

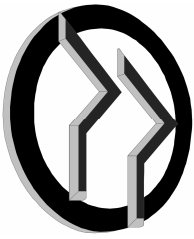
PROFESSIONAL PLASTICS, INC.

10641 S. Sam Houston Pkwy West, Bldg 100, Suite 5 ~ Houston, TX 77071
Toll Free: (877) 216-7767 ~ Phone: (281) 879-4500~ Fax: (281) 879-4502
Visit our website: www.professionalplastics.com

Product Specification: ProLens-6X
Material Grade: Flame Retardant
Hard Mar Resistant Coated Sheet
Material Color: Clear

	<u>Property</u>	<u>Requirement</u>	<u>Test Method</u>
1.0	Dimensions		
	1.1 Gauge Tolerance		TM0002
	Nominal Gauge Ranges	Min. Limit of Nominal	Max. Limit of Nominal
	.059”-.080”	-10%	+10%
	.093”-.125”	-5%	+5%
	1.2 Width Tolerance		TM0004
	.093”-.125”	+1/2”	.75”
	.039”-.080”	Web	Web
	1.3 Length Tolerance	+1/2”	+1”
2.0	Appearance		
	2.1 Warpage	Length divided by 100	TM0105
	2.2 Squareness on trimmed sheets only		
	Sheet Lengths up to 65”	.250(max)	
	2.3 Die Lines	Compared against visual standard VSR – 3.5 max	TM0028
	2.4 Ripples/Distortion	Compared against visual standard VSR – 3.5 max	TM0027
	2.5 Visual Defects (Base Sheet) 100% visual inspection performed		
	A. Black Specs		TM0032
	<u>Defect Size</u>	<u>Maximum per Square Foot</u>	
	.040”-.065”	1	
	.030”-.039”	1	
	.020”-.029”	2	
	.010”-.019”	9	

No clusters of 3 or more above 0.019” in a 1” diameter area



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B. Inclusions (Clear Surface) TM0031
TM0030

<u>Defect Size</u>	<u>Maximum per Square Foot</u>
.061”-.080”	1
.030”-.060”	2
.020”-.029”	3
.010”-.019”	15

2.6 Visual Defects (Coating) 100% visual inspection performed TM0118

A. Scratches/Fibers TM0059
TM0060

<u>Defect Size</u>	<u>Maximum per Square Foot</u>
Width <0.032”	
Length >1.00”	0
.251”-.500”	1
.040”-.250”	1
Width >0.032”	0

2.7 Coating Dewets TM0057

<u>Defect Size</u>	<u>Maximum per Square Foot</u>
.020”-.070”	1
.10”-.019”	4

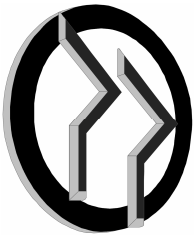
2.8 Coating Runs TM0058

<u>Defect Size</u>	<u>Maximum per Square Foot</u>
.020”-.187”	1

The total number of coating defects (combined runs, scratches, lint dewets) shall not exceed 5 per square foot.

This specification is intended to describe the quantity of defects that could occur in a square foot of a particular size. The operating specification is developed around a numerical rating system based on visual standards. This document in effect converts this visual standard into a written numerical specification.

<u>Property</u>	<u>Requirement</u>	<u>Test Method</u>
3.0 Flammability		
3.1 FAA 60Ext. Time	15 max.	TM0061
3.2 FAA 60Length	6 max.	TM0061
3.3 FAA 60Drip Time	3 max.	TM0061
4.0 Coating		
4.1 Scribe Adhesion	No coating removed by adhesive tape	TM0047



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4.2 Coating Thickness	.00020" (min) .00035" (max)	TM0050
4.3 Taber Haze (100 cycles)	10% (max)	TM0046
4.4 Cure Test	Pass	TM0117
5.0 Masking		
5.1 Masking Coverage	Pass	TM0043
5.2 Masking Appearance	Pass	TM0044

6.0 Packing/Identification

6.1 Masking Coverage

Clear or blue polystick masking is standard on both sides (as extruded) of each sheet.

6.2 Container

Sheets are packaged and the shipping containers marked in accordance to standard commercial practices.

7.0 Definitions of Parameters

Black Specks - Contamination associated with degraded polycarbonate. Appears as small carbon particles in the sheet.

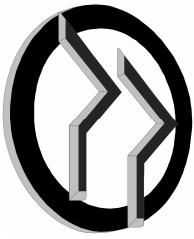
Inclusions - Colorless surface defect caused by airborne particle.

Coating Runs - Caused by the coating forming irregularly (usually a fanned out tail) around any of the defects. Measurements apply to the main portions of the tail as observed from an angle of 90 degrees to the surface. The defect causing the coating run is usually an inclusion, black speck, or fiber.

Lint - Airborne fiber adhering to the sheet during the coating operation.

Dewets - Small circular area not covered by the coating.

Scratches - Thin linear defects on the polycarbonate or coated surface.



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