



## **METALLIC<sup>®</sup>, IRIDIS<sup>®</sup>, METALLIC IRO<sup>®</sup>, STONE<sup>®</sup>, NACRE<sup>®</sup>**

Commercial information:

The range of sheets in the **Metallic<sup>®</sup>, Iridis<sup>®</sup>, Metallic IRO<sup>®</sup>, Stone<sup>®</sup> et Nacré<sup>®</sup>** family by Madreperla have been developed to meet the needs of designers who want to maintain the typical characteristics of PMMA sheets and need innovative effects inspired by traditional materials, like metal, stone, and natural mother of pearl. PMMA sheets are easier to work with. In many cases, the equipment for post-machining PMMA sheets is cheaper and easier to work with.

Please contact our technical office for information concerning color resistance: [madreperla@madreperlaspa.com](mailto:madreperla@madreperlaspa.com)

### **Metallic<sup>®</sup>, IRIDIS<sup>®</sup>, Metallic IRO<sup>®</sup>, Stone<sup>®</sup>, Nacré<sup>®</sup>**

**Metallic<sup>®</sup>:** Metallic effect with a high aesthetic value. Wide range of different solutions, it can be an alternative to any metal, combining elegance and workability of acrylic.  
Metallic<sup>®</sup> is not guaranteed for external use.

**Metallic IRO<sup>®</sup>:** 2 special colors developed to be externally used, giving the same light resistance guarantee as all acrylic sheets.

**IRIDIS<sup>®</sup>:** Three different iridescent colors, that are enhanced thanks to subtle games of light  
Iridis<sup>®</sup> is not guaranteed for external use

**Stone<sup>®</sup>:** one side satin surface, that takes inspiration from natural materials  
Stone<sup>®</sup> is not guaranteed for external use

**Nacré<sup>®</sup>:** The last born of the Metallic ranges. With Nacré Madreperla returns to its roots, when the company was producing buttons with a mother of pearl effect, in a large range of colors.  
Nacré<sup>®</sup> is not guaranteed for external use.



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### **Technical conditions:**

Our sheets are delivered in accordance to ISO 7823-1.

### **Cut-to-size sheets:**

On request, we can supply cut-to-size sheets with minimum surface required 400cm<sup>2</sup>.

### **Tolerances on size:**

The Tolerances are as follows:

- standard sizes: 0/+ 10mm.
- cut to size +/- 1mm/lm

### **Squared cutting:**

On request we can supply squared cuttings.

### **Untrimmed sheets:**

Our cast acrylic sheets can be supplied on request untrimmed. Minor defects may occur in the oversize. Only net dimensions will be charged to the customer. The untrimmed size of the sheets is roughly 40mm bigger than the trimmed one.

### **Color formulation:**

Slight differences may occur in shade between different production batches of the same color, caused by different pigments batches, although every care has been put in production. It is recommended not to use different production batches for the same fabrication.

### **Out of standard items:**

Other thicknesses, dimensions and colors can be produced on request with minimum quantities. The order is accepted for the smallest production batch.

We have a large number of color formulation ready, therefore don't hesitate to contact us for information.

Please check our document: production out of standard products.

### **Color intensity:**

The color intensity and light transmission remains constant up to 20mm thickness



**Standard protection:**

The side with printed logos identifies the side to be used as viewside.

The film is thermoformable for all Setacryl® sheets (glossy surface), but customers should perform a trial before use.

The film protecting Polarlite®, SatinIgas® and Setasand®, Stone®, Seta-LETTER® sheets (satin and frost surfaces) is not suitable for thermoforming.

All protection films are suitable for laser cutting.

In order to preserve the sheet from scratches, avoid sliding sheets across work surface debris.

Dirt can penetrate the masking, scratching the sheet.

**Storage:**

The correct way to store acrylic sheets is to place them horizontally, on the supplied flat bulk skids, in a well ventilated, consistent temperature area. Avoid storing acrylic sheets where extreme variations in temperature may occur. Extreme temperature changes expand or contract the acrylic sheets.

Special vertical racks can be used to store the sheets vertically. The rack should allow the sheets to lean approximately 10° (gradient).

**Cleaning:**

Acrylic sheets can be cleaned using a mild soap solution or a specific plastic cleaner, combined with a lint free cloth.

To remove grease, oil, or tar use hexane or kerosene followed by a mild soap solution.

Avoid cleaners containing alcohol or ammonia.

**Safety:**

Acrylic is a combustible thermoplastic that will ignite when in contact with any source of ignition.

Unlike other polymers, does not produce toxic or corrosive gases and produces very little smoke.

Production of molten droplets is reduced compared to extruded sheets.

When storing acrylic sheets, be aware of the material properties.

Madreperla acrylic sheets classify:

- HB according to UL94
- E according to EN 13501

**Thickness tolerances:**

The sheets are produced upon ISO 7923-1.

Formula to calculate the thickness tolerance. The thickness can vary within the same sheet:

$$\pm (0,4 + (0,1 \times s))$$

Where “s” is the nominal thickness in mm

Following the formula, the following thickness tolerances are accepted for cast acrylic sheets:

| Thick. in mm | 3 mm    | 4mm     | 5mm     | 6mm   | 8mm     | 10mm    | 12mm    | 15mm    | 18mm    | 20mm    | 25mm    |
|--------------|---------|---------|---------|-------|---------|---------|---------|---------|---------|---------|---------|
|              | +/- 0,7 | +/- 0,8 | +/- 0,9 | +/- 1 | +/- 1,2 | +/- 1,4 | +/- 1,6 | +/- 1,9 | +/- 2,2 | +/- 2,4 | +/- 2,9 |