

## Product Description

3form Chroma is produced from optical grade engineered resin. Chroma is available in thick-gauge formats which lends itself well for use in many horizontal applications. Chroma is a highly functional material that brings impact when color is introduced. Chroma is produced with brilliant colors that can be specified to create an enormous range of hues, opacities and amazing effects. The surface of Chroma can be specified with a durable vellum finish that can be easily refinished throughout its lifetime.

Chroma XT is exterior grade Chroma suitable for use as signage, lighting, awnings, tables or canopies. Use Chroma XT to bring amazing color and design to your exterior applications.

### FEATURES AND BENEFITS

- Great for edge lighting – tremendous optical properties and high light transmission
- Rigid - stable and sturdy material for horizontal applications
- Qualifies for 3form Reclaim™ – keeping end-of-life material out of landfills
- Available in any of the colors within the 3form Color Portfolio.
- Vellum finish is able to be sanded to a renewable matte finish to maintain product "newness"

### AVAILABLE COLORS/EFFECTS

3form Chroma is available in any of the colors within the 3form Color Portfolio. Visit [www.3-form.com](http://www.3-form.com) for the complete list of available color options.

Variations in material dye lots will result in slight color differences between samples provided and finished product.

### TEXTURES/PATTERNS/FINISHES

3form Chroma comes standard with a Vellum finish on the front and back faces. Chroma Clear comes standard with renewable matte surfaces on front and back.

Chroma panels can be ordered with an optional Renewable Matte finish that allows for in-field refinishing. If specified on the back face, the Renewable Matte finish increases the thickness by an extra 1/16" (1.5 mm).

See the 3form Material Finishes document on [www.3-form.com](http://www.3-form.com) for detailed information regarding material and finish compatibility.

### PANEL SIZES AND TOLERANCES

All dimensions and squareness (standard or custom) are subject to a +1/4" or - 3/16" (+6 mm or -5 mm) tolerance. Squareness (standard or custom) is subject to a 1/8" (3.1 mm) tolerance.

Chroma is available in 1/2 inch (12.7 mm), 1 inch (25.4 mm) and 2 inch (50.8 mm) thicknesses.

#### PANEL SIZE TABLE

NOMINAL GAUGE	PANEL DIMENSIONS
1/2" (12.7 mm)	48" x 96" (122 cm x 243.8 cm), 48" x 120" (122 cm x 304.8 cm)
1" (25.4 mm)	48" x 96" (122 cm x 243.8 cm), 48" x 120" (122 cm x 304.8 cm)
2" (50.8 mm)	48" x 96" (122 cm x 243.8 cm)

Given the unique manufacturing process for 3form Chroma, a given gauge is subject to a +/- 10% thickness tolerance. Thickness values are based on measurements 2-3" (50-75 mm) from the edge, along both long edges of each panel.

#### THICKNESS TOLERANCE TABLE

##### STANDARD CHROMA, DIGITAL PRINT AND XT PANELS

GAUGE*	MINIMUM ALLOWANCE	MAXIMUM ALLOWANCE
1/2" (12.7 mm)	0.412" (11.4 mm)	0.562" (14.9 mm)
1" (25.4 mm)	0.850" (22.9 mm)	1.090" (27.9 mm)
2" (50.8 mm)	1.800" (45.7 mm)	2.200" (55.9 mm)

##### FLARE AND PANELS WITH RENEWABLE MATTE BACK FINISH

GAUGE*	MINIMUM ALLOWANCE	MAXIMUM ALLOWANCE
5/8" (15.9 mm)	0.515" (14.5 mm)	0.710" (17.9 mm)
1-1/8" (28.6 mm)	0.965" (24.5 mm)	1.225" (31.1 mm)
2-1/8" (53.9 mm)	1.865" (47.4 mm)	2.325" (59.1 mm)

\*Chroma Flare adds 1/8" (3 mm) and renewable matte back finish materials add 1/16" (1.5 mm) to overall thickness.

