



## PROCESSING & CLEANING – MANUAL

**SPECIAL CARE: NEVER remove PE film from surfaces before installation**

### CIRCULAR SAW MACHINES – LINEAR SAW MACHINE

To cut panels raw with a circular saw machine there can be used blades in 300 till 400mm in diameter. Typical rotation speed is 3000 top 5000 rpm. Blades i.e. 350 mm in diameter should have not less than 30 knives and not more than 80. blade thickness is suggested to be not less than 3mm to avoid induced vibration by thick sheets. Liquid cooling on blade is not necessary even if recommended. Steel kind of the knives must to be chosen taking in account not only to the plastic nature of the panel but also on hardness of some -acrylic couture- inlays (inox, fabrics...)

### LASER MACHINES

Laser cut of PMMA is possible, evidently must to be considered that laser kind (CO2, IAG laser, Pulsed laser..) have to cut both sheets and also inlays. For this reason laser cut on AC sheets is not recommended

### WATER CUT

Water cut offers a nice cut, sanded-look. No limits on this technology applied to -acrylic couture- sheets.

### MILLING MACHINE – MILLINGS

Milling machine is the most common technology to mill and shape -acrylic couture- panels. Tools can be chosen by the aluminum tool catalogue. Knives steel quality must to be chosen taking in account also nature of the embedded inlays. Speeds of these machines must to be turned to obtain a translucent sanded-look cut. Spindle rotation speed can be adjusted from 3.000 to 25.000 rpm and speed cut must not exceed 2 meter/minute. Diamond-coated tools to obtain a perfect cut can be used with some limitations: some of our textures contain steel, this will lead to a premature loss of efficiency of these kind of tools.



## **POLISHING OF EDGES – SURFACES**

Edges can be polished easily: first passage is to remove irregularities of the cut (if necessary) with some abrasive tools: glass paper, abrasive discs, sand machine etc.

After this passage edges will look regular and sandy. With a polishing fat paste and a cotton rotative disc it is possible to polish till a glass look transparent cut. In same way also scratches on surface can be removed.

## **GLUEING**

-acrylic couture- panels can be glued like conventional cast acrylic sheets (PMMA).

## **TEMPERATURE RANGE**

-acrylic couture- panels can carry on temperatures ranging from -40°C to 70°C. Take in consideration, in case of framing of the panels, dilatation constants of PMMA specified in datasheet.

## **FOOD CONTACT – HUMAN CONTACT**

-acrylic couture- panels are manufactured according to EU rules for food contact and EU standards for fashion accessories applied to human body

## **TOLERANCES:**

Thickness:  $\pm 0,6$  mm+10% of the nominal thickness (extended UNI EN 7823);  
sheet dimensions:  $\pm 3\%$  on nominal size

## **CLEANING:**

- For cleaning there should be only used clear water, some drops of dishwashing liquid and a soft sponge. Do not use cleaners based on alcohol! Microfiber cloth is not suitable!
- Dry the panels with a clean, moisturized shammy leather.



- Sponge and shammy leather should be used only for cleaning of acrylics and should be well rinsed before
- Dust should not be wiped dryly
- Cleaning from dust must be done with virgin cotton tissue, soap and water or NEUTRAL cleaners for glass. Absolutely forbidden the use of alkali, salts, acids, hydrocarbons, gasoline, alcohols, ammonia, solvents...
- Slight traces of usage can be removed easily with suitable polishes for acrylics
- The panels should not be brought into contact with organic solvents like thinner, alcohols, fuels etc. Also cleaners for windows often contain alcohols. Fumes of thinners are also harmful.
- Polishes and finishes mostly contain sealing and dirt-resistant ingredients and should be used regularly

### **AMBIENT COMPATIBILITY – BIO COMPATIBILITY**

-acrylic couture- methacrylates are non-toxic, non-cancer genic, non-teratogenicity, non-mutagenic EVEN IF SWALLOWED; -acrylic couture- polymers are manufactured with same polymer used for human implant ology in another division of our same company. -acrylic couture- polymers are derived by non-cancer genic monomers. -acrylic couture- panels are protected by food-grade PE film.

- “Cross-linked” polymers for higher resistance to scratching and many chemicals compared to conventional PMMA
- 30-year guarantee on UV resistance /weathering
- 100-year guarantee based on very high molecular density against polymer degradation
- -acrylic couture- panels are 100% recycable