	20	2.00 - 3.00	0.079 - 0.118
68"X72"	1.80X1.70	0.080"	2.00	20	1.60 - 2.44	0.063 - 0.096
72"X72"	1.80X1.80	0.100"	2.50	18	2.05 - 2.95	0.081 - 0.116
78"X78"	2.00X2.00	0.110"	2.80	18	2.30 - 3.30	0.091 - 0.130
65"X93"	2.40X1.60	0.118"	3.00	18	2.45 - 3.55	0.096 - 0.140
68"X92"	2.40X1.70	0.125"	3.20	15	2.72 - 3.68	0.107 - 0.145
72"X96	2.40X1.80	0.157"	4.00	15	3.40 - 4.60	0.134 - 0.181
75"X100"	2.54X1.91	0.177"	4.50	15	3.82 - 5.17	0.150 - 0.204
70"X100"	2.60X1.80	0.197"	5.00	-15 / +14	4.25 - 5.70	0.167 - 0.224
48"X120"	3.00X1.20	0.220"	5.60	-15 / +12	4.76 - 6.27	0.187 - 0.247
60"X120"	3.00X1.50	0.236"	6.00	-15 / +8	5.10 - 6.48	0.201 - 0.255
72"X120"	3.00X1.80	0.315"	8.00	10	7.20 - 8.80	0.283 - 0.346
80"X120"	3.05X2.03	0.354"	9.00	-10 / +9	8.10 - 9.81	0.319 - 0.386
51"X125"	3.20X1.30	0.394"	10.00	-10 / +7	9.00 - 10.70	0.354 - 0.421
63"X125"	3.20X1.60	0.472"	12.00	-10 / +7	10.80 - 12.84	0.425 - 0.506
75"X125"	3.20X1.90	0.500"	12.70	-10 / +7	13.58 - 11.43	0.535 - 0.450
		0.590"	15.00	-10 / +7	13.5 - 16.05	0.531 - 0.632
		0.708"	18.00	-8 / +5	16.56 - 18.90	0.652 - 0.744
		0.748"	19.00	-7 / +6	17.70 - 20.10	0.697 - 0.791
		0.787"	20.00	-7 / +9	18.60 - 21.80	0.732 - 0.858
		0.825"	21.00	-8 / +8	19.32 - 22.68	0.761 - 0.893
		0.944"	24.00	-8 / +5	22.08 - 25.20	0.869 - 0.992

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1.00"	25.00	-8 / +8	23.00 - 27.00	0.906 - 1.063
1.25"	32.00	-7 / +4	29.76 - 33.28	1.172 - 1.310
1.50"	38.00	-6 / +6	35.72 - 40.28	1.406 - 1.586
2.00"	50.00	-6 / +6	47.00 - 53.00	1.850 - 2.087

These thickness tolerances are based on statistical production records. Thickness tolerances allowed by ASTM D4802 Norm are the official reference for acrylic sheets.

### STANDARD COLORS

T = Transparent

TL = Translucent

OP = Opaque

Color	Pantone color reference	Color Description	Color Type	%Light Transmission
Clear	NA	CLEAR	T	91.90
2050	PMS280 C	BLUE	OP	0.56
2424	PMS286 C	BLUE	T	48.11
2114	PMS287 C	BLUE	TL	5.04
2051	PMS301 C	BLUE	TL	39.19
2648	PMS3005 C	BLUE	TL	5.27
2069	PMS2995 C	BLUE	T	85.53
2030	PMS3425 C	GREEN	TL	1.35
2108	PMS349 C	GREEN	TL	4.86
2092	PMS355 C	GREEN	T	78.74
3030	PMS331 C	GREEN	T	91.75
2146	PMS614C	IVORY	TL	20.20
2037	Yellow C	YELLOW	TL	19.25
2208	PMS109 C	YELLOW	T	90.69
2016	PMS130 C	YELLOW	TL	15.79
2422	PMS1505 C	ORANGE	T	85.80

