



SALBAK

Flexible Pressed PVC Sheet

Display Grade	Flexible, Transparent or Opaque. Unique surface tack. <i>Applications:</i> Advertising, Car Licence Holders, Anti-dazzle Strips, Silk Screen Printing.
Decorative Opaque	Flexible, Opaque, High Gloss Finish. <i>Applications:</i> Military Uniforms, Coasters.
Door Material	Flexible, Transparent available in Standard or Low Temperature (to -30 degrees C). <i>Applications:</i> Warehouse Doors/Cold Stores.
Clear Transparent	Flexible, Transparent, Semi-Rigid or General Purpose. <i>Applications:</i> Document Wallets, Stationery, Protective Clothing.
Industrial Black	Flexible Opaque, Toughened. Abrasions resistant. <i>Applications:</i> Gaskets, Mud Flaps, Benchtops, Floor Mats, Flexible Ducting, Polishing Barrel Linings.
Desk Guard	Flexible, Transparent. Non-slip, Easy to clean. <i>Applications:</i> Desk and Table Protection.
Non-Slip Table Mats	Flexible, Opaque. Non-Slip, Easy to clean. <i>Applications:</i> Marine Industry, Navy.
Clear Automotive	Flexible, Transparent, UVS Superior Low Temperature (Cold Crack) Properties. <i>Applications:</i> Autoglazing, Boat Canopies, Tractor Hoods, Radiation Suits, Medical Equipment, Map Covers, Sailboards, Tents.
Industrial Grey	Rigid, Opaque, Impact Modified. Chemical resistant. <i>Applications:</i> Tank Lining, Ducting, Sign Backing, Cutting Plates and Boards.

SALBAK – Technical Data

SALBAK - Pressed plasticised PVC sheet

A clear transparent plasticised material which complies with the Federal Motor Vehicles Safety Standards No 205 item AS6 of the ANSI Safety Standards Z26.1 - 1996 (revision 1973) and CSA Standard D -263. It is especially suitable for back lights and quarter lights and is specified for original equipment for hoods of sports cars and convertibles. Being specially formulated and stabilised to give prolonged protection against the effects of ultra violet light the product is equally suited to other flexible glazing applications such as awnings and leisure boat canopies.

SALBAK v CALENDERED & EXTRUDED PRODUCTS

Calendered Sheet is manufactured by forcing powder, liquids, additives and pigments through an industrial mangle (a calendar). The result is a thin flexible sheet, usually 0.25 – 1.00 mm thick, and on rolls 1370 mm wide by 25 – 50m long.

Extruded sheet is manufactured by mixing and heating powder, liquids, additives and pigments in a screw inside the barrel of an extrusion machine. The mixture is then forced through a die, set at the appropriate thickness, to form a sheet. The result is a thin, flexible sheet, usually 0.25 – 1.00 mm thick, and on rolls 1370 mm wide by 20 – 50 m long.

Salbak is manufactured by layering thin, calendered sheets between polished metal plates until the appropriate thickness is achieved. For example, to manufacture 1.00 mm, four layers of 0.25 mm calendered sheet are used. The metal plates are then heated in a hydraulic hot press and under the influence of heat and pressure the layers of PVC become soft and bond with each other.

This plate pressed manufacturing process means that Salbak sheet has superior optical clarity to Calendered & extruded products. Also, because the Salbak sheets are bonded together under heat and pressure, the sheets will not droop, distort or lose their shape, which will happen to other products after several months. Finally Salbak has the best UV stability of any Marine glazing product on the market today. Whereas Calendered & extruded products will show signs of yellowing after only a few months, we would expect Salbak to last for several years before any yellowing occurred.

APPLICATIONS

Marine: Salbak has been the preferred pressed polished clear of the most discerning fabricators for over 30years.

Automotive: Salbak meets FMVSS 205, AS6 of ANSI safety standards Z26.1 – 1996 (Revision 1973), CSA standard D- 263, and D. o. T standards, and is used in a variety of quality automobiles including Land Rover and Rolls Royce

Military: Salbak meets DEF STAN 93 – 49/1 and is used extensively in military clothing and accessories.

Awning: Salbak provides an optically clear and UV stable solution for the leisure industry, including tent and awning for restaurants and hotels.

Medical: Salbak is used in a variety of medical applications where a high quality and long lasting transparent material is required.

