



○ ● ■ Cast and Extruded Acrylic Tubes, Rods, Bars, Balls ■ ● ○

Quality description for EXTRUDED ACRYLIC RODS, HALF-ROUND RODS, BARS and TRIANGLE BARS IN PMMA¹

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¹ In the whole text as QS. Our QS is written in conformity with the norms ISO 9002



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Preface

Our QS for extruded acrylic rods, half-round rods, bars, triangle bars in PMMA has been valid since the year 2000. Purpose of this certification is to guarantee the excellent quality of every single item.

The strict quality control during the production process and a constant improvement of the production technologies allowed the standardisation of the quality of the extruded acrylic profiles.

1 Material features

Extruded acrylic rods, half-round rods, bars and triangle bars in PMMA are polymerised plastic semi-finished products. They are manufactured through the process of extrusion. After the production process they are clear and bright on the external wall². High purity, brightness and transparency are their most important characteristics; besides they are very resistant against weather conditions and ageing, since the optical quality and the light transmittance remain unchanged over years.

2 Quality description

2.1 Optical quality

Extruded acrylic rods, bars and triangle bars in PMMA are absolutely colourless and have a clear external wall. They are free of bubbles, filaments, foreign bodies. In spite of this, the manufacturing process of extrusion causes some light stripes which are visible from a short distance. These stripes are admitted but should not condition the optical quality and the transparency of the entire profile.

Following defects are not admitted:

- Deep scratches;
- Bubbles, inclusions or foreign bodies, unpolymerized stuff in the material bigger than 2 mm²/meter;
- crazing effect

2.2 Tolerances

In order to guarantee an excellent standard quality the extruded acrylic tubes are controlled many times during the production process. Tubes that show worse values than those indicated in the table 1,2,3,4 do not get through the quality control and are systematically rejected.

² This information refers only to the EXTRUDED ACRYLIC CLEAR PROFILES



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Table 1: Tolerances of extruded acrylic rods

External Diameter Ø (mm.)	Standard Length** (mm.)	Packing Unit (N.)	Tolerance on ext. diameter
2	2000	100	± 0,3 mm.
3	2000	100	± 0,3 mm.
4	2000	100	± 0,3 mm.
5	2000	50	± 0,3 mm.
6	2000	50	± 0,3 mm.
7	2000	50	± 0,3 mm.
8	2000	50	± 0,3 mm.
10	2000	25	± 0,3 mm.
12	2000	25	± 0,3 mm.
15	2000	25	± 0,3 mm.

Table 2: Tolerances of extruded acrylic half-round rods

External Diameter Ø (mm.)	Standard Length** (mm.)	Packing Unit (N.)	Tolerance on ext. diameter
4	2000	100	± 0,3 mm.
5	2000	50	± 0,3 mm.
6	2000	50	± 0,3 mm.
7	2000	50	± 0,3 mm.
8	2000	50	± 0,3 mm.
10	2000	25	± 0,3 mm.
12	2000	25	± 0,3 mm.
15	2000	25	± 0,3 mm.
20	2000	25	± 0,3 mm.
25	2000	25	± 0,3 mm.

Table 3: Tolerances of extruded acrylic bars

Side Length [] (mm.)	Standard Length** (mm.)	Packing Unit (N.)	Tolerance on profile
4x4	2000	100	± 0,4 mm.
5x5	2000	50	± 0,4 mm.
6x6	2000	50	± 0,4 mm.
8x8	2000	50	± 0,4 mm.
10x10	2000	25	± 0,4 mm.
12x12	2000	25	± 0,4 mm.
15x15	2000	25	± 0,4 mm.
20x20	2000	25	± 0,4 mm.



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Table 4: Tolerances of extruded acrylic triangle bars

Side Length [] (mm.)	Standard Length** (mm.)	Packing Unit (N.)	Tolerance on profile
5x5x5	2000	50	± 0,4 mm.
8x8x8	2000	50	± 0,4 mm.
10x10x10	2000	25	± 0,4 mm.
15x15x15	2000	25	± 0,4 mm.
20x20x20	2000	25	± 0,4 mm.
25x25x25	2000	25	± 0,4 mm.

2.3 Delivery conditions

2.3.1 Packing

Type of packing:

- PE film

Packing unit:

- until []³ 4 mm. : 100 bars/bundle
- from [] 5 to []8 mm.: 50 bars/bundle
- from [] 10 to []25 mm.: 25 bars/bundle

2.3.2 Delivery packing

Extruded acrylic rods, bars, and triangle bars are set in wooden pallets. The standard delivery packing include:

- wooden base (Palette) or PE-bubble film
- the bars – packed as in 2.3.1 - are wrapped up in PE film and sealed with plastic tape

The profiles are delivered on standard wood pallets which are adapted and optimised to the volume of the goods ordered

Ask for more information by fax at 0039 02 95737357 or by mail at info@gevacril.com⁴

³ Indicates the side or the diameter of the profile

⁴ The information given refers only to the specific products indicated in the QS. Gevacril considers this information right, reliable and in conformity to the specific technical information available on the market at the moment of their printing but do not give any guaranty for them and for any kind of application or processing of the above mentioned products



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2.4 Identification

2.4.1 Product identification

A label on every acrylic tube indicates:

- product;
- external diameter/ side length;
- length;
- day, month, year of production;
- quality control approval.

2.4.2 Identification of the delivery crates/boxes

A label on every delivery case – as in 2.3.2 – indicates:

- destination address;
- detailed case content.

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