

ArmaFORM[®] PET: Finishing Options

ArmaFORM[®] 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.

Standard Converting Options ArmaFORM[®] PET

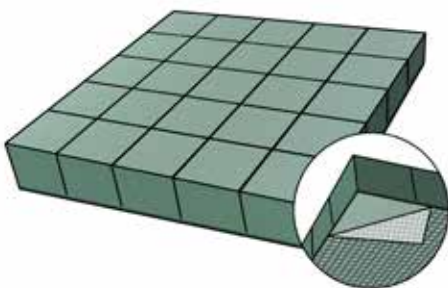
Grooving (GR)



Groove pattern	30 x 30 mm	Standard board size	1.008 x 1.224 mm
Width of cut	≤ 25mm: 0,9 mm > 25mm: 1,2 mm	Minimum foam thickness	10 mm
Depth of cut	2,0 mm	Maximum foam thickness	100 mm

To promote resin flow speed and wet-out. One side is cut in both directions.

Gridscore (GS)



Grid pattern	30 x 30 mm	Standard board size	1.008 x 1.224 mm
Width of cut	≤ 25mm: 0,9 mm > 25mm: 1,2 mm	Minimum foam thickness	10 mm ≥ 100 kg/m ³ 15 mm ≤ GR80 15 mm ≤ FR100
		Maximum foam thickness	50 mm

To provide optimum flexibility in two directions. Foam is almost cut and bonded to lightweight fibreglass scrim on bottom side. Boards are not cracked.

Double Contour (DC)

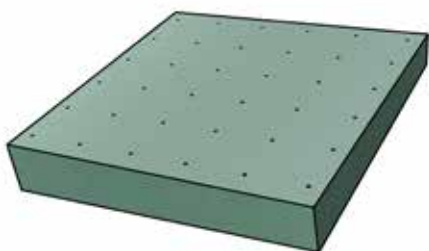


Groove pattern	30 x 30 mm	Standard board size	1.008 x 1.224 mm
Width of cut	≤ 25mm: 0,9 mm > 25mm: 1,2 mm	Minimum foam thickness	15 mm
Depth of cut	> 50% of the foam	Maximum foam thickness	95 mm

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

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Perforation (P)



Hole pattern	32 x 32 mm	Standard board size	1.008 x 1.224 mm 1.008 x 2.448 mm
Hole diameter	3 mm	Maximum foam thickness	140 mm

Standard pattern. Thickness and / or density limitation might apply.

Holes to ensure wet-out and to prevent trapped air.

Scrim (S)

Maximum foam thickness	150 mm	Minimum foam thickness	10 mm \geq 100 kg/m ³ 15 mm \leq GR80 15 mm \leq FR100*
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Our foam core sheets can be delivered with or without fibreglass scrim.

Thermoforming

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.

Not offered by Armacell. To be discussed with your sales representative.

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