
**Plastics — Poly(methyl methacrylate)
sheets — Types, dimensions and
characteristics —**

**Part 3:
Continuous cast sheets**

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*Plastiques — Plaques en poly(méthacrylate de méthyle) — Types,
dimensions et caractéristiques —*

Partie 3: Plaques coulées continues

ISO 7823-3:2003

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 7823-3 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 11, *Products*.

ISO 7823 consists of the following parts, under the general title *Plastics — Poly(methyl methacrylate) sheets — Types, dimensions and characteristics*:

- Part 1: Cast sheets
- Part 2: Extruded sheets
- Part 3: Continuous cast sheets

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Plastics — Poly(methyl methacrylate) sheets — Types, dimensions and characteristics —

Part 3: Continuous cast sheets

1 Scope

This part of ISO 7823 specifies requirements for non-modified flat poly(methyl methacrylate) (PMMA) continuous cast sheets (plates) for general-purpose use. The sheets may be colourless or coloured, and may be transparent, translucent or opaque.

The thickness range of the sheets covered by this part of ISO 7823 is 1 mm to 10 mm.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 62:1999, *Plastics — Determination of water absorption*

ISO 75-1:—¹⁾, *Plastics — Determination of temperature of deflection under load — Part 1: General test method*

ISO 75-2:—²⁾, *Plastics — Determination of temperature of deflection under load — Part 2: Plastics and ebonite*

ISO 178:2001, *Plastics — Determination of flexural properties*

ISO 179-1:2000, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test*

ISO 291:1997, *Plastics — Standard atmospheres for conditioning and testing*

ISO 306:—³⁾, *Plastics — Thermoplastic materials — Determination of Vicat softening temperature (VST)*

ISO 489:1999, *Plastics — Determination of refractive index*

ISO 527-1:1993, *Plastics — Determination of tensile properties — Part 1: General principles*

ISO 527-2:1993, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics*

ISO 877:1994, *Plastics — Methods of exposure to direct weathering, to weathering using glass-filtered daylight, and to intensified weathering by daylight using Fresnel mirrors*

1) To be published. (Revision of ISO 75-1:1993)

2) To be published. (Revision of ISO 75-2:1993)

3) To be published. (Revision of ISO 306:1994)

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ISO 1183-1:—⁴⁾, *Plastics — Methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pycnometer method and titration method*

ISO 1183-2:—⁵⁾, *Plastics — Methods for determining the density of non-cellular plastics — Part 2: Density gradient column method*

ISO 2039-2:1987, *Plastics — Determination of hardness — Part 2: Rockwell hardness*

ISO 2818:1994, *Plastics — Preparation of test specimens by machining*

ISO 2859-1:1999, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 4582:1998, *Plastics — Determination of changes in colour and variations in properties after exposure to daylight under glass, natural weathering or laboratory light sources*

ISO 4892-2:1994, *Plastics — Methods of exposure to laboratory light sources — Part 2: Xenon-arc sources*

ISO 4892-4:1994, *Plastics — Methods of exposure to laboratory light sources — Part 4: Open-flame carbon-arc lamps*

ISO 11359-2:1999, *Plastics — Thermomechanical analysis (TMA) — Part 2: Determination of coefficient of linear thermal expansion and glass transition temperature*

ISO 13468-1:1996, *Plastics — Determination of the total luminous transmittance of transparent materials — Part 1: Single-beam instrument*

ISO 13468-2:1999, *Plastics — Determination of the total luminous transmittance of transparent materials — Part 2: Double-beam instrument*

ISO 14782:1999, *Plastics — Determination of haze for transparent materials*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1 non-modified cast PMMA sheets
sheets based on homopolymers of MMA, or copolymers of MMA with acrylic or methacrylic monomers, produced by bulk polymerization in the presence of suitable initiators

3.2 flat PMMA sheets
sheets with two plane, substantially parallel surfaces

4 Composition

The amounts of plasticizing ingredients (materials that do not undergo chemical reaction to become a part of the polymer), other monomers and crosslinking agents (materials that produce the links between the chains of polymers) present shall be such that the basic properties are not changed from the values given in Table 3. These amounts are in most cases less than a mass fraction of 5 %.

Other additives, e.g. colorants, UV absorbers and pigments, may be included to give specific properties.

4) To be published. (Revision in parts of ISO 1183:1987)

5) To be published. (Revision in parts of ISO 1183:1987)

National environmental legislation and regulations shall be followed regarding additives.

5 General requirements

5.1 Protective coverings

Unless otherwise agreed upon by the interested parties, the surfaces of the sheet, as delivered, shall be protected by suitable materials, for example kraft paper secured with a water-soluble or pressure-sensitive adhesive, or a polyethylene film, which are readily removable without causing surface contamination or damage.

5.2 Appearance

5.2.1 Surface defects

The sheet shall have a smooth surface. There shall be no scratches, marks or other surface defects larger than 3 mm² each anywhere in the sheet.

5.2.2 Inclusion defects

There shall be no bubbles, inclusions, cracks or other defects that could adversely affect the performance of the sheet in its intended application which are larger than 3 mm² each anywhere in the sheet.

