



# GEVACRIL

○ ● ■ Cast and Extruded Acrylic Tubes, Rods, Bars, Balls ■ ● ○

## Quality description for EXTRUDED POLYCARBONATE TUBES<sup>1</sup>

### Contents

PREFACE .....	2
1 MATERIAL FEATURES .....	2
2 QUALITY DESCRIPTION .....	2
2.1 <i>Optical quality</i> .....	2
2.2 <i>Tolerances</i> .....	2
2.3 <i>Delivery conditions</i> .....	3
2.3.1 <i>Packing</i> .....	3
2.3.2 <i>Delivery packing</i> .....	3
2.4 <i>Identification</i> .....	4
2.4.1 <i>Product identification</i> .....	4
2.4.2 <i>Identification of the delivery cases</i> .....	4

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<sup>1</sup> In the whole text as QS. Our QS is written in conformity with the norms ISO 9002



## ○ ● ■ Cast and Extruded Acrylic Tubes, Rods, Bars, Balls ■ ● ○

### Preface

Our QS for extruded polycarbonate tubes has been valid since the year 2002. Purpose of this certification is to guarantee the excellent quality of every single tube.

The strict quality control during the production process and a constant improvement of the production technologies allowed the standardisation of the quality of the extruded polycarbonate tubes.

### 1 Material features

Extruded polycarbonate tubes are polymerized plastic semi-finished products. They are manufactured through the process of extrusion. After the production process they are clear and bright both on the internal and the external wall. High purity, brightness and transparency are their most important characteristics; besides they are very high impact resistance and an unequalled resistance against weather conditions and ageing, since the optical quality and the light transmittance remain unchanged over years.

### 2 Quality description

#### 2.1 Optical quality

Extruded polycarbonate tubes are absolutely colourless and have a clear internal and external wall. They are free of bubbles, filaments, foreign bodies and rings. In spite of this, the manufacturing process of extrusion causes some light stripes which are visible from a short distance. These stripes are admitted but should not condition the optical quality and the transparency of the entire tube.

Following defects are not admitted:

- Deep scratches;
- Bubbles, inclusions or foreign bodies, unpolymerized stuff in the material bigger than
- 2 mm<sup>2</sup>/meter;
- orange peel effect
- crazing effect

#### 2.2 Tolerances

In order to guarantee an excellent standard quality the extruded acrylic tubes are controlled many times during the production process. Tubes that show worse values than those indicated in the table 1 do not get through the quality control and are systematically rejected.



## ○ ● ■ Cast and Extruded Acrylic Tubes, Rods, Bars, Balls ■ ● ○

Table 1: Tolerances

External Diameter Ø mm.	Standard length mm.	Thickness mm.	Tolerances	
			On external diameter mm.	On thickness mm.
10	2000	1/2/3	± 0,3	± 0,20/0,25/0,30
12	2000	1/2/3	± 0,3	± 0,20/0,25/0,30
15	2000	1/2/3	± 0,3	± 0,20/0,25/0,30
20	2000	1/2/3	± 0,3	± 0,20/0,25/0,30
25	2000	2/3	± 0,5	± 0,25/0,30
30	2000	2/3/4/5	± 0,5	± 0,25/0,30/0,35/0,40
38	2000	2/3	± 0,8	± 0,25/0,30
40	2000	2/3/4/5	± 0,8	± 0,25/0,30/0,35/0,40
50	2000	2/3/4/5	± 0,8	± 0,25/0,30/0,35/0,40
60	2000	2/3/4/5	± 0,8	± 0,25/0,35/0,35/0,40
70	2000	2/3/4/5	± 0,8	± 0,30/0,35/0,40/0,40
80	2000	2/3/4/5	± 0,9	± 0,30/0,35/0,40/0,45
90	2000	2/3/4/5	± 0,9	± 0,30/0,35/0,40/0,45
100	2000	2/3/4/5	± 1,2	± 0,30/0,35/0,40/0,45
110	2000	3/4/5	± 1,2	± 0,35/0,40/0,45
120	2000	3/4/5	± 1,2	± 0,35/0,40/0,45
130	2000	3/4/5	± 1,3	± 0,35/0,40/0,50
150	2000	3/4/5	± 1,5	± 0,40/0,45/0,50
200	2000	3/4/5	± 1,5	± 0,40/0,45/0,50

## 2.3 Delivery conditions

### 2.3.1 Packing

Type of packing:

- PE stretch-film

Packing unit:

The tubes are packed in bundles until an O.D. of 60 mm.; every tube is single packed starting from an O.D. of 70 mm.



## ○ ● ■ Cast and Extruded Acrylic Tubes, Rods, Bars, Balls ■ ● ○

### 2.3.2 Delivery packing

Extruded polycarbonate tubes are set in wooden pallets. The standard delivery packing include:

- wooden base (Palette);
- the tubes – packed as in 2.3.1 - are wrapped up in PE film and sealed with plastic tape.

The tubes are delivered on standard wooden pallets which are adapted and optimised to the volume of the goods ordered

## 2.4 Identification

### 2.4.1 Product identification

A label on every acrylic tube indicates:

- product;
- external diameter;
- internal diameter;
- length;
- day, month, year of production;
- quality control approval.

### 2.4.2 Identification of the delivery crates/boxes

A label on every delivery case – as in 2.3.2 – indicates:

- destination address;
- detailed case content.

Ask for more information by fax at 0039 02 95737357 or by mail at [info@gevacril.com](mailto:info@gevacril.com)<sup>2</sup>

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<sup>2</sup> The information given refers only to the specific products indicated in the QS. Gevacril considers this information right, reliable and in conformity to the specific technical information available on the market at the moment of their printing but do not give any guaranty for them and for any kind of application or processing of the above mentioned products