



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

Quality description for GEVACRIL-METALLIC TUBES¹

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



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Preface

Our QS has been valid since 2005. Purpose of this certification is to guarantee the excellent quality of every single ACRYLIC METALLIC TUBE.

The strict quality control during the production process and a constant improvement of the production technologies allowed the standardisation of the high quality of ACRYLIC METALLIC TUBE.

1 Material features

ACRYLIC METALLIC TUBE are polymerized plastic semi-finished products. They are got through casting and centrifugation and they are known as ACRYLIC METALLIC TUBE. After the production process they have a shimmering metallic outer wall and have a perfectly smooth surface. High purity and brightness are their most important characteristics.

2 Quality description

The QS - quality description - includes following contents: optical quality; thermic features; weather resistance; tolerances; delivery condition.

2.1 Optical quality

ACRYLIC METALLIC TUBE have a metallic shimmering surface and are produced in different colours. They are free of any kind of tracks or deep scratches. In spite of this some optical defects are not to avoid while looking sidelong through the tubes. Following defects are admitted:

- some optical pigment alterations²;
- see table 1:

² This effect is due to the centrifugation. Some pigment alteration in form of ring may occur on the surface. These should not alter the optical quality of the entire tube



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Table 1: Admitted defects

Defect group	Superficial scratch mm	Rings or spots on the external wall	Bubbles, foreign bodies, filaments mm ²	max. number of defects admitted on 300 mm. of tube
A	≤ 1,0	many ³	≤ 1,0	many ⁴
B	> 1,0 – 2,0	some	> 1,0 – 2,0	5 LD (B)
C	> 2,0 – 5,0	some	> 2,0 – 5,0	1 MD (C) + 2 LD (B) ⁵
D	> 5,0 – 25,0	*	> 5,0 – 25,0	1 BD (D) ⁶

Table 1: A = negligible defect; B = little defect (LD); C = medium defect (MD); D: big defect (BD)⁷.

Following defects are not admitted:

- Deep scratches;
- Unpolymerized stuff in the material bigger than 10 mm.²;
- rests of polishing material.

2.2 Thermic features

- As acrylic glass is characterised by particularly long molecules, the cast acrylic tubes remain in a solid state until 110 °C. Due to the pigments, we advise to use the ACRYLIC METALLIC TUBES only by service temperatures < 80 C.

2.3 Weather resistance

ACRYLIC METALLIC TUBE can be used either indoor or outdoor. They have a good weather resistance and are UV stabilized. In spite of this the presence of the pigments into the chemical composition could have a limited resistance in time and may cause some colour changes.

³ So long these defects do not alter the optical qualities of brightness and transparency on the whole tube

⁴ So long these defects do not alter the optical qualities of brightness and transparency on the whole tube

⁵ Minimal distance: MD to LD = > 100 mm

⁶ On the entire tube (2.000 mm.)

⁷ The data on the admitted defects are based on internal tests made by Gevacril srl



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2.4 Tolerances

In order to guarantee an excellent standard quality the acrylic metallic tubes are controlled many times during the production process. Tubes that show worse values than those indicated in the table 3 do not get through the quality control and are systematically rejected.

Table 3: Tolerances

External Diameter Ø mm.	Standard Length mm.	Thickness mm.	Tolerances	
			On external diameter	On thickness
				3 mm.
50	2000	3	+1%,-0,5%	± 1
70	2000	3	+1%,-0,5%	± 1
100	2000	3	+1%,-0,5%	± 1
150	2000	3	+1%,-0,5%	± 1
215	2000	3	+1%,-0,5%	± 1

2.5 Delivery conditions

2.5.1 Packing

Every single tube is packed as follows:

- from Ø 50 to Ø 215 in PE film

2.5.2 Delivery packing

Acrylic metallic tubes are set on wooden pallets and packed in cardboard boxes. The standard delivery packing includes:

- wood base (Palette);
- cardboard box;
- the tubes – packed as in 2.4.1 - are wrapped up in PE film and sealed with plastic tape.

The tubes are delivered in standard cardboard boxes which measures are adapted to the volume of the tubes.



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2.6 Identification

2.6.1 Product identification

A label on every acrylic tube - as in 2.4.1 - indicates:

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

2.6.2 Identification of the delivery crates

A label on every delivery case – as in 2.4.2 – indicates:

- destination address;
- case number;
- detailed case content.

Ask for more information by fax at 0039 02 95737357 or by mail at info@gevacril.com⁸

⁸ 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