

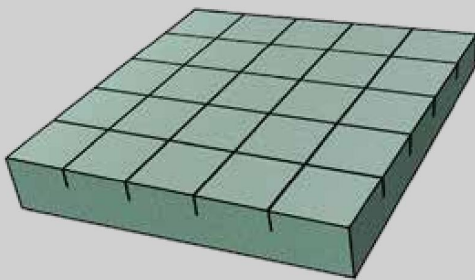
FINISHING OPTIONS

PET

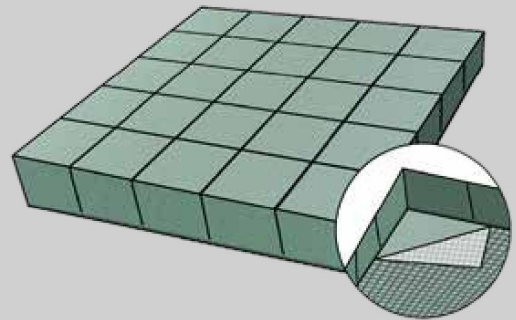
PET foam core sheets are available with a variety of finishing options such as grooving, gridscore, double contouring and perforation to assist resin flow and air removal or to allow curvature conformability.

This document is meant to give you a general overview of the different converting options Armacell is offering today. Further converting options can be discussed with your sales representative.

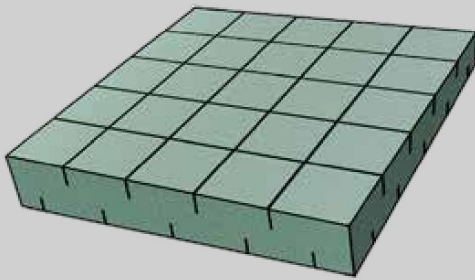
GROOVING



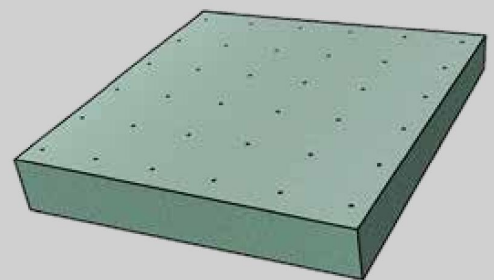
GRIDSCORING



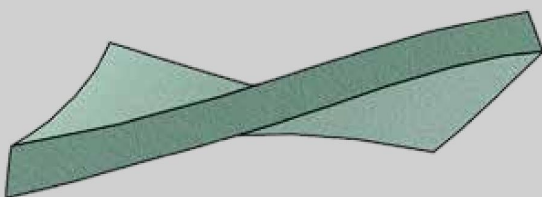
DOUBLE CONTOUR



PERFORATION

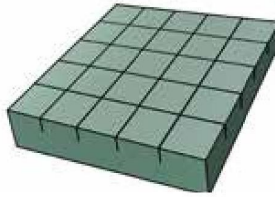


THERMOFORMING



– Grooving (GR)

Groove pattern:	30 x 30 mm
Width of cut:	≤ 25mm: 0,9 mm
	> 25mm: 1,2 mm
Depth of cut:	2,0 mm

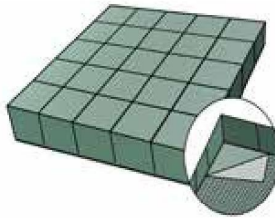


Standard board size:	1008 x 1224 mm
Minimum foam thickness:	10 mm
Maximum foam thickness:	100 mm

– Gridscoring (GS)

Foam is almost cut in 30 mm squares and bonded to lightweight fibreglass scrim on bottom side, creating a flexible core sheet. The boards are not cracked.

Grid pattern:	30 x 30 mm
Width of cut:	≤ 25mm: 0,9 mm
	> 25mm: 1,2 mm



Standard board size:	1008 x 1224 mm
Minimum foam thickness:	10 mm ≥ 100 kg/m ³ 15 mm ≤ GR80 15 mm ≤ FR100
Maximum foam thickness:	50 mm

– Double Contour (DC)

Both sides of the foam core are cut in both directions to a depth of > 50% of the core thickness, creating a somewhat flexible core sheet.

Groove pattern:	30 x 30 mm
Width of cut:	≤ 25mm: 0,9 mm
	> 25mm: 1,2 mm
Depth of cut:	> 50% of the foam



Standard board size:	1008 x 1224 mm
Minimum foam thickness:	15 mm
Maximum foam thickness:	95 mm

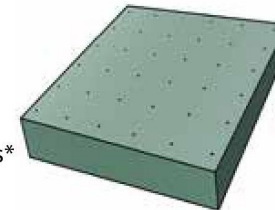
– Perforation (P)

Thickness ≤ 60 mm

Hole pattern:	32 x 32 mm
Hole diameter:	3 mm

Thickness ≥ 60 mm

Hole pattern:	32 x extrusion thickness*
Hole diameter:	5 mm



Standard board size:	1008 x 1224 mm 1008 x 2448 mm **
Maximum foam thickness:	140 mm

* Extrusion thickness depending on density 45-85mm.

** Except 250 kg/m³.

– Scrim (S)

Our foam core sheets can be delivered with or without fibreglass scrim.

Maximum foam thickness: 150 mm

Minimum foam thickness:	10 mm ≥ 100 kg/m ³ 15 mm ≤ GR80 15 mm ≤ FR100
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– Thermoforming (T)

Due to its pure thermoplastic nature PET core is well suited for thermoforming to create both two and three-dimensional shapes without the stress concentrations in the core. Thermoforming is carried out by heating the PET core to its softening point and forcing it against the contour of a female or male mould. Among others, the final temperature is depending on foam thickness and density, as a starting guidance you can say that thermoforming PET core takes place between 185 - 210°C. After the material has cooled down to room temperature the part remains in its new shape with close to zero spring-back effect.