### FLATNESS TOLERANCE

Chroma panels shall not have distortion in the form of a wrinkle, twist or scallop along the perimeter of the sheet. Warp in the form of a curve (bow warp) extending across the sheet is permitted to a maximum of 1/4" (6.3 mm) for each 48" (1.2 m), or fraction thereof. Panel is to be measured laying horizontally under its own weight on a flat continuous surface.

# Specifications

## FLAMMABILITY & SMOKE TEST RESULTS

### BUILDING CODE APPROVALS

3form Chroma conforms to the 2009 International Building Code® for light-transmitting plastics. The provisions of these codes provide adequate regulation for most applications of light-transmitting plastics:

TEST	3FORM CHROMA	RESULT
ASTM D 2843 Smoke Density	4.1%	PASS Less than 75
ASTM D 635 Flame Spread	Rate of burning: 1.2 in/min	PASS CC2
ASTM D 1929 Self-ignition Temp.	852°F	PASS Greater than 650°F
ASTM E 84 Flame Spread, 1/2" Thickness Smoke Developed	95 450	Class C (76-200) 450 (less than 450)
ASTM E 84 Flame Spread, 1" Thickness Smoke Developed	115 150	Class C (76-200) 450 (less than 450)

## PANEL WEIGHT

THICKNESS (INCHES)	WEIGHT FLUX (LB/FT²)
1/2" (12.7 mm)	3.1 lb/ft² (15.1 kg/m²)
1" (25.4 mm)	6.2 lb/ft² (30.2 kg/m²)
2" (50.8 mm)	12.4 lb/ft² (60.5 kg/m²)

\*Chroma XT panels weigh an additional 0.4 lb/lft² (1.9 kg/m²)

\*\*Chroma Flare panels weigh an additional 0.8 lb/lft² (3.8 kg/m²)

## EXPANSION/CONTRACTION ALLOWANCES

Like all resin products, 3form Chroma will expand and contract nominally with fluctuations in temperature. The following formula provides allowances that should be made in framed or fitted applications:

- Longest length of panel (inches) x temperature change of the sheet (°F) x 0.00004 = Amount of Linear Expansion/Contraction (inches)

### Example:

- A 48" x 96" panel that experiences a 50°F temperature change will expand/contract: 96 inches x 50 degrees x 0.00004 = 0.192 inches

Installers should take extra precautions if installation is occurring before the HVAC systems are operational. Allowances should also be made in the following situations:

- Fastening points
- Channel depths in frames
- Holes for standoffs and other hardware
- Meeting points for multiple sheets of 3form Chroma

## ETCHING

3form Chroma may be etched with two different finishing options to produce patterns, text, or anything imaginable. When etching, two different surface finishes may be specified: Polished and Renewable matte. Following are some limitations to the etching process:

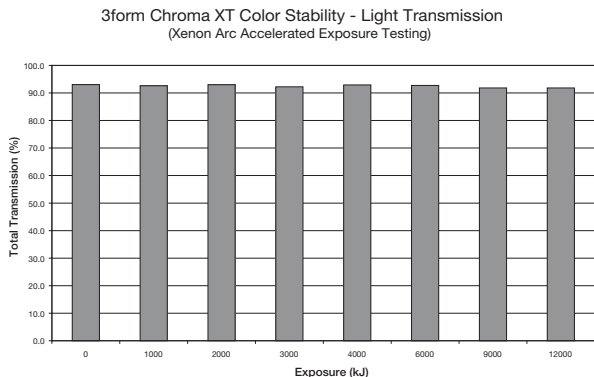
- Limited to 1/8" deep
- Etch must be greater than 1/2" wide

## UV EXPOSURE PERFORMANCE

Chroma XT is an excellent choice for exterior applications. The chart demonstrates that the change in light transmission remains unchanged. (12,000 kJ of exposure represents approximately 10 years of outdoor exposure in Florida) Should your application be for exterior use, please notify your 3form Sales Representative.

\*Chroma Flare cannot be used in exterior applications.

## USAGE LIMITATIONS



3form Chroma should never come in direct contact with metal fasteners. Non-metallic\* gaskets, washers, and tubing are to be utilized in conjunction with mechanical connections such as point supports and frames. Holes for fasteners must be located a minimum of 2" from the edge of the hole to the edge of the panel. Please contact the 3form Technical Help Line should you have any questions regarding the use of Chroma with mechanical fasteners.

