

EXTRUSION GUIDELINES for polyethylene and polypropylene

GAUGE TOLERANCES:

POLYETHYLENE

GAUGE	TOLERANCE		RANGE	MAX GAUGE	MIN GAUGE
	PLUS	MINUS			
.014	.001	-.002	.0030	.015	.012
.019	.001	-.002	.0030	.020	.017
.023	.001	-.002	.0030	.024	.021
.035	.001	-.003	.0040	.036	.032
.055	.001	-.003	.0040	.056	.052
.075	.001	-.004	.0050	.076	.071
.100	.001	-.005	.0060	.101	.095
.125	.001	-.005	.0060	.126	.120
.150	.001	-.005	.0060	.151	.145
.180	.001	-.005	.0060	.181	.175

SQUARENESS

A physical measurement is taken diagonally across all corners of the sheet as shown, with the difference not to exceed 1/4 inch or a maximum of 1/6 inch difference between the two diagonal measurements in a 24" x 24" sheet.

POLYPROPYLENE

GAUGE	TOLERANCE		RANGE	MAX GAUGE	MIN GAUGE
	PLUS	MINUS			
.014	.001	-.002	.0020	.014	.012
.020	.001	-.002	.0030	.021	.018
.023	.001	-.002	.0030	.024	.021
.030	.001	-.002	.0030	.031	.028
.035	.001	-.003	.0040	.036	.032
.055	.001	-.003	.0040	.056	.051
.075	.001	-.004	.0050	.076	.071
.100	.001	-.005	.0060	.101	.095
.125	.001	-.005	.0060	.126	.120
.150	.001	-.005	.0060	.151	.145
.170	.001	-.005	.0060	.171	.165
.220	.001	-.005	.0060	.221	.215

DIMENSION TOLERANCE POLYETHYLENE and POLYPROPYLENE

LENGTH TOLERANCES

INCHES	TOLERANCE (inches)				
	PLUS	MINUS	RANGE	MAX	MIN
Up to 24	.2500	-.0000	.250	96.750	12.00
24+ to 48	.3750	-.0000	.375		
48+ Up	.7500	-.0000	.750		

WIDTH TOLERANCES

INCHES	TOLERANCE (inches)				
	PLUS	MINUS	RANGE	MAX	MIN
Up to 24	.125	-.0000	.250	96.750	12.00
24+ to 48	.250	-.0000	.250		

PHYSICAL TOLERANCES for POLYETHYLENE and POLYPROPYLENE

- DOWN WARP:** No more than 1/4" on gauges .055 & below
No more than 1/8" on gauges above .055
- UP WARP:** None allowed on any gauge
- EDGE CURL:** 1/8" up curl, 1/8" down curl
- WAVY EDGES:** No more than 3 per any 24" of length, 1/8" max curl height measured from flat a surface
- TREAT:** Minimum treat level to be 56 dyne

PHYSICAL TOLERANCES for PAPER/SQUARE CUT POLY SHEET

No sheet will be out of square more than +/- 1/32" for each paper/square cut piece