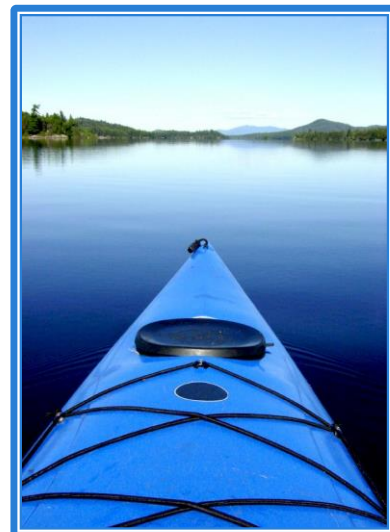


PRIMEX PLASTICS CORPORATION

A subsidiary of ICC Industries Inc.



Prime ABS Weather-X ML500 is a multi-layer sheet structure of up to 5 layers but is typically 3 consisting of Acrylic, ASA and ABS. An acrylic clear coat finish provides a hard, stain resistant surface that has excellent gloss, depth of image, chemical resistance and surface hardness. This layering technique provides superior UV protection, color stability and ease of formability.



Prime ABS Weather-X ML500

Prime Weather-X ML500	High	Avg.
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.06	g/cc
Gloss, 60° Angle	D-523	90	%
Tensile @ Yield	D-638	5,800	psi
Flexural Strength	D-790	10,600	psi
Flexural Modulus	D-790	350,000	psi
Notched Izod	D-256	3.6	ft-lb/in
Rockwell Hardness	D-785	102	R Scale
HDT @ 264 psi	D-648	198	° F

Applications:

Includes agriculture, spa, automotive, transportation and marine industry applications.

Finishing:

When drilling co-extruded sheet/profile with an acrylic modified drill bit, Be sure to exit from the Acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, acrylic capped sheet should be clamped during drilling. For cutting/trimming Weather-X ML500 sheet with CNC or air routers, a standard solid carbide fiberglass router – diamond-cut tool can be used. Routing parts in a CNC environment is best done with chip-breaker-type, solid carbide tools..

Processing:

Surface Temp = 325-350°F, Mold Temp = 150 - 175°F, De-mold @ 170°F and mold shrink is .004-.008 in/in. Oven heaters on gloss side should be somewhat lower than on the substrate side. The sheet must be fully saturated with heat before forming.

Colors, Textures and Capabilities:

The surface is typically high gloss. The colors are Solids, Granite, Pearlescent, Swirl, Metallics, Soft White and Metamerism Effects.