\*Gaskets, washers and tubing must be produced with a non-plasticized material. Suitable materials include: neoprene, teflon, nylon, silicone.

## DEFLECTION

3form Chroma will exhibit different amounts of deflection given a variety of factors: fastening techniques, loads, gauges and panel dimensions to list a few. Your 3form Representative can assist you with general deflection guidelines for your application using the Chroma Deflection Charts. If your application has specific engineering requirements, please contact the 3form Technical Help Desk for additional direction at 801-649-2670.

## HEAT FORMING/COLD BENDING

3form Chroma can be heated and formed to produce simple and/or complex curves and shapes. The table below lists the minimum inner radius for a heat formed shape. Tighter radii may be possible, contact 3form Technical Service for details.

THICKNESS	MINIMUM HEATFORMING RADIUS
1/2" (12.7 mm)	4" (101.6 mm)
1" (25.4 mm)	8" (203.2 mm)
2" (50.8 mm)	12" (304.8 mm)

It's recommended that large and complex forming geometries should be specified to be produced by 3form Fabrication.

## CHROMA HIGHRES

3form Chroma HighRes is produced with a unique construct and is subjected to the following restrictions when heat-forming:

- 1/2" thickness only
- Maximum finished sizes of 46" x 94" and/or 46" x 118"
- Renewable Matte finish only
- No Complex Curves

Though 3form Chroma is commonly used in flat or heat curved applications, the polymeric nature of the material allows a minimal amount of cold bending for a given panel. Cold bending is not possible on 1" and 2" gauges. Cold bending is **NOT RECOMMENDED** on any thickness of Chroma XT. The table below shows the minimum suggested radius for 3form Chroma at a given gauge:

THICKNESS	MINIMUM BEND RADIUS
0.250" (6.3 mm)	not recommended
0.500" (12.7 mm)	225" (571 cm)

## EDGE FINISHING

Edges of 3form Chroma panels are able to be machined or routed into a variety of different forms. In addition to a straight edge, edges may accept beveling, rounding, etc. Additional finishing, such as sanding or polishing, can also be provided to some edges.

## REFINISHING

One of the unique benefits of 3form Chroma is its ability to be refinished. If 3form Chroma needs to be refinished for any reason, the panels may be renewed by sanding. Make sure to sand the entire surface to obtain a uniform finish over the whole panel. Begin by dry sanding with a coarse grit paper (100 or 150 grit) to remove blemishes/scratches. Continue sanding with gradually finer grit papers until the surface is smooth and level and the blemish/scratches are removed. Complete the refinishing process by sanding with a 220 grit paper to attain a matte finish. Only the primary surface (non-colored side) is refinishable. After sanding, clean the surface with warm water and a mild detergent. Dry with a clean, cotton cloth and finish by treating the panel with Invisible Shield®. Even finer grit sandpapers may be used to attain a satin or semi-polished appearance. With papers greater than 400 grit, wet sanding (with water) should be employed. Be sure to keep sanders in motion at all times when refinishing surfaces or edges. Only use light pressure with power sanders in order to maintain evenness and avoid overheating of the sheet surface.

## SOUND TRANSMISSION CLASS (STC) VALUES

Measurement protocol: ASTM E 90 - Standard Test Method for Laboratory Measurement of Airborne Sound Transmission Loss of Building Partitions and Elements

THICKNESS	STC VALUES
1/2" (12.7 mm)	32
1" (25.4 mm)	36

## THERMAL INSULATION VALUES

Insulation values are a function of both the convective properties (U-Values and shading coefficients) and the conductive properties (thermal conductivity).

