

Technical Information

Product Description

PLEXIGLAS RESIST® 45, -65, -75, -100

Product and Application

PLEXIGLAS RESIST® is a highly weather-resistant sheet material extruded from **impact-modified** acrylic (polymethyl methacrylate, PMMA). The grades RESIST 45, -65, -75, -100 show increasing impact strength in that order. The sheets therefore offer **greater break resistance** than standard acrylic during

- transport and handling,
- the entire fabrication process,
- installation and
- subsequent use.

PLEXIGLAS RESIST® combines the positive properties of PMMA with the toughness of other plastics such as polycarbonate (PC).

The opposite graph shows the impact resistance of RESIST sheets as compared with PC and the basic grade PLEXIGLAS® XT 20070.

Very often, extreme break resistance is uneconomical. In this case, the individual, custom-tailored solutions offered by PLEXIGLAS RESIST® are particularly advantageous.

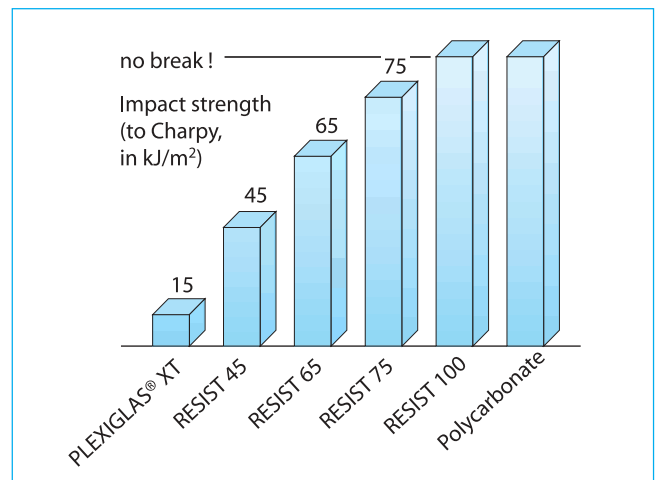
PLEXIGLAS RESIST® is highly weather resistant and durable. Unlike other plastics (e.g. PC, PET, PETG) it requires no additional UV protection.

PLEXIGLAS RESIST® is therefore a highly versatile and absolutely reliable material for

- structural glazing outdoors, e.g. barrel vaults for bus-stops, bicycle stands, walkways,
- protective glazing such as general access protection, housings for machines, equipment and workplaces,
- vehicle glazing, e.g. windshields for motorcycles and scooters, interior glazing in buses and trains,
- glazing of shop fittings and counters,
- signage, e.g. illuminated signs, indicator panels, advertising pillars,
- P.O.P. displays and sales stands, glazing of vending machines, drawing equipment etc.

In the field of vehicle glazing, PLEXIGLAS RESIST® 75 is suitable for use in classes E to F according to the German regulation ABG No. 2326 (e.g. trailers, caravans, building site vehicles, forklift trucks, motorcycle windshields etc.). Moreover, it is approved to DOT-112, AS-6, M-34 to M-84.

All clear-transparent RESIST sheets are approved for food-contact applications (FDA Regulation 21 CFR § 177.1010 and European Directive 90/128/EEC).



Chemical Resistance

The chemical resistance roughly corresponds to that of PLEXIGLAS® XT 20070. We will be pleased to answer specific inquiries about compatibility with given substances.

Machining

Owing to its increased toughness, PLEXIGLAS RESIST® lends itself perfectly to sawing, drilling, milling, grinding and polishing under conditions corresponding to the material. Twist drills must have specially ground bits for acrylic. Only slight pressure should be exerted during polishing. For more precise recommendations, please consult our Guidelines for Workshop Practice.

The appropriate accident prevention regulations and statements of tool manufacturers must be observed during machining.

PLEXIGLAS RESIST® can be laser-cut. The gloss of the lasered edge changes at increasing impact strength. Clear edges can be obtained by wiping them with petroleum ether.

Bonding

PLEXIGLAS RESIST® is as easy to bond as the basic grades of PLEXIGLAS® XT, e.g. using the solvent-type adhesives ACRIFIX® 116 and 117 as well as the gap-filling polymerization adhesives ACRIFIX® 190 and 192. With the latter, it should be borne in mind that the joints show lower impact strength than the bonded parts made of PLEXIGLAS RESIST®. The bond strength diminishes at increasing impact strength.