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2119	Orange 021 C	ORANGE	TL	4.79
2283	PMS485 C2X	RED	TL	37.32
2793	PMS485 C2X	RED	TL	7.12
2157	PMS186 C	RED	TL	1.56
2423	PMS186 C	RED	T	49.85
L-014	PMS221 C	PINK	TL	24.98
2418	PMS476 C	BROWN	OP	0.01
2370	PMS412C	BRONZE	T	11.85
2404	PMS463 U	BRONZE	T	79.58
2412	PMS462 C	BRONZE	T	47.38
2538	PMS448 C	BRONZE	T	38.41
2064	PMS418 C	GRAY	T	57.07
3001	PMS430C	GRAY	OP	0.06
2094	PMS404 C	GRAY	T	72.25
2540	PMS406 U	BRONZE	T	84.65
2514	PMS413 U	GRAY	T	86.64
2515	PMS406 U	GRAY	T	85.77
2074	Black C	GRAY	T	35.49
2025	Black 6C 2X	BLACK	OP	-
2067	NA	WHITE	TL	69.04
7138	NA	WHITE	TL	25.05
7420	NA	WHITE	TL	2.99
7508	NA	WHITE	TL	4.64
2371	NA	WHITE	OP	0.08

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7328	NA	WHITE	TL	9.11
2447	NA	WHITE	TL	45.18
3015	NA	WHITE	OP	0.24

The percentage of light transmission is in reference to 0.118" thickness. For specific percentage of light transmission for other colors and thicknesses, please contact Customer Service.

**FLUORESCENT COLORS – For indoor application only.**

T = Transparent      TL = Translucent      OP = Opaque

Color	Color Description	Color Type
L-032	ORANGE	T
L-043	YELLOW	T
L-089	BLUE	T
L-111	GREEN	T
L-116	RED	T

**PEARLESCENT COLORS – For indoor application only.**

Color	Color Description
L-400	WHITE
L-401	IVORY
L-402	BROWN
L-403	PINK
L-404	BROWN
L-412	BLUE
L-450	GRAY

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## P-95 & DP-95

All standard and most of our custom colors can be made in P-95 (mate finish one side) or DP-95 (matte finish two sides).

The most common products made in P-95 and DP-95 finishes are:

Color	Sizes Available	P-95	DP-95
CLEAR	48"x72"	Yes	Yes
7328	48"x96"	Yes	Yes
2447	51"x100"	Yes	Yes
7508	60"x96"	Yes	Yes
2025	72"x96"	Yes	Yes
3030	80"x120"	Yes	Yes
Other Standard colors		Yes	Yes
Custom Colors		Yes	Yes

## COLOR MATCHING

We offer color matching service for your new designs and ideas. Certain minimum quantities and other requirements may apply depending on specific needs.

## CUSTOM COLOR MATCHING POLICY

After receiving a sample of the custom color needed, Plastiglas de Mexico will search in its color bank for identical or very close matches to avoid development costs.

If a satisfactory existing color is unavailable, we will match the particular color. The color development process requires approximately 2 to 3 weeks lead-time depending on our backlog. To initiate the color development process the minimum volume required is 60 sheets in 48"x96" of 0.118" and one full pallet for other sizes and thicknesses. For subsequent orders of the same item, the same color in the identical size and thickness will require minimum production run.

Please refer to your current Custom Colors Price List

Cancellation Policy: An approved matched custom color order cancellation is subject to a 100% cancellation charge.

Custom Color match fee is \$150.00 USD\$ per color.

## MINIMUM RUNS ON EXISTENT PRODUCTS (SHEETS PER PRODUCTION BATCH)

	mm	1.5mm - 6.0 mm	8.0 mm - 12.0 mm	15.0mm - 18.0 mm	24.0mm - 32.0 mm	38.0mm - 50.0mm
	in	0.060" - 0.236"	0.315" - 0.472"	0.590" - 0.708"	0.944" - 1.25"	1.50" - 2.00"
mm	in					
1220X1830	48" X 72"	15	15	10	X	X
1220X2440	48"X 96"	15	15	8	10	6
1295X2540	51"X 100"	15	15	10	10	X
1524X2440	60"X 96"	15	12	8	10	X
1830X2440	72"X 96"	13	12	10	10	X
1905x2540	75"x 100"	12	12	8	X	X
1220x3050	48"x120"	8	8	8	8	6
1524x3050	60"x120"	8	8	8	8	6
1830x3050	72"x120"	8	8	8	8	6
2030X3050	80"X 120"	8	8	8	8	6
1295X3175	51"x 125"	8	8	8	X	X
1600X3175	63"x 125"	8	8	8	X	X
1905X3175	75"x 125"	8	8	8	X	X

## PACKAGING (Sheets per pallet)

All CHEMCAST® products are packed in standard wooden pallets and in the quantities shown in the following table.

