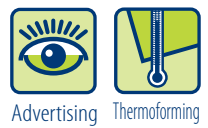




# PALOPAQUE®

*Flat Rigid Opaque PVC Sheets*



## ► Introduction

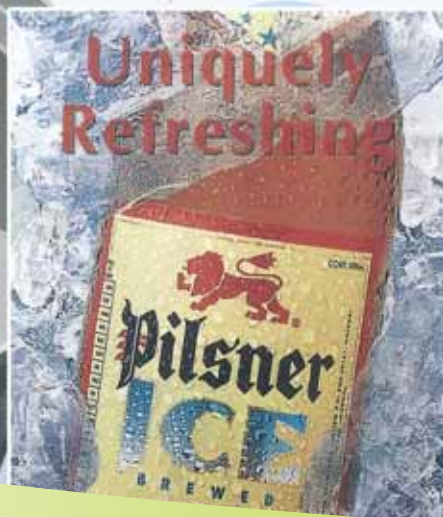
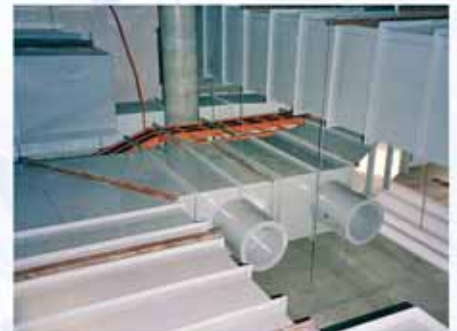
PALOPAQUE has been manufactured by Palram for 40 years. This experience in formulation and extrusion yields the highest quality PVC sheet suitable for the widest variety of applications. PALOPAQUE sheets are readily formed and fabricated.



## ► Features at a Glance

- Easy to thermoform and bend
- Resistant to chemical and corrosive environments
- Highest fire rating
- Glossy or matte surface
- Excellent electrical and thermal insulation
- High impact strength
- Weather resistant
- Comply with international standards
- Easy fabrication
- Installation with conventional tools
- No special handling required
- New - Matte finish on one side available\*
- ISO 9001:2000 certified quality assurance

*\* Except for PALOPAQUE UV TF*



## ► PALOPAQUE - Typical Physical Properties

Property	(Method <sup>a</sup> )	Conditions	Units	Value
Density	(D-1505)		g/cm <sup>3</sup>	1.4
Heat Deflection Temperature	(D-648)	Load: 1.82 MP	°C	65 - 68
Service Temperature Range			°C	-10 to +50
Thermal Conductivity	(C-177)		W/m K	0.15
Coefficient of Linear Thermal Expansion			cm/cm °C	6.7 x 10 <sup>-5</sup>
	(D-696)			
Impact Falling Weight	(ISO 6603/1)	3 mm sheet	J	95
Rockwell Hardness	(D-785)		R Scale	97R
Tensile Strength at Yield	(D-638)	10 mm/min	MPa	52
Tensile Strength at Break	(D-638)	10 mm/min	MPa	50
Elongation at Yield	(D-638)	10 mm/min	%	3
Elongation at Break	(D-638)	10 mm/min	%	180
Tensile Modulus of Elasticity	(D-638)	1 mm/min	MPa	2,900
Flexural Strength	(D-790)	1 mm/min	MPa	80
Flexural Modulus	(D-790)	1 mm/min		2,700

<sup>a</sup> ASTM except where noted otherwise.

## ► Flammability

PALOPAQUE sheets are self-extinguishing and comply with the most demanding international fire resistance standards defined in the field of plastics, as indicated by representative results in the table below.

Standard	Classification*
DIN 4102	B-1
BS 476/7	Class 1
NSP 92501,5	M-1
NSP 92501,5	M2
CSE RF 3/77	Class 1
UL 94	V-0
ASTM D-635	SE

\* Depends on thickness

## ► Fabrication

Sawing	Machining	Thermoforming	Drilling	Bonding	Welding
For both band and circular saws use blades with a minimum tooth set, and about 8 to 10 teeth per inch. Prevent overheating by feeding slowly.	Use low machining speeds for turning and shaping and to assure easy removal of machining chips.	Between 130°C and 140°C Palopaque sheets become formable and can then be formed, press molded or blow formed.	Use conventional drills, but be certain to remove drill chips in order to avoid overheating of the sheet. Also, use slow rate of penetration.	Palopaque sheets can be bonded with conventional solvent based PVC adhesives	Palopaque extruded PVC sheets are weldable by the hot-air welding process conventionally used for PVC.

Inasmuch as PALRAM Industries has no control over the use to which others may put the material, it does not guarantee that the same results as those described herein will be obtained. Each user of the material should make his own tests to determine the material's suitability for his own particular use. Statements concerning possible or suggested uses of the materials described herein are not to be construed as constituting a license under any PALRAM Industries patent covering such use or as recommendations for use of such materials in the infringement of any patent. PALRAM Industries or its distributors cannot be held responsible for any losses incurred through incorrect installation of the material. In accordance with our company policy of continual product development you are advised to check with your local PALRAM Industries supplier to ensure that you have obtained the most up to date information.

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## ► PALRAM Rigid Opaque PVC Sheets

Product	Description
PALOPAQUE®	Standard flat sheet
PALOPAQUE® UV	Flat sheet that is UV protected for external use
PALOPAQUE® UV TF	Flat sheet that is UV protected, intended for thermoforming products for external use
PALOPAQUE® Matte	Flat sheet with matte finish on one side - available with the above (except PALOPAQUE UV TF)



## ► Chemical Resistance

**Excellent Chemical Resistance:** mineral acids, alkalis, plating solutions, paper making chemicals, pickling solutions, other inorganic solutions and fumes thereof.

**Good Chemical Resistance:** alcohols, aliphatic hydrocarbons, glycols, amines, phenols.

**Not Recommended with:** ketones, aromatic hydrocarbons, chlorinated solvents, some esters and ethers.

More detailed information appears in: "Chemical Resistance of Palram Rigid PVC Sheets".

## ► Dimensions & Colors Available\*

- **Colors:** Dark Grey, Light Grey, White
- **Thickness:** 1 to 15 mm
- **Width x Length:** 1220 x 2440 mm  
1000 x 2000 mm  
1500 x 3000 mm

\* Custom colors and sizes are available upon request, possibly subject to minimum order size.