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Product Data

Standard Polycarbonate Mirror

Product Specification: Standard Grade Polycarbonate Mirror

- Material Grade:** Standard Grade Lexan Mirror Polycarbonate Sheet with Improved Optical Quality.
- Material Color:** Clear and Bronze 5109, Gray 713
- Scope:** Specification for Standard Quality Polycarbonate Mirror. Parameters and manufacturing tolerances are outlined in this specification sheet. Although Polycarbonate sheets cannot be made completely without flaws, the use of this document will insure only those sheets meeting this specification will be used for Standard Grade Mirror.

<u>Property</u>	<u>Requirement</u>		<u>Test</u>
<u>1.0 Dimension</u>			
1.1 Gauge Tolerance	.030"	+ - 10%	TMB 2000
Nominal Gauge Range Available .030 - .118"	.118"	+ - 5%	
1.2 Width Tolerance	+ 1.5"	- 0"	TMB4000
1.3 Length	+ 2.0"	- 0"	TMB 5000
<u>2.0 Appearance</u>			
2.1 Warpage	.500" (Max.)		TMB 1800
2.2 Squariness	.500" (Max.)		TMB 2400
2.3 Ripples/Distortion	Compared Against Visual Standard MGVS		TMB 2700
2.4 Die Lines	Compared Against Visual Standard (Vertical)		TMB 2800

<u>Property</u>	<u>Requirement</u>	<u>Test</u>
<u>3.0 Mirror Defects</u>		TMB 3200
Substrate Defects 100% Visual Inspection Performed Vertically		
3.6 Inclusions, Bubbles, Black/White Specks,		TMB 3210
	Max. Defect Per Sq. Ft.	
Defect Size		
.066" - .085"	1	
.040" - .065"	3	
.030" - .039"	3	
.020" - .029"	12	
3.7 Pits, Dimples,		TMB 3600
	Max. Defect Per Sq. Ft.	
Defect Size		
.065" - .085"	1	
.050" - .064"	2	
.030" - .049"	8	
<u>4.0 Mirror Defects</u>		TMB 4800
Visual Defects 100% Visual Inspection performed Vertically		
4.2 Aluminum Splater	Max. Defects Per Sheet	TMB 4815
Defect Size		
.080" .500"	1 Cluster	
4.3 Voids, White Spots,		TMB 4820
	Max. Defect Per Sq. Ft.	
Defect Size		
.066" - .085"	1	
.040" - .065"	2	

.015" - .039"

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<u>Property</u>	<u>Requirement</u>	<u>Test</u>
<u>4.4 Scratch Lines</u>		TMB 4910
Surface or Mirror Side	Width \leq .020"	
Length		
.500" - 1.0"	1	
.250" - .500"	4	
<u>4.5 Protective Backing</u>		TMB 4950
Painted Side		
4.5 Thickness	Not Less Than 1.0 Mil Gray Backcoat	TMB 4960
4.6 Uniformity	Pass	TMB 4980
<u>5.0 Packaging</u>		TMB 5500
Masking, Shipping Container		
5.1 Protective Masking	Front / Clear PE Back Masking Optional Brown Craft Paper	TMB 5510
5.3 Bulk Packed 5530	4' x 8' Skid Quantities Foam Interleaved	TMB

Notes:

- Inspection of Standard Grade Polycarbonate Mirror shall be accomplished using the test methods as indicated in this specification sheet. If a defect does not appear using these test methods, it will not be considered a defect.

- There shall be no more than 1 splatter cluster on a sheet, and limited to 20 % of total sheet area, leaving a minimum of 80 % useable sheet.
- Final inspection shall be done in a vertical position prior to masking.
- Random backcoating sags or minor areas of paint irregularities may occur that do not effect the mirrors quality, such paint blemishes will not be considered defects.
- Manufacture must be notified if any material rejected by customer or end user is to be returned, and must be returned in the same condition as it was received.