SHEETS PER PALLET

THICKNESS		48"X72"	48"X96"	51"X100"	60"X96"	72"X72"	72"X96"	75"X100"	48"X120"	60"X120"	72"X120"	80"X120"	51"X125"	63"X125"	75"X125"
		180X120	240X120	250X130	240X150	180X180	240X180	254X191	305X122	305X152	305X183	305X203	320X 130	320X160	320X191
MM	INCHES														
1.5 mm	0.060"	250	-	-	-	-	-	-	-	-	-	-	-	-	-
2.0 mm	0.080"	240	-	-	-	-	-	-	-	-	-	-	-	-	-
2.5 mm	0.100"	190	-	-	-	-	-	-	-	-	-	-	-	-	-
3.0 mm	0.118"	150	125	120	80	100	80	70	50	45	45	45	60	55	50
4.0 mm	0.157"	90	80	75	60	75	55	50	-	-	-	40	-	-	-
4.5 mm	0.177"	-	70	70	50	-	45	45	40	40	35	35	40	45	35
5.0 mm	0.197"	75	65	60	45	60	40	-	-	-	-	35	-	-	-
5.6 mm	0.220"	65	60	60	40	55	35	40	35	35	30	30	35	35	25
6.0 mm	0.236"	65	60	50	40	50	35	35	35	35	30	30	35	35	25
8.0 mm	0.315"	45	40	-	30	-	25	-	-	-	-	22	25	-	-
9.0 mm	0.354"	-	35	35	25	-	25	24	25	25	20	20	20	22	20
10.0 mm	0.394"	40	30	-	-	-	22	-	-	-	-	18	-	-	-
12.0 mm	0.472"	-	28	28	20	-	20	18	22	16	15	15	15	16	15
15.0 mm	0.590"	-	20	-	15	-	15	16	-	-	-	-	-	-	-
18.0 mm	0.708"	-	18	18	14	-	12	-	10	10	10	10	-	-	-
20.0 mm	0.787"	-	16	-	-	-	-	-	-	-	-	-	-	-	-
24.0 mm	0.944"	-	14	14	10	-	10	-	10	10	8	7	-	-	-
32.0 mm	1.250"	-	10	-	8	-	8	-	-	6	-	-	-	-	-
38.0mm	1.500"	-	9	-	-	-	-	-	7	5	5	5	-	-	-
44.0 mm	1.750"	-	8	-	-	-	-	-	-	-	-	-	-	-	-
50.0mm	2.000"	-	7	-	-	-	-	-	5	-	-	4	-	-	-

Shipments should be submitted to +/- 10% or +/-20% of the quantity ordered, depending on the kind of product.

Standard products are subject to +/- 10%.

Custom colors, oversized (120" and 125" length), P-95, DP-95, High Impact and other differentiated products are subject to +/- 20%.

For minimums on other differentiated products, please contact Customer Service.

