

Norm ISO – ABNT nº 7823-1

Acrylic Sheets produced by the Casting Process

5.2.1 Surface Defects

Sheets surface should be smooth, without scratches, marks or any superficial flaws that exceeds 3 mm² each, at any position on the sheets surface.

5.2.2 Embedded Defects

The sheets should have no bubbles, contamination or any other defect that may harm the material during its application. The defects cannot exceed 3mm² in any area of the sheet.

5.2.3 Defects classification

The area of any defect in the sheet is classified as described on table 1 below. Each defect. Is to be considered isolate.

5.2.4 Defects distribution

5.2.4.1 There should not be a significant number of small defects, even if their classification is negligible, as in table 1, in an area of 1m² in any point of the sheet.

5.2.4.2 No acceptable defect, as defined in table 1, can be less than 500 mm far from another in any point of the sheet.

Table 1 – Defects classification

Classification	Surface defect area	Embedded defect area
Negligible	Smaller than 1mm ²	Less than 1mm ²
Acceptable	1mm ² to 3mm ²	1 mm ² to 3mm ²

5.4.2 Thicknesses

The thickness tolerance of sheets between 2 and 25 mm and up to 6 m² of area should be calculated by the equation $\pm (0,1 \times E + 0,4)$, where “E” is the nominal thickness of the sheet in millimeters (ex: a sheet of: 1000x2000x3,0mm, has thickness limits from 2.3 to 3.7mm). As tolerances are the same on one sheet as well as in all the sheets of a certain lot.

Special care

To clean acrylic sheets use only neutral soap with a soft clean cloth. Do never use alcohols, thinner or solvents.