



HuaMing Cast acrylic sheet

Sanitary range

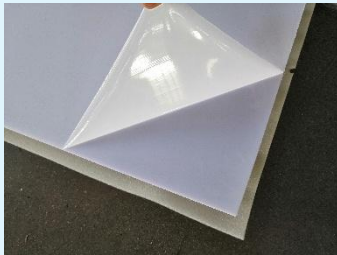




HuaMing Sanitary range is cast PMMA sheet, specially developed for sanitaryware appliances.

Sanitaryware grade cast acrylic sheet is a special grade of sheet specifically used for the production of bathtubs and other sanitary ware applications. It has the same high molecular weight as standard cast sheet but has cross-linking, a special chemical reaction that can improve the sheet's resistance to household chemical cleaning agents and other solvents.

What is cross-linking: The reaction of two or more molecules bonding and cross-linking to form a more stable molecule network structure



Tolerances of dimensions

HM cast sheet are supplied in compliance with the international standard ISO 7823/1 concerning cast PMMA sheet.

The dimensional tolerances are :

<i>in length or width</i>	:	0/ + 3 mm - up to 1000 mm.
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	:	0/+ 6 mm - from 1001 to 2000 mm.
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	:	0/ + 9 mm - from 2001 to 3000 mm.
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	:	0/ + 0,3% - from 3001 and over.
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Reference face or view face

The side of HM Sanitary sheet which will be visible in use, must be the top face (clear polyethylene film). The bottom may have slight variations in gloss and tint.



Guarantee:

Compliance with thicknesses and their tolerances A VICAT softening point ≥ 105 °C

Water absorption ≤ 40 mg

Thermal stability during its transformation (no surface deterioration)

A tensile strength greater than 60 MPa Stability of colours to light and hot water

Resistance to chemicals, hot water and staining

All of these tests check the fitness of sheets to meet sanitary purposes.



Storage

The pallets must be stored in a dry place away from direct sunlight and rain. Nevertheless, the pallets can remain outside for a maximum duration of 24 hours after unloading. It is recommended to store sheets horizontally on their original pallets. It is strongly recommended not to stack pallets so as not to create internal stresses and alter the flatness of sheets. When only a few sheets have been used, make sure that the rest are repacked.

Film guarantee

The thermoforming properties of the film are guaranteed for one year from the manufacturing date. This guarantee is valid if the sheets have been stored according to the recommendations given above. An excessive thermoforming temperature may deteriorate the sheet protective film making it more difficult to remove.



Handling

Do not handle the HM sheet with bare hands, the edges are sharp and this could pollute the surface. If possible, wear clean leather gloves.

Do not wear fluffy, brightly-coloured clothes, the sheets could be polluted by cloth fibres or the cloth colouring could pass through the film, causing stains or marks. Wear white or grey cotton overalls.

Do not move the sheets causing them to slide, this could damage the PE protective film and lead to the manufacturing of marked thermoformed products. Two people should carry them or a suction-paddled remover should be used.

Processing

HM sheet must be thermoformed by conventional methods using a female mould under vacuum. Nevertheless versatile production procedures can be employed.

After moulding, a shell is obtained, but generally this shell is too flexible and must be reinforced to give the required rigidity to the product. After reinforcement, the piece is trimmed and drilled for waste, overflow, taps and other fittings which may be required.



Technical advice

The best performances during thermoforming, are obtained at a temperature around 160°C. The sheets must be heated about 15°C more, in order to compensate for the loss of temperature during handling. The sheet must be heated uniformly throughout the thickness and over the entire surface.

It is advisable to work with aluminium moulds, with incorporated water channels to enable a temperature regulation. This is a key to consistent moulding conditions.

The cooling conditions must be determined in order to cool down the entire surface, but mainly in the area of the clamping system. The shell must be removed from the mould at a temperature above 70°C but below 80°C. This avoids breakage on the mould or distortions after demoulding.



Sanitary acrylic sheet sizes, without PVC gasket

Trimmed sheet size	MOQ(pcs)	Trimmed sheet size	MOQ(pcs)
1560*1560	12	1110*1840	18
1200*2000	18	1250*1850	18
1800*2230	12	1250*2160	18
910*1730	18	910*1810	18
1730*1870	12	1500*1700	12
1600*1720	12	1750*1750	12
1650*2000	12	1850*1870	12
1110*1980	18	620*1900	12
1750*2010	12	1870*2000	12
1850*2050	12	960*1700	18
1970*2050	12	960*1900	18
960*1800	18	1460*1860	12
1050*2100	18	1320*2130	18
1420*2240	18	1090*1770	18

STANDARD RANGE

Trimmed sheet size	MOQ(pcs)	Trimmed sheet size	MOQ(pcs)
1570*2270	12	1060*1940	18
1520*2160	18	1470*2420	12
1450*2080	18	1650*1800	12
1000*1650	18	1750*2010	12
1810*2240	12	1920*2010	12
1760*2500	12	1250*2000	18
2160*2160	12	1550*2050	12
2500*2500	12	1350*2270	18
1210*1710	18	1200*2060	18
1360*2750	12	1220*3050	18
1180*2090	18	950*1850	18
1090*2310	18	1180*2160	18
1150*1850	18	1630*2780	12
900*2450	18	1730*2080	12
1080*1890	18	1750*2100	12

STANDARD RANGE

Trimmed sheet size	MOQ(pcs)	Trimmed sheet size	MOQ(pcs)
1580*1580	12	1810*2070	12
1578*1578	12	2030*2270	12
1350*2180	18	2030*2090	12
1320*1950	18	1790*1870	12
1550*1750	12	1570*2560	12
1250*2050	18	1730*2320	12
1430*2830	12	1240*2460	12
1500*2950	12	2160*3160	12
1500*2410	12	1840*2100	12
2270*2270	12	1770*2190	12
900*1900	18	1570*1770	12
900*1600	18	1670*1670	12
1650*1950	12	1450*2310	18
1250*2750	18	1550*1630	12
1660*2320	12	1630*1750	12

STANDARD RANGE

Trimmed sheet size	MOQ(pcs)	Trimmed sheet size	MOQ(pcs)
1900*2530	12	1630*2910	12
910*1850	18	1950*1950	12
1400*1900	18	1020*2190	18
1070*1800	18	1080*2190	18
1750*1770	12	1390*2340	12
1600*1850	12	1270*2080	18
1750*2220	12	1590*1630	12
1900*2060	12	2500*4060	12
1000*1900	18	1880*1560	12
1180*1930	18	1450*1920	12
1100*1900	18	1750*1800	12
1100*2000	18	1660*3050	12
1660*2830	10	1050*1700	18

Notes:

Thickness range is from 2.2-5mm, hot sale thickness includes:2.2mm,2.5mm,2.8mm,3.0mm,3.2mm,3.5mm
All sheets with one side thermoforming film



Meet HuaMing, Meet Future.

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