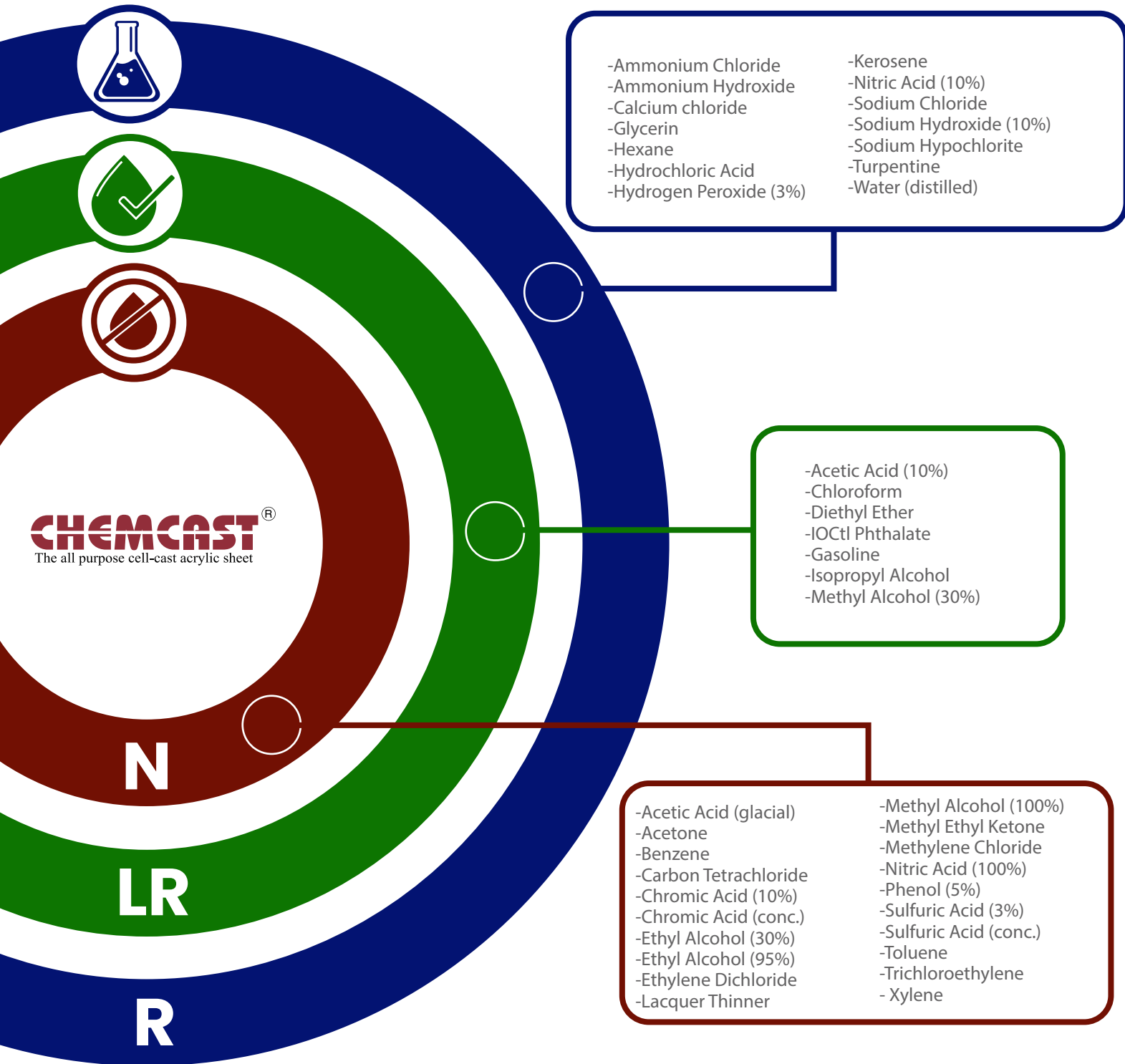
Based on customer's order, the standard colors will be packed in rainbow pallets of the same size. Proper identification with pallet labels will show the colors included on each rainbow pallet.

# PHYSICAL AND MECHANICAL PROPERTIES

PROPERTY	TYPICAL VALUE (1)	TEST METHOD
<b>OPTICAL</b>		
Specific Gravity	1.18	ASTM D 792
Optical Refractive Index	1.49	ASTM D542
Haze (%)	2.0	ASTM D542
Light Transmission (%)		
0.100" - 0.197"	92	ASTM 1003
0.220" - 0.472"	90	ASTM 1003
<b>MECHANICAL</b>		
Tensile Strength (psi)	9600	ASTM D638
Elongation at Rupture (%)	4.5	ASTM D638
Modulus of Elasticity (psi)	425,000	ASTM D798
Impact Strength (ft lb/in)	0.4 - 0.5	ASTM 256
Flexural Strength (psi)	15000 - 16000	ASTM D 798
Rockwell Hardness	M (90 - 100)	ASTM 785
Barcol Hardness	50	ASTM 2583
<b>THERMAL</b>		
Forming Temperature		
(°C)	140 - 180	ASTMD 648
(°F)	284 - 356	ASTMD 648
Deflection Temperature Under Load (264 psi)		
(°C)	91	ASTM 1525
(°F)	196	ASTM 1525
Maximum recommended continuous service temp		
(°C)	80	
(°F)	176	
<b>MISCELLANEOUS</b>		
Water absorption (24 hrs. -23°C -73°F) (%)	0.3%	ASTM 570

All values referred to 0.118" (3.0 mm) acrylic sheet. These values are typical and should not be taken as specifications.

# 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 (49°C).

**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 some manner.

These values are typical and should not be taken as specification

## LIMITED WARRANTY

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

This limited warranty does not consider any fault or damage during sheet transformation or installation. Customer should follow the technical recommendations for processing CHEMCAST® 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 see the Plastiglas de Mexico's recommended maintenance methods.

Plastiglas de Mexico has no liability under any circumstance for the cost of removal of defective sheet or the installation of replacement sheet or for indirect incidental or consequential damage. In order to make a claim under the foregoing warranty, please contact Plastiglas de México or one of our 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.

Time frames for claim's acceptance:

- 1.- Quality in the delivery: Immediately after the reception of the material.
- 2.- Protective paper anchoring: 6 months after the manufacturing date written on the product label
- 3.- Performance and processability: 1 year after the manufacturing date written on the product label.

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