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5.2.3 Classification of defects

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The area of any defect found in the sheets shall be classified as specified in Table 1. Each defect shall be considered separately.

Table 1 — Classification of defects

Classification	Area of surface defect	Area of inclusion defect
Negligible	Less than 1 mm ²	Less than 1 mm ²
Acceptable	1 mm ² to 3 mm ²	1 mm ² to 3 mm ²

5.2.4 Distribution of defects

5.2.4.1 There shall not be a significant number (for the application) of small defects, each of which is defined as negligible in Table 1, within 1 m² anywhere in the sheet. What constitutes a significant number shall be agreed between the interested parties.

5.2.4.2 No defect defined as acceptable in Table 1 shall be within 500 mm of another acceptable defect anywhere in or on the sheet.

5.3 Colour

The colour distribution shall be homogeneous, unless otherwise specified. Variations in colour shall be agreed upon between the interested parties.

5.4 Dimensions

5.4.1 Length and width

The length and width of the sheet shall be agreed upon between the interested parties. For cut sheets, the tolerances for each sheet shall be as specified in Table 2.

Table 2 — Tolerances on length and width of cut sheets

Length or width mm	Tolerance mm
Up to 1 000	+3 0
From 1 001 to 2 000	+6 0
From 2 001 to 3 000	+9 0
3 001 and over	+0,3 % 0

5.4.2 Thickness

The thickness tolerance for sheets in the range from 1 mm to 10 mm and up to 6 m² in area shall be $\pm 0,1h$, where h is the nominal sheet thickness in millimetres.

The tolerances apply within each sheet and from sheet to sheet.

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5.4.3 Tolerances for other sheet sizes (standards.iteh.ai)

Tolerances for sheet sizes and thicknesses outside the above ranges shall be agreed upon between the interested parties.

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5.4.4 Conditions of measurement

Measurements of dimensions shall be made at room temperature, except that, in cases of dispute, measurements shall be made under standard conditions, as specified in ISO 291. For measurements made under ambient conditions, due allowance shall be made for dimensional changes due to the differences in temperature and relative humidity between test locations.

5.5 Basic and other properties

5.5.1 Basic properties

The basic mechanical, thermal and optical properties of sheets shall be as specified in Table 3.

5.5.2 Other properties

Other properties of sheets shall be agreed upon between the interested parties. Examples of, and test methods for, such properties are presented in Table 4.

Table 3 — Basic properties of PMMA cast sheets — Required values

Property	Unit	Test method	Required value	Subclause
Tensile strength	MPa	ISO 527-2/1B/5	min. 65	6.5.2
Tensile strain	%	ISO 527-2/1B/5	min. 4	6.5.2
Modulus of elasticity in tension	MPa	ISO 527-2/1B/1	min. 3 000	6.5.2
Charpy impact strength (unnotched)	kJ/m ²	ISO 179-1/1fU	min. 13	6.5.3
Vicat softening temperature	°C	ISO 306:—, method B50	min. 103	6.6.1
Dimensional change on heating (shrinkage)	%	Annex A	max. 2,5	6.6.3
Total luminous transmittance ^a	%	ISO 13468-1	min. 90	6.8.1
Light transmittance at 420 nm (thickness 3 mm) ^a				
— before exposure to xenon lamp	%	ISO 13468-2	min. 90	6.8.3
— after exposure to xenon lamp for 1 000 h (ISO 4892-2:1994, method A)	%	ISO 13468-2	min. 88	6.8.3

^a For transparent, colourless material.

Table 4 — Other properties of PMMA cast sheets — Typical values

Property	Unit	Test method	Typical value	Subclause
Flexural strength	MPa	ISO 178	110 to 115	6.5.1
Rockwell hardness		ISO 2039-2	100 to 105	6.5.4
Linear expansion coefficient	K ⁻¹	ISO 11359-2	7×10^{-5}	6.6.4
Temperature of deflection under load	°C	ISO 75-2/A	95 to 100	6.6.2
Haze ^a	%	ISO 14782	0,5 to 1	6.8.2
Refractive index, n_D^{23}		ISO 489:1999, method A	1,49	6.8.4
Density ^{a, b}	g/cm ³	ISO 1183-1:—, method A or C, or ISO 1183-2	1,19	6.9.1
Water absorption	%	ISO 62:1999, method 1 (24 h, 23 °C)	0,5 ^c	6.9.2

^a For transparent, colourless material.
^b Coloured sheets may have a higher value.
^c Value reported refers to a square specimen of edge 50 mm and thickness 3 mm.

6 Test methods

6.1 General

6.1.1 Sampling

The sampling procedure shall be agreed upon between the interested parties. The sampling procedure given in ISO 2859-1 is widely accepted and frequently used. Hence it is recommended.

6.1.2 Conditioning and testing atmospheres

Conditioning of specimens (48 h) and tests shall be carried out in accordance with ISO 291 at 23 °C ± 2 °C and (50 ± 5) % relative humidity, except for the Vicat softening temperature, temperature of deflection under load and dimensional change on heating (shrinkage) (see 6.6.1, 6.6.2 and 6.6.3).