

Royalite R722

Acrylic (PMMA) + PVC

Spartech Plastics

Описание материалов:

ROYALITE® R722 thermoplastic sheet is specifically formulated to meet the stringent requirements of FAR Part 25, Appendix F as it relates to plastics used in the interior of aircraft. It consistently meets FAA guidelines for flammability, heat release and smoke density using methods set forth in FAR Part 25, Appendix F, Parts I, IV, and V, respectively, at thicknesses down to 0.040in.

APPLICATIONS:

The unique formulation of ROYALITE® R722 not only allows it to meet the FAA guidelines, but gives specifiers, engineers and thermoformers a material that surpasses all others in its class in processability and durability. This material offers a superior range of physical and mechanical properties over other related materials, and its ease in thermoforming and machining make it the new material of choice for such aircraft components as interior walls, window surrounds, seats, trays, partitions, galley and lavatory panels. Its high rigidity and toughness allows for weight reduction by supporting thinner-walled parts.

PROCESSING:

ROYALITE® R722 thermoplastic sheet can be processed on most standard thermoforming equipment using conventional forming methods. For some complex shapes and deep draw parts, it may be necessary to use predraw boxes and/or plug assists. It is suitable for use with aluminum and epoxy molds and fine-grain wood molds such as mahogany. Temperature-controlled molds are recommended with the temperature maintained between 140°F-160°F. Care must be taken in forming so as not to overheat the sheet because ROYALITE® R722 is a PVC/acrylic alloy. Stock temperatures of approximately 325°F-355°F (IR measured) are recommended for proper forming. Best results are achieved by "soaking" the sheet with heat, utilizing lower power settings and longer cycle times. As with any thermoplastic material, care should be taken to account for the coefficient of thermal expansion when considering design parameters. Please contact Royalite for data relating to a specific application or equipment.

COLORS & TEXTURES:

ROYALITE® R722 is offered in a tremendous range of colors with a multitude of textures ranging from smooth to deep-textured. This Royalite product is capped with calendered film, which provides exceptional color and gloss control, plus outstanding grain retention after forming.

FINISHING:

With conventional plastic fabricating tools, it is possible to machine, saw, drill, rout and grind this rigid Royalite sheet. It can be punched and die-cut, sanded and polished easily. As long as proper procedures are followed, this material can be joined to other materials, or itself, by adhesive bonding, ultrasonic welding and by mechanical fasteners such as screws and rivets. Please contact Royalite for specific recommendations.

CHEMICAL & STAIN RESISTANCE, CLEANABILITY:

ROYALITE® R722 is resistant to a wide range of concentrated chemicals, including aqueous acids and bases, alcohols, lubricating oils and greases and motor fuels. It also exhibits very good stain resistance to common staining agents. Therefore, it is easily and safely cleaned with mild detergents or multi-purpose cleansers such as Fantastic® or Formula 409®. As with all plastics, extreme care should be taken when selecting a cleaning agent; some solutions may leave a residue or discolor the material. Contact Royalite for suggested guidelines.

AVAILABILITY:

ROYALITE® R722 is available in various custom colors, grain textures, gauges and blank sizes subject to normal production scheduling. Maximum width available is 58". The available gauge range is 0.040"-0.250". Widths and gauges outside the standard are available with some restrictions.

Главная Информация

Характеристики	Ультра высокая ударпрочность
	Ультразвуковой сварочный
	Низкий дым
	Жесткий, высокий
	Жесткий, высокий
	Высокая прочность на растяжение
	Сопrotивление пятнам
	Обрабатываемость, хорошая
	Обрабатываемый
	Очищаемый

Сплоченность
 Хорошая адгезия
 Низкая термостойкость
 Хорошая химическая стойкость
 Теплостойкость, высокая
 Долговечность
 Огнестойкий

Используется
 Тонкостенные детали
 Интерьер самолета
 Кронштейн Лоток
 Сиденье

Рейтинг агентства
 FAA 14 CFR часть 25 приложение. F части I, IV и V
 Далеко 25-25853A
 Далеко 25-25853B

Формы
 Частицы

Метод обработки
 Термоформовка

Физический	Номинальное значение	Единица измерения	Метод испытания
Удельный вес ¹	1.49 - 1.55	g/cm ³	ASTM D792
Твердость	Номинальное значение	Единица измерения	Метод испытания
Твердость Роквелла (R-Scale)	105		ASTM D785
Механические	Номинальное значение	Единица измерения	Метод испытания
Прочность на растяжение-Поток (Yield)	41.4	MPa	ASTM D638
Флекторный модуль	2690	MPa	ASTM D790
Flexural Strength	68.9	MPa	ASTM D790
Устойчивость к истиранию (1000 Cycles, 1000 g, CS-10 Wheel)	30.0	mg	ASTM D1044
Воздействие	Номинальное значение	Единица измерения	Метод испытания
Зубчатый изод Impact (22°C)	430	J/m	ASTM D256
Тепловой	Номинальное значение	Единица измерения	Метод испытания
Температура отклонения при нагрузке (1.8 MPa, Annealed)	73.9	°C	ASTM D648
Воспламеняемость	Номинальное значение	Единица измерения	Метод испытания
FAA Flammability			FAR 25.853
1.02 mm ²	Passes		FAR 25.853
1.02 mm ³	Passes		FAR 25.853
OSU пиковый коэффициент теплоотдачи			ASTM E906

1.02 mm	35.0	kW/m ²	ASTM E906
3.18 mm	50.0	kW/m ²	ASTM E906
OSU полное отведение тепла-2 мин			ASTM E906
1.02 mm	50.0	kW·min/m ²	ASTM E906
3.18 mm	45.0	kW·min/m ²	ASTM E906
Плотность Дыма			ASTM E662
1.02 mm	140		ASTM E662
Ds @ 4min : 3.18 mm	100		ASTM E662

NOTE

1. Color Dependent
2. FAR Part 25, Appendix F, Part I, Section (a)(1)(ii)
3. FAR Part 25, Appendix F, Part I, Section (a)(1)(i)

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