4140 Morris Drive
Burlington, Ontario
Canada L7L 5L6

TEL: (905) 637-3862 • FAX: (905) 637-8841 • Toll Free US & Canada: 1-800-381-5335 • www.MarShield.com

Handling

Both sides of each Lead Acrylic panels are protected by masking paper. Do not remove this paper until the panel has been mounted and is in final position. Rolling the paper edges enough to accommodate the hardware thickness is recommended prior to the final position. Unpack the material carefully. If crated, remove the crate lid and one side. If being handled by forklifts, particular care is needed to prevent chipping or scratching. Use of a pallet is recommended. To move always LIFT IT, NEVER SLIDE IT.

Handling Mounting or Framing

- An allowance of 1% should be taken for expansion and shrinkage of length and width. Allowances for thickness changes are not necessary.
- Do not fix Leaded Acrylic in place with screws or bolts unless a 1% clearance has been left (in the form of slots) for these fasteners.
- Do not us sheets thinner than 12 mm without frames. The overlap between the sheet and the frame should be at least 3/8"
- When using Leaded Acrylic, avoid local load concentrations to minimize the possibility of breakage.

Cutting

Lead Acrylic is best cut with a circular saw, either a bench or overhead model. For long blade life, use a tungsten-carbide-toothed blade. A blade designed for cutting plywood (or any other fine-toothed blade) will give a reasonably smooth cut. A lower cutting (feed) speed also promotes a smoother cut. The blade of the bench saw should protrude 5% to 10% of its diameter above the upper surface of the Lead Acrylic. If chipping occurs on the upper surface, raise the blade, if on the lower surface, lower the blade (reverse for an overhead saw).

Hazard Warning - Dust Treatment:

When cut, lead-containing dust may be released which may be poisonous if inhaled or ingested in large quantities; or in small quantities over time. A dust mask should be used when cutting.

If much cutting is planned, use a ventilation system that draws air and dust from the site of the cutting tool, away from the operator and into a filling system.

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Drilling

A drill press or hand-held drill can be used as follows:

- Standard drilling conditions
- Point angle: 125° to 140° Relief angle: 15° to 20° Drill speed: 100 to 500 RPM
- Clamp the material for drilling, backing it with wood scrap. Reduce the RPM and feed speed when the hole diameter and depth increase. If cracking occurs, decrease the feed speed or increase the tip angle. If necessary, cool with air or water, water spray should be stopped after 0.5 hour to prevent excessive absorption. Larger holes can be made with a hole saw.

Maintenance

Storage

Always store the Lead Acrylic panels horizontally, never vertically, or inclined. The storage base should be a flat, smooth surface (such as a plywood sheet) and be larger than the panel.

Panels should be stacked no higher than 1 foot, with corrugated cardboard sheets placed between them. Avoid water splash, humidity over 80% RH, or temperatures over 120.

Cleaning

Lead Acrylic panels and windows require the same cleaning techniques used on conventional plastic sheets. Cleaning, rinsing and drying with a soft cloth and water should remove normal dirt and smudges. Avoid products containing ammonia as this will "cloud" the Lead Acrylic and void your warranty.

Removing Scratches

To remove fine scratches, haziness and abrasions from Lead Acrylic surfaces, we recommend the use of Plastic Polish. Follow the directions on the bottle supplied. In general, all surface dust should be removed with a soft cloth. Shake the polish well, and apply the polish in a gentle circular motion until dry. Then buff with a clean dry cloth, lint free. For deeper scratches, repeat polishing and buffing procedure a number of times.