For over 50 years, Plaskolite has been providing the highest quality acrylic to sign fabrication shops throughout North America. Today, you can trust Plaskolite to produce the acrylic products that sign shops prefer due to its unparalleled performance characteristics that include:

- Unsurpassed weatherability
- Inherent UV stability
- Outstanding durability
- Production flexibility with roll stock and acrylic sheet
- Cost efficiencies
- Ease of fabrication
- Excellent clarity
- Size compatibility

Scratch resistant coating adds even greater sign durability.

Plaskolite offers a high-quality, scratch-resistant coating for those demanding applications requiring abrasion, stain and solvent resistance. Safer than glass and more economical than competitive products, Plaskolite acrylic with scratch-resistant coating is ideal for applications such as signs, retail displays, tabletops, door panels and other high traffic surfaces where the acrylic will be exposed.
SUGGESTED THERMOFORMING CONDITIONS

Condition | UNITS | OPTIX | SG | SG-05 | SG-10 | Cast Acrylic
---|---|---|---|---|---|---
Thermoforming for Sheet Thickness 0.100” to 0.375”
Optimal Forming Temperature ˚F | 320 | 315 | 310 | 380
Forming Temperature Range ˚F | 270-350 | 270-350 | 270-350 | 350-390
Heating Time | Minutes | 1 - 10 | 1 - 10 | 1 - 10 | 2 - 25
Cooling Time | Minutes | 0.5 - 4 | 0.5 - 4 | 0.5 - 4 | 1 - 7
Optimal Melt Temperature ˚F | 180 | 175 | 170 | 190
Two Sided Infrared
Free Shrinkage at Forming Temperature % | 1 - 3 | 1 - 3 | 1 - 3 | 0 - 2
Machine Direction % | 0 | 0 | 0 | 0 - 2
Transfer Direction % | 0 | 0 | 0 | 0 - 2

ACRYLIC THAT WEATHERS THE TESTS OF TIME

Sign Grade Acrylic Sheet

Property | ASTM | UNITS | OPTIX | SG | SG-05 | SG-10 | Cast Acrylic
---|---|---|---|---|---|---|---
Optical | | | | | | | |
Light Transmission | D-1003 | % | 92 | 92 | 90
Percent Haze | D-1003 | % | 2 | 2 | <3
Mechanical | | | | | | | |
Impact Strength (73˚F) ft-lbs./in. | D-256 | 0.4 | 0.7 | 1.1
Impact Strength (0˚F) ft-lbs./in. | D-256 | 0.2 | 0.2 | 0.5
Tensile Modules of Elasticity psi | D-638 | 400,000 | 340,000 | 250,000
Tensile Strength @ Yield | D-638 | 11,030 | 8,000 | 6,500
Impact Strength @ Yield | D-790 | 19,000 | 12,000 | 8,000
Rockwell Hardness | Method A | 85 | 85 | 85
Thermal | | | | | | | |
Deflection Temperature (264psi) ˚F | D-648 | 203 | 144 | 185
Coefficient of Thermal Expansion 10 x 10⁻⁶/°F | D-696 | 2.3 x 10⁻⁶ | 4 x 10⁻⁶ | 5 x 10⁻⁶
Self-Ignition Temperature °R | D-1020 | 173 | 185 | 256
Burning Rate in./min. | D-635 | 1.019 | 1.25 | 1.97
Smoke Density Rating | D-2843 | 3.4 | 3.5 | 4.0
Processing | | | | | | | |
Density Specified Gravity | D-792 | 1.19 | 1.17 | 1.15
Moisture Water Absorption % wt. gain | D-570 | 0.4 | 0.3 | 0.3
Dimensional Molding Shrinkage mils./in. | D-595 | 2 - 6 | 3 - 6 | 3 - 6

Colors: Clear, 2447 White & .7328 White
Thicknens .118” - .236”
Available Widths: 30” - 105”
For custom sign grade materials call for availability, quotation and delivery information.

Processing and Handling Tips

Plaskonite Sign Grade Acrylic Sheet

Forming
SG Sheet forms at approximately 50˚ to 60°F lower than that of cast acrylic with optimum range between 280˚ to 320˚F.

Orientatoin
When heated to forming temperature, SG sheet will exhibit mild shrinkage in the extrusion direction, but not in the cross-extrusion direction. Cast sheet, depending on the manufacturer, may exhibit shrinkage from 0% to 2% in both directions. SG Sheet can be easily painted, however, it is susceptible to attack by aromatic solvents such as Toluene, Xylene, or Ketones.

Recommended Paint Systems:

Painting
SG Sheet can be easily painted, however, it is susceptible to attack by aromatic solvents such as Toluene, Xylene, or Ketones.

Recommended Adhesives:

Adhesives listed below are recommended for use with SG Sheet products. However, adhesives should be tested prior to full-scale use.

Recommended UV Ink:

Nastair - Phone (800) 767-0942

Recommended Equipment:

Field & Spring<br>300 Series (Spray)<br>400 Series (Spray)

Weld-On #40<br>Reactive gluing system. Good for bonding SG Sheet to other materials such as cell cast acrylic, polystyrene, PVC, butyrate and wood.

Weld-On #5<br>Fast-drying, high strength.

T-4000 (Cleaner) 206-T (Cleaner)


FR-2 (Spray) 400 Series (Spray)

FR-1 (Screen) 800 Series (Screen)

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