

Spartech Polyester Sta-Tuf®

Thermoplastic

Spartech Plastics

Описание материалов:

Sta-Tuf® High Impact Thermoplastic Alloy.

For formed, flat or fabricated letters and other sign applications, Sta-Tuf offers an ideal combination of physical properties. This unique material provides extra-high impact resistance over ten times tougher than conventional acrylic sheet plus outstanding weather resistance and formability. Combined with easy solvent cementing and fabrication characteristics, Sta-Tuf is value engineered for cost performance. Flat Sta-Tuf is available in 10 standard sign colors; corrugated Sta-Tuf in three standard colors.

Fabrication. Sta-Tuf can be sawed, drilled and routed with conventional equipment recommended for acrylic sheet, and can be punched or die cut if proper procedures are followed. Painting, silk-screening, vinyl application, and other decorative techniques are easily accomplished; and Sta-Tuf can be joined to itself or other materials by adhesive or solvent bonding. Mechanical fastening with screws, rivets, etc., may be successful depending on the end use; please contact your Spartech Plastics Technical Sales Representative for guidelines specific to your custom requirements.

Cutting. Sta-Tuf can be cut with standard power sawing equipment, including table saws, band saws, jig and sabre saws, and portable circular saws. Standard hollow-ground, high-speed, cross-cut steel blades are adequate for most sawing operations, but carbide-tipped blades may be used for longer blade life. Saw blades should have a 0-10 degree positive rake angle. Depending on thickness of the material, there should be from 4 to 8 teeth per inch. All teeth should be of uniform height. Saws should be run at speeds of 8,000 to 12,000 linear feet per minute.

Metal-cutting type band saw blades, with 10 to 14 teeth per inch, should be used. Blade speeds between 4,000 and 5,000 feet per minute are recommended. In general, the thicker the material, the slower the recommended speed to avoid overheating. Speed, feed, and thickness of stock should allow each tooth to cut a clean chip.

Drilling. Sta-Tuf may be drilled with modified, standard high-speed, steel twist drills. The drills should have slow spirals and wide polished flutes. The included tip angle should be ground to 60 degrees and the cutting edge dubbed off to a zero degree rake angle. Back lip clearance angles should be ground to 12 to 15 degrees.

Cementing. Conventional solvent cements will readily join Sta-Tuf; if cementing to the back (dull) surface does not produce satisfactory results, add 25% MEK to the solvent. Polymerizable cements such as PS-30 and Weld-On 40 yield excellent results with Sta-Tuf.

Thermoforming. The broad, forgiving thermoforming "window" and unmatched resistance to in-shop breakage characterize Sta-Tuf as extremely versatile in nearly all forming operations from high-volume, multistation rotary machines to single station and shuttle presses. Forming temperatures of approximately 300-325°F are suggested as a starting point for good detail and best parts. Please contact Spartech Plastics for further suggestions on proper forming procedures.

Painting. Any standard acrylic paint such as Lacryl® and Grip-Flex® is recommended for use with Sta-Tuf. First-surface decoration with vinyl has also been proven very successful. Follow the manufacturer's guidelines for proper painting, paint removal, and vinyl application techniques as recommended for conventional acrylic sheet.

Главная Информация

UL YellowCard	E139482-222842
Характеристики	Ультра высокая ударпрочность Распылитель Обработываемый Сплоченность Хорошая адгезия Хорошая устойчивость к погоде Теплостойкость, высокая
Внешний вид	Доступные цвета
Формы	Лист
Метод обработки	Термоформовка

Физический	Номинальное значение	Единица измерения	Метод испытания
Удельный вес	1.10	g/cm ³	ASTM D792
Твердость	Номинальное значение	Единица измерения	Метод испытания
Твердость Роквелла (R-Scale)	99		ASTM D785
Механические	Номинальное значение	Единица измерения	Метод испытания
Модуль растяжения	2070	MPa	ASTM D638
Прочность на растяжение (Yield)	37.9	MPa	ASTM D638
Флекторный модуль	2070	MPa	ASTM D790
Flexural Strength (Yield)	57.2	MPa	ASTM D790
Воздействие	Номинальное значение	Единица измерения	Метод испытания
Зубчатый изод Impact			ASTM D256
0°C	37	J/m	ASTM D256
23°C	110	J/m	ASTM D256
Ударное падение Dart (23°C)	15.6	J	ASTM D3029
Тепловой	Номинальное значение	Единица измерения	Метод испытания
Температура отклонения при нагрузке (1.8 MPa, Unannealed)	85.0	°C	ASTM D648
CLTE-Поток	9.9E-5	cm/cm/°C	ASTM D696
Воспламеняемость	Номинальное значение	Метод испытания	
Огнестойкость (1.57 mm)	НВ	UL 94	
Оптический	Номинальное значение	Метод испытания	
Блестящий Гарднер	99	ASTM D523	
Дополнительная информация	Номинальное значение	Единица измерения	
Thermoforming Molding Temperature	149 - 163	°C	

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