THICKNESS	WINTER U-VALUE (BTU/HR-FT <sup>2</sup> -°F)	SUMMER U-VALUE (BTU/HR-FT <sup>2</sup> -°F)
1/2" (12.7 mm)	0.82	0.81
1" (25.4 mm)	0.65	0.65
2" (50.8 mm)	NOT TESTED	NOT TESTED

## Cleaning Instructions

3form Chroma, like all thermoplastic materials should be cleaned periodically. A regular cleaning program will help to maintain the aesthetics and life of the material. 3form recommends the use of Invisible Shield, Novus® No. 1 and Brillianize® plastic cleaners. Rinse or wipe the sheet with lukewarm water. Remove dust and dirt from 3form Chroma with a damp, soft cloth or sponge and a solution of mild soap and/or liquid detergent in water. Rinse or wipe the 3form Chroma again thoroughly with lukewarm water. For more stubborn stains, dirty spots or grease, surface cleaners like Fantastik® or Formula 409® also work well. A scotch brite sponge can also help remove tough grease stains. After all cleaning steps, be sure to rinse thoroughly with lukewarm water.

Always use a soft, damp cloth to blot dry. Rubbing with a dry cloth can scratch the material and create a static charge. Never use scrapers or squeegees on 3form Chroma. Also avoid scouring compounds, gasoline, benzene, acetone, carbon tetrachloride, certain deicing fluids, lacquer thinner or other strong solvents.

### DO NOT:

- Use squeegees or scrapers as they may scratch the sheet
- Use scouring compounds or solvents such as: acetone, gasoline, benzene, carbon tetrachloride, or lacquer thinner to clean the sheet
- Use abrasives or highly alkaline cleaners
- Use a dry cloth or a cloth of synthetic fiber such as rayon or polyester as they may scratch the sheet.
- Use Windex® or Glass Plus® cleaners

### DO:

- Use warm water, mild detergent and a soft cloth or chamois
- Rinse surface thoroughly after cleaning with lukewarm water
- Blot dry with slightly damp, soft cloth or chamois

## IMPORTANT

If a cleaning material is found to be incompatible in a short-term test, it will usually be found to be incompatible in the field. The converse, however, is not always true. Favorable performance is no guarantee that actual end-use conditions have been duplicated. Therefore, these results should be used as a guide only and it is recommended that the user test the products under actual end-use conditions.

For more information, please visit [3-form.com](http://3-form.com) or call 877-649-2670.

## STORAGE INSTRUCTIONS

Chroma & Chroma XT panels are shipped with a protective peel coat that needs to be removed within (30) days of arrival. Chroma & Chroma XT should be stored at room temperature in a dry environment that is not exposed to direct sunlight or heat. Panels should be stored horizontally (flat), as delivered, to prevent warpage. Due to possibilities for expansion and contraction, allow materials to come to room temperature prior to fabricating.

# Chemical Resistance of 3form Chroma to Select Compounds

## 7 DAY FULL IMMERSION TESTING @ 73°F (23°C)

Polymer materials are affected by chemicals in different ways. Changes in performance or appearance when exposed to chemicals can be attributed to fabrication methods, exposure conditions, concentration of chemical substances or exposure duration. Such factors can even influence the final effect on substances that 3form Chroma is considered “Resistant” to, under test conditions. Further details are explained below:

### FABRICATION

Stresses generated from sanding, grinding, drilling, polishing, machining, sawing and/or forming (hot or cold).

### EXPOSURE

Exposure duration, stresses imparted during the application life-cycle due to loads, temperature changes, heat, environments, etc.

### APPLICATION OF CHEMICALS

Application from contact, rubbing, wiping, spraying, soaking, etc. Also having an affect is the relative concentration of the chemical in question.

The following table provides indicative performance of the chemical resistance characteristics of clear 3form Chroma panels. The following codes are used to describe the chemical resistance characteristics:

#### R = RESISTANT

3form Chroma is able to withstand the identified compound for long exposure periods. (7 days, full immersion)

#### LR = LIMITED RESISTANCE

3form Chroma is only resistant when in contact with this compound for short periods at room temperature. It is advised that further determination of the effect of the substance be further tested in your particular application.

#### N = NOT RESISTANT

3form Chroma is not resistant to the compound. The material will swell, craze, haze, dissolve or experience some physical change when exposed to this substance.

