

PLEXIGLAS® SHEET: Defect Tolerance

ACRYLIC SHEET

PLEXIGLAS® MC, Q, T, UF- 5, AND FROSTED: MANUFACTURING SPECIFICATION

Dimensional Tolerances

Standard Thickness (-10 +10%)

ASTM D-4802 thickness tolerances (-5%/+5%) can be manufactured to upon request.

Length +1/4", -0"

Width +1/4", -0"

Squareness -comparison of diagonal measurement

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Sheet Dimension	Max Difference in Measurement
> 48"	1/8"
> 48" but < 72"	3/16"
> 72" but < 96"	1/4"
> 96" but < 168"	3/8"

The below inclusion based on 4 x 8 sheet, except where noted.

Bubbles

1/32" - 1 per 4 sq. ft allowed. Over 1/32" - none allowed. Less than 1/32" disregard unless clusters form causing major visual defects.

Foreign Particles Black or Red Specks. Dust, Etc.

Less than 1/32" disregard unless clusters form chain bubbles causing major visual defects.

1/32" - 1 per 4 sq. ft allowed.

Over 1/32" - none allowed.

Foreign Color Forming V-Patterns, Wavy and Straight Lines or Bands.

None allowed where a discernible pattern can be visually seen.

Die Lines

No visually detected die lines when inspected at 30" distance under normal factory lighting held 45 degrees – 90 degrees to the line of sight.

Chatter

Must comply to established visual standards.

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Pits

1/16" - 1" per 4 sq. ft allowed. Over 1/16" - none allowed. Less than 1/16" - allowable unless there is a discernible pattern.

Parting Lines

None allowed as seen in normal factory light, add point source light.

Flow Line on Air Traps

None allowed which can be visually detected under point source light.

Warble

Must comply to established visual standards viewed under point source light.

Scratches

No visually detected scratches when inspected at 30" distance under normal factory lighting held at 45 degrees to 90 degrees to the line of sight.

Sawdust Contamination

None allowed under the masking or between surfaces. No build-up of sawdust can be fused along sheet edge.

Flatness (Warpage)

1/4" maximum displacement from perfect flatness for a 4' x8' size sheet.

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