FABRICATION & GENERAL ADVICE

If possible, it is advisable to unroll Salbak sheets several hours before commencing fabrication. The tissue interleaving used may leave slight impressions on the sheet, which is sometimes referred to as 'snail trails'. This will disappear as the sheet warms

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up. To quickly remove this marking, affected areas may be heated with an infra red or hot air source. A heat gun should be held 10 -15 cm away from the sheet while treating 30 cm area at a time. The same treatment can also be used for other light markings, such as zip marks.

'Shrink wrap' should not be used to protect sheets. This will ultimately cause 'plasticiser migration', which can alter the properties of the material and make the Salbak sheet less flexible. It will also generate static which will lead to a build up of dust on the sheet. Instead the tissue used to interleave the sheets should be used.

It is inadvisable to stack enclosure curtains on top of each other without interleaving them; otherwise the plastic panels will stick to each other. Although they can be peeled apart relatively easily, there is a risk that the windows may scratch each other. Furthermore, there is a risk of 'plasticiser migration'.

While fabricating in the cold environment, it is recommended that the enclosure first be heated, and the Salbak sheets be stretched into position. Sheets installed tightly in a cold environment will not necessarily remain so in warmer weather.

PHYSICAL PROPERTIES

Property	Value	Test method
Melting point	>200 degrees C	
Ignition temperature	>400 degrees C	
Max service temperature	55 – 65 degrees C	
Conditions to avoid	Continuous temperature above 50 degrees C Instant temperature above 200 degrees C	
Gauge	1.00 mm + -0.01	
Specific gravity	1.27	ASTM D792
Shore a hardness	92 degrees C	ASTM D2240
Tensile strength	23 MPa	DIN 55 -455
Elongation at break	300%	DIN 53- 455
Haze	3.0 %	ASTM D1003
Luminous transmittance	89 %	ASTM D1003
Volatility loss	1.76 %	ASTM D1203
Flammability	SE / NBR	FMVSS 302
Dimensional stability	0 – 2 %	BS 2782 Method 106F
'W' flex	No cracks	FLTM BN2 -2
Taber abrasion	12.2 %	CS – 10F Calibrase 500g load 25 cycles

WILLIAMS COLD CRACK TEST			
GAUGE		TEMPERATURE	
mm	US mil	Degrees C	Degrees F
1.00	40	- 32	- 25.6
0.75	30	- 25	- 13. 0
0.50	20	- 22	- 7.6

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QUV – A EXPOSURE

Salbak has been comparatively tested alongside other marine glazing products in accordance with ASTM G53, where it demonstrated that it has superior UV stability to its direct competitors in the marine glazing market area.

QUV – A exposure of Salbak for 8000 hours, has resulted in a change in colour against a white background of 0.6 unites to the yellow. The nearest competitor showed a colour change of 2.6 units.

AVAILABILITY

Salbak is available in a choice of Transparent clear or transparent grey tint.

The standard gauges are 0.50, 0.75 and 1.00 mm, and are all available in the following sheet sizes (mm):

2500 x 1250

1270 x 1016

1270 x 660

The net weights per 2500 x 1250 mm sheet are as follows:

0.05 mm = 1.98 kg

0.75 mm = 2.98 kg

1.00 mm = 3.97 kg

SHELF LIFE

If stored in a cool, dry environment (5 – 20 degrees C) Salbak will be suitable for use even after several years. Some white spotting may occur, but this can be removed by buffing. It has been known for Salbak to be used 12 years after production.

QUALITY CONTROL & PACKAGING

All Salbak sheets are inspected by highly trained quality control inspectors, before being carefully packaged to ensure the product reaches the customer in optimum condition.

Salbak is packed in sturdy cardboard drums and is interleaved with protective tissue paper. The pack quantities for sheet size 2500 x 1250 mm are as follows:

0.50 mm – 10 sheets per drum

0.75 mm – 5 sheets per drum

1.00 mm – 5 sheets per drum

CARE & MAINTENANCE

Cleaning is best carried out with dilute soap or detergent solution, once the enclosure has been thoroughly rinsed to loosen the build up dirt. Soap should be rinsed off thoroughly afterwards and should not be allowed to dry on the Salbak sheets.

Proprietary cleaners should not be used unless specifically stated to be suitable for cleaning purposes, as they may contain either an abrasive or solvent, both of which will adversely affect the PVC surface.