Properties

This table summarizes the major physical **properties** (typical values at 23 °C / 50% R.H.).

Properties	PLEXIGLAS RESIST® 45 Clear 03926	PLEXIGLAS RESIST® 65 Clear 03922	PLEXIGLAS RESIST® 75 Clear 03921	PLEXIGLAS RESIST® 100 Clear 03923	Unit	Test Standard
Density	1.19	1.19	1.19	1.19	g/cm ³	ISO 1183
Impact strength (Charpy)	45	65	75	no break	kJ/m ²	ISO 179/1 fu
Notched impact strength (Charpy)	3.5	6.5	7.5	8.0	kJ/m ²	ISO 179/1eA
Tensile strength	60	50	45	40	MPa	ISO 527-2/1B/5
Nominal elongation at break	10	15	20	25	%	ISO 527-2/ 1B/50
Elastic modulus (short-term value)	2700	2200	2000	1800	MPa	ISO 527-2/1B/1
Flexural strength	95	85	77	69	MPa	ISO 178
Cold-curving radius, min.	300 x thickn.	250 x thickn.	210 x thickn.	170 x thickn.	–	–
Coefficient of linear thermal expansion (0 to 50 °C)	7·10 ⁻⁵ (= 0.07)	8·10 ⁻⁵ (= 0.08)	9·10 ⁻⁵ (= 0.09)	11·10 ⁻⁵ (= 0.11)	1/K (mm/m °C)	DIN 53752-A
Permanent service temperature, max.	70	70	70	65	°C	–
Reverse forming temperature	> 80	> 80	> 75	> 70	°C	–
Vicat softening temperature	101	100	100	97	°C	ISO 306, Method B50
Transmittance (380...780 nm)	91	91	91	91	%	DIN 5036, Part 3
UV transmission	none	none	none	none	–	–
Surface resistivity	> 10 ¹⁴	> 10 ¹⁴	> 10 ¹⁴	> 10 ¹⁴	ohm	DIN VDE 0303, Part 3
Fire rating	B 2	B 2	B 2	B 2	–	DIN 4102
Water absorption (24 h, 23 °C) from dry state; specimen 60 x 60 x 2 mm ³	41	45	46	49	mg	ISO 62, Method 1

Forming

The forming conditions are the same as for PLEXIGLAS® XT basic grades. The thermoforming temperature should be between 140 °C and 160 °C, the range in which the material is thermoelastic. There is no need for predrying provided the sheets are stored correctly, covered with their protective PE masking.

The material turns white during heating but this color disappears again as the material cools down.

PLEXIGLAS RESIST® can also be installed cold-curved, provided the minimum cold-curving radius is observed (see table).

Coating and Screen Printing

The same paints and inks can in principle be used as for the basic grades of PLEXIGLAS® XT. However, we recommend carrying out prior tests in each case.

Cleaning and Care

PLEXIGLAS® is easy to clean. Do not rub dry. Dusty surfaces can be cleaned with warm water to which some dishwashing liquid has been added, using a soft cloth or sponge. The "Antistatische Kunststoff-Reiniger + Pfleger (AKU)" (Antistatic Cleaning + Care Agent for Plastics) from Burnus GmbH, Darmstadt, is most suitable for PLEXIGLAS RESIST®.

Physical Forms

Sheets of PLEXIGLAS RESIST® are supplied with a smooth surface and protective PE masking on both sides. The standard size is 3050 x 2050 mm. Standard grades (Clear, White) and thicknesses are available from stock. On request, we will be pleased to inform you about other sizes (e.g. greater lengths), colors, sizes/cut-to-size sections,

degrees of impact strength, thicknesses up to 20 mm and other terms of delivery.

This leaflet presents the special characteristics of PLEXIGLAS RESIST®. A further product description leaflet is available on the general behavior of PLEXIGLAS® XT basic grades (Ref. No. 231-1).



Certified to DIN EN ISO 9001 (Quality) and DIN EN ISO 14001 (Environment)

Our technical advice on the applications of our products is given without obligation. The buyer is responsible for their use and processing, and is also liable for observing any third-party rights. Technical data concerning our products are typical values.

Subject to alteration.

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Important notice

This is an international English-language information prepared for several markets. It is essential that the selection of particular materials and their methods of use conform with the requirements of national and local Building Regulations.

Delivery and advice: