



SETA-LETTER®

Commercial information:

Seta-LETTER® is a cast acrylic sheets with a satin surface.
Colors are completely dense, and designed to facilitate the creation of logos, letters and advertising signs.

Letters and logos can be easily laser cut or milled, offering customer the possibility to choose a product that offers one satin surface and one glossy surface.

It is produced standard in higher thicknesses, 8mm and 18mm.

Seta-LETTER® characteristics:

- 11 standard colors
- resistance to impacts: 8 to 10 times higher than glass
- Very high resistance to external agents and UV rays (10 years guarantee for colors).
- excellent workability:
 - thermoforming
 - bending
 - gluing
 - milling
- higher workability than extruded acrylic sheets





SETA-LETTER®

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 400cm².

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®, Satinlgas® 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 7823-1.

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