



CORPORATE PURCHASING SPECIFICATIONS

AA 22820

Rev. No.00

PREFACE SHEET

ACRYLIC RESIN (PERSPEX) SHEET

FOR INTERNAL USE ONLY

REMOVE THIS PREFACE SHEET BEFORE ISSUE TO SUPPLIERS

Comparable Standards:

User plants & Replaced Plant Specifications / References:

1. BHOPAL MC:22983 A
2. HARDWAR 0503.415

Revisions:

APPROVED:
INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(E)

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ACRYLIC RESIN (PERSPEX) SHEET

1.0 GENERAL :

This specification governs the quality of Acrylic Resin Sheet i. e. Perspex, manufactured from polymethyl methacrylate.

2.0 APPLICATION:

Suitable for use as a glazing material where transparency, toughness and ease of working and repairing are of special value.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard covering this type of material.

4.0 DIMENSIONS AND TOLERANCES:

Shall be stated on our order/drawing accompanying the order.

4.1 Tolerance on Thickness:

Above (mm)	Up to & incld (mm)	Tolerance (+) (mm)
-	2	0.2
2	4	0.3
4	6	0.4
6	10	0.8
10	-	1.0

5.0 FINISH:

The surface shall be smooth, uniform without cracks, gaseous or foreign inclusions, scratches, hairline cracks, chipping marks depressions, cavities and other defects.

6.0 TEST METHOD:

Unless otherwise specified, the material shall be tested in accordance with the relevant methods of BS: 2782.

7.0 SAMPLE FOR TEST:

Two sheets of ordered thickness and size 300 x 300 mm shall be supplied for test and approval.

8.0 PHYSICAL PROPERTIES:

8.1 Transparency:

Shall be transparent so as to have good visibility.

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**CORPORATE PURCHASING
SPECIFICATIONS****8.2 Oil Absorption for 24 hours at 70°C:**

2% Max.

8.3 Softening Point(Type Test):**8.3.1 As received:**

110°C, Min

8.3.2 After 24 Hrs at 90°C:

115°C, Min

9.0 CHEMICAL PROPERTIES:**9.1 Identification Test:**

The material shall be of acrylic resin when identified by Infra-red spectrophotometer or by any conventional method.

10.0 TEST CERTIFICATES:

Three, copies of test certificate shall be supplied with each consignment, giving the following information.

AA 22820. Acrylic Resin Sheet (Perspex)

BHEL Order No

Batch/Lot No.

Test values obtained/Certificates for compliance for
clauses 4, 5, 8 & 9.

11.0 PACKING AND MARKING:

The material shall be suitably packed to prevent damage during transit. Each package shall be clearly marked with the following information:

AA 22820: Acrylic Resin Sheet (Perspex).

BHEL Order No.

Suppliers Manufacturer's Name & Trade Mark.

Batch/Lot No.

Thickness, Width & Length.

Quantity:

Test Certificate Reference