



OPTIX.R DUST RECYCLED EXTRUDED SHEETS

EXTRUDED OPTIX.R DUST ACRYLIC (PMMA) SHEETS are produced from PLASKOLITE recycled PMMA saw dust according to the ISO 7823-2:2003 standard. The sheets can be used for a wide variety of domestic and industrial applications.

OPTIX.R DUST is available in wide range of thicknesses in opaque silver, grey, white, and black colors.

TYPICAL PROPERTY VALUES

Properties	Method	Units	Value
Mechanical			
Tensile Strength	ISO 527-2	MPa	80
Elongation at break	ISO 527-2	%	6
Tensile Modulus	ISO 527-2	MPa	3100
Flexural Strength	ISO 178	MPa	95
Flexural Modulus	ISO 178	MPa	3100
Impact Resistance (Izod notched)	ISO 180/1A	kJ/m ²	2
Optical			
Light Transmission (thickness dependent)	ASTM D1003	%	0 (Opaque)
Haze (3 mm transparent sheet)	ASTM D1003	%	100 (Opaque)
Thermal			
Vicat Softening Temp.(50N)	ISO 306	°C	99
Heat Deflection Temp. (1.82 MPa)	ISO 75-1	°C	94
Maximum Continuous Service Temp.		°C	70
Maximum Short Time Service Temp.		°C	90
Minimum Temp.		°C	-40

DIMENSIONS

Thickness, mm	Width, mm	Length, mm
2.0 - 6.0	1000, 1220 and 2050	600 - 6000

Sheets are also available cut to size, according to customer requirements.

TOLERANCES FOR DIMENSIONS

Sheet Thickness, mm	Thickness, %	Width Tolerances, mm	Length Tolerances, mm	Diagonals Tolerances, mm	Flatness Tolerances
≥2.0, < 6.0	± 3	<p>Sheets cut in production: -0.0 /+3.0</p> <p>Sheets cut to size: ± 0.50</p>	<p>Sheets cut in production (length < 4000 mm.): -0.0 / +3</p> <p>Sheets cut in production (length ≥4000 mm.): -0.0 / +0.1% of length</p> <p>Sheets cut to size: ± 0.50</p>	<p>Sheets cut in production: Length < 4000 mm - ≤2 Length ≤ 4000 mm - ≤ 4</p> <p>Sheets cut to size: ≤ 0.5</p>	<p>Max. allowed bowing - 0.5% from linear dimensions.</p> <p>Max. allowed bowing across the width of the sheet - ≤ 5 mm per meter of width.</p> <p>Max. allowed bowing along the length of the sheet - ≤ 5 mm per meter of length.</p>

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COLORS

OPTIX.R DUST sheets are provided in opaque silver, white and black colors.
For more information, please contact PLASKOLITE Technical Support.

SHRINKAGE

After heating acrylic extruded sheets will shrink during the cooling process, the shrinkage is higher in the extrusion direction.

This characteristic of OPTIX.R DUST should be taken into account when planning the final sheet's dimensions.

Sheet Thickness, mm	Shrinkage	
	Shrinkage M.D*, %	Shrinkage T.D**, %
≥ 2.0, < 2.30	6 - 7	0.5
≥ 2.30, < 3.50	5 - 6	0.5
≥ 3.50, < 4.00	3 - 4	0.5
≥ 4.00, < 6.00	2 - 3	0.5

* M.D. - Machine (extrusion) direction

** T.D. - Transverse (perpendicular to extrusion) direction

FIRE TEST PERFORMANCE

PMMA is a combustible material and will burn if ignited, however, unlike other polymers, does not produce toxic or corrosive gases and produces very little smoke which is an important safety benefit.

CHEMICAL RESISTANCE

For information regarding the chemical resistance of OPTIX.R DUST, please contact PLASKOLITE.

ENVIRONMENTAL STRESS CRACKING

Environmental Stress Cracking (ESC) is a result of the combination of stress and chemical exposure. The level of stress needed for ESC is lower than the normal failure mechanical stress of PMMA in a chemical-free environment. Stresses can be created during fabrication and forming and can be controlled by an annealing process. Stresses can also be created by improper installation. Cold bended sheets under permanent induced stress or sheets under periodic stress (fatigue) are also susceptible to ESC.

GENERAL GUIDELINES

STORAGE

OPTIX.R DUST is a rigid sheet, incorrect handling can cause breakage, leaving sharp edges. The sheets must be stored with their original protective masking in a cool, dry, and well-ventilated room, away from direct sunlight, excessive humidity, rain or solvent vapors.

OPTIX.R DUST sheets are best stored horizontally on their delivery pallets. Pay attention to avoiding pressure on the unsupported areas. Never leave sheets or pallets uncovered.

PROTECTIVE FILM

Both surfaces of OPTIX.R DUST sheet are protected by a fully recyclable polyethylene (PE) film. Keep this film in position as long as possible and remove only and immediately after installation.

There are two kinds of protective film for the sheets:

- Universal film that is suitable for machining

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- Easy-removal film that is suitable for sheets where the film will be removed before processing. This type of film is not suitable if machining of the sheet is required to be done with the protective film on the sheet.

Both of the above types of film are suitable for thermoforming and laser cutting.

Printed film must be removed before thermoforming in order to avoid transfer of the printing ink to the sheet's surface.

CLEANING & MAINTENANCE

OPTIX.R DUST sheets are produced in clean-room environment and do not need to be cleaned before use. However, cleaning may be needed after fabrication, before sensitive processes such as vacuum metallization or printing or for maintenance during use.

If OPTIX.R DUST sheets need to be cleaned, wash the sheet surface with clean fresh water with a mild soap. In order to verify that the soap you are using is compatible with PMMA test a hidden area before cleaning. Use a clean soft cloth or sponge and rinse well. Do not scrub or use brushes. Dry with a soft cloth. The use of window cleaning fluids or solvents such as alcohols, turpentine, acetone, etc., can cause damage to the sheet.

ENVIRONMENTAL ADVANTAGES

OPTIX.R DUST sheets are environmentally friendly. LCA (Life Cycle Assessment) and Eco profiles of PMMA sheet production show a low impact on the environment.

The long-time resistance to aging and weathering of OPTIX.R DUST sheets often ensures a long service time. The sheets and their polyethylene protective layers are fully recyclable. They do not contain any toxic materials, halogens, or heavy metals, which may cause environmental damage or health risks. OPTIX.R DUST sheets do not contain Bisphenol-A. Ozone Depleting Substances (ODP) are not used in the manufacture of OPTIX.R DUST sheets and they do not release pollutant substances into the environment during manufacture. They do not produce toxic or corrosive gases when burning, fires can be extinguished with water.

OPTIX.R DUST scrap is not classified as hazardous waste small amounts can be disposed as household refuse. Large quantities should be disposed by recycling.

Handling:

Machining, Assembling, Forming, Glazing and Signage Installation recommendations can be found in the OPTIX Guidebook

Cold bending:

Unlike thermoforming, cold-bended OPTIX.R DUST will not keep its form unless installed into a frame. The sheet must be with perfect edges to avoid breakage during bending. The radius of the bend should not be below the minimum value in order to avoid high permanent stress, which can eventually cause small cracks or even break the sheet. Minimum recommended bend radius is 300 times the thickness of the sheet.

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of use are beyond our control. We recommend that the prospective user determines the suitability of our materials and suggestions before adopting them on a commercial scale.

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PLASKOLITE

400 W Nationwide Blvd Suite 400
Columbus, OH 43215
800.848.9124 • Fax: 877.538.0754
plaskolite@plaskolite.com
www.plaskolite.com

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