



PALOPAQUE®

Flat Solid Opaque PVC Sheet



► Introduction

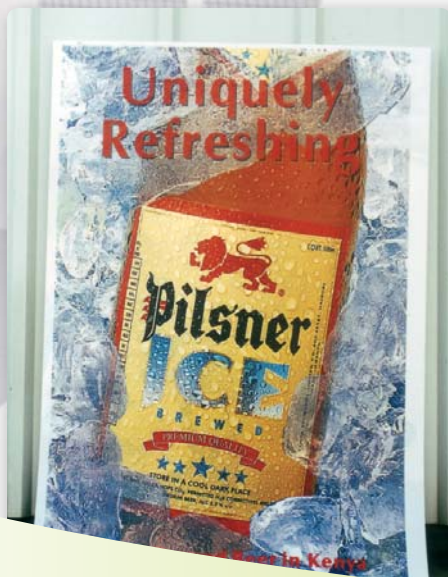
PALOPAQUE is a UV stabilized flat solid PVC sheet, with over 40 years of manufacturing experience that is reflected in its high quality. Easily formed and fabricated, PALOPAQUE is ideal for a wide variety of applications. PALOPAQUE makes an excellent printing substrate for the advertising and signage industries and is suitable for digital or traditional printing. With its high chemical resistance, PALOPAQUE is highly suitable for industrial applications. Breakthrough HYG technology adds active sanitation action for hospitals, clinics and laboratories.

► Main Benefits

- PALOPAQUE HYG: Active sanitation
- PALOPAQUE HT: Resistance to higher temperatures
- Excellent chemical resistance
- Impact resistant
- Easily fabricated and formed
- Highest fire rating, self-extinguishing
- Glossy or matte surface
- High electrical and thermal insulation
- High impact strength
- Weather resistant
- Comply with international standards
- Easy fabrication
- Non toxic
- Optional Matte finish on one side

► Typical Applications

- Frequently cleaned cladding
- Advertising and signage
- Chemical process industries
- Chemically resistant Signage
- Sterile surfaces in laboratories
- Clinics and hospitals
- Food industry
- Air vents



► PALOPAQUE™ Product Range

Type	Description
PALOPAQUE™	Standard UV stabilized sheet for general purpose and thermoforming applications. <i>*Increased UV resistance is available upon special request</i>
PALOPAQUE™ HT	Increased resistance to high temperatures
PALOPAQUE™ Matte	Matte finish on one side
PALOPAQUE™ HYG	Hygienic panels with active sanitation action, effectively eliminating various types of harmful microbes, including those resistant to antibiotics.

► Standard Dimensions

Width x Length (mm)	Thickness (mm)
1220 x 2440	1 to 15
1000 x 2000	1 to 10
1500 x 3000	1 to 6
2000 x 3000	1 to 4

* Custom dimensions are available, subject to minimum quantity.

► Standard Colors

White	Light Grey RAL 7040	Dark Grey RAL 7015	Metallic Grey RAL 9022
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* Custom colors are available, subject to minimum quantity.

** Indicated RAL designations are closest match.

► Fabrication Tips

PALOPAQUE can be easily fabricated using various techniques. Below are general recommendations for some of them.

Sawing	Machining	Thermoforming	Drilling	Bonding	Welding
For both band and circular saws use blades with a minimum tooth set, and about 8 to 10 teeth per inch. Prevent overheating by feeding slowly.	Use low machining speeds for turning and shaping, and assure free removal of machining chips.	Between 130°C and 170°C PALOPAQUE sheets become formable and can then be formed, press molded or blow formed.	Use conventional drills, but be certain to remove free drill chips in order to avoid overheating of the sheet. Also, use slow rate of penetration.	PALOPAQUE sheets can be bonded with conventional solvent based PVC adhesives.	PALOPAQUE extruded PVC sheets can be welded by hot-air welding process conventionally used for PVC.

Inasmuch as PALRAM Industries has no control over the use to which others may put the material, it does not guarantee that the same results as those described herein will be obtained. Each user of the material should make his own tests to determine the material's suitability for his own particular use. Statements concerning possible or suggested uses of the materials described herein are not to be construed as constituting a license under any PALRAM Industries patent covering such use or as recommendations for use of such materials in the infringement of any patent. PALRAM Industries or its distributors cannot be held responsible for any losses incurred through incorrect installation of the material. In accordance with our company policy of continual product development you are advised to check with your local PALRAM Industries supplier to ensure that you have obtained the most up to date information.

► Typical Physical Properties

Property	Method*	Conditions	Units	Value
Density	D-792		g/cm ³	1.4
Heat deflection temperature (H.D.T)	D-648	Load: 1.82MPa	°C	65 - 68
Service Temperature			°C	-10 to +50
Thermal conductivity	C-177		W/m K	0.15
Coefficient of linear thermal expansion	D-696		cm/cm °C	6.7 x 10 ⁻⁵
Rockwell hardness	D-785		R Scale	97R
Tensile strength at yield	D-638	10 mm/min	MPa	52
Tensile strength at break	D-638	10 mm/min	MPa	50
Elongation at yield	D-638	10 mm/min	%	3
Elongation at break	D-638	10 mm/min	%	140
Tensile modulus of elasticity	D-638	1 mm/min	MPa	2,900
Flexural strength	D-790	1.3 mm/min	MPa	80
Flexural modulus	D-790	1.3 mm/min	MPa	2,700
Impact falling weight	ISO 6603/1 E50	3 mm sheet	J	95

* ASTM except where noted otherwise

► Resistance to Chemicals

Excellent resistance to... Mineral acids, alkalis, plating solutions, paper making chemicals, pickling solutions, other inorganic solutions and fumes thereof.

Good resistance to... Alcohols, aliphatic hydrocarbons, glycols, amines, phenols.

Not recommended to contact... ketones, chlorinated solvents, aromatic hydrocarbons, some esters and ethers.

For more information please refer to "Chemical Resistance of PVC Products" available at www.palram.com or with your PALRAM distributor.

► Flammability

PALOPAQUE is self-extinguishing and complies with the most demanding international fire resistance standards defined in the field of plastics, as shown in the attached table.

Standard	Classification*
DIN 4102	B-1
BS 476/7	Class 1
NSP 92501,5	M-1
CSE RF 3/77	Class 1
UL 94	V-0
ASTM D-635	SE

* Depends on thickness

Europe
UK
Israel
USA
Australia
Far East



EUROPE

PALRAM EUROPE LTD.
Tel: +44-1302-380776
Fax: +44-1302-380788
sales.europe@palram.com
www.palram.com

PALRAM UK
Tel: +44-1302-380738
Fax: +44-1302-380788
sales.uk@palram.com

ISRAEL

PALRAM ISRAEL
Tel: +972-4-8459900
Fax: +972-4-8459980
palram@palram.com
www.palram.co.il

USA

PALRAM AMERICAS
Tel: +610-2859918
Fax: +610-2859928
palramamericas@palram.com
www.palramamericas.com