### DISINFECTANTS\*

REAGENT	RESULT
ChemiSwiss SUIclean™	R
ClearSpace powered by PreventX™	R
Clorox Healthcare® Bleach Germicidal Wipes	R
Clorox Healthcare® Hydrogen Peroxide Cleaner Disinfectant Wipes	LR
Clorox Healthcare® VersaSure™ Alcohol-Free Disinfectant Cleaner Wipes	LR
Diversey™ Avert® Disinfectant Cleaner	R
Diversey™ Oxivir® TB Hospital Grade Disinfectant	R
Diversey™ Virex® Cleaner Disinfectant TB	LR
Diversey™ Virex® II 256 One Step Disinfectant Cleaner and Deodorant	LR
Ecolab® Neutral Disinfectant Cleaner	NR
Ecolab® Oxycide Daily Disinfectant Cleaner	R
Ecolab® Quaternary Disinfectant Cleaner	LR
PDI® Sani-Cloth® AF3 Germicidal Disposable Wipe	NR
PDI® Sani-Cloth® Bleach Germicidal Disposable Wipe	R
PDI® Sani-Cloth® Plus Germicidal Disposable Cloth	LR
PDI® Sani-Cloth® Prime Germicidal Disposable Wipe	LR
PDI® Super Sani-Cloth® Germicidal Disposable Wipe	LR

\*Use recommended cleaners and disinfectant products as directed by the manufacturers

### GENERAL CHEMICALS

REAGENT	RESULT	REAGENT	RESULT
acetic acid (5%)	R	hydrochloric acid	R
acetic acid (glacial)	N	hydrofluoric acid (40%)	N
acetic anhydride	LR	hydrogen peroxide (3%)	R
acetone	N	hydrogen peroxide (28%)	N
acrylic paints and lacquers	LR	iso octane	R
ammonia (aqueous solution)	R	isopropyl alcohol	LR
ammonium chloride (saturated)	R	kerosene	R
ammonium hydroxide (10%)	R	lacquer thinner	N
ammonium hydroxide (conc.)	R	lactic acid (80%)	LR
aniline	N	methane	R
battery Acid	R	methyl alcohol (50%)	LR
benzaldehyde	N	methyl alcohol (100%)	N
benzene	N	methyl ethyl ketone (MEK)	N
bituminous emulsion	N	methylene chloride	N
bleach (see sodium hypochlorite)	R	mineral oil	R
bromine	N	mortar	R
butanol	LR	motor fuel (benzene-free)	R
butyl acetate	N	motor fuel (with benzene)	N
calcium chloride (saturated)	R	muratic acid (20%)	R
calcium hypochlorite	R	nitric acid (10%)	R
carbon tetrachloride	N	nitric acid (40%)	LR
cement	R	nitric acid (conc.)	N
chlorine water	LR	oil paints (pure)	R
chloroform	N	olive oil	R
chromic acid (40%)	N	oxygen	R
citric acid (10%)	R	ozone	R
cottonseed oil (edible)	R	phenol solution (5%)	N
detergent solution	R	phosphoric acid (10%)	R
diesel oil	R	plaster of paris	R
diethyl ether	N	soap solution (ivory)	R
dimethyl formamide	N	sodium carbonate (2%)	R
dioclyle formamide	N	sodium carbonate (20%)	R
ethyl acetate	N	sodium chloride (10%)	R
ethyl alcohol (50%)	LR	sodium hydroxide (1%)	R
ethyl alcohol (95%)	N	sodium hydroxide (10%)	R
ethyl dichloride	N	sodium hydroxide (60%)	R
ethylene glycol	R	sodium hypochlorite (5%)	R
2-ethylhexyl sebacate	R	stearic acid	R
formaldehyde (40%)	R	sulfuric acid (3%)	R
formic acid (2%)	R	sulfuric acid (30%)	R
formic acid (40%)	LR	sulfuric acid (conc.)	N
gasoline (regular, leaded)	LR	thinners (general)	N
glycerine	R	toluene	N
glycerol	R	trichloroethylene	N
glycol	R	turpentine	LR
heptane	R	urine	R
hexane	R	water (distilled)	R
hot bitumen	LR	xylene	N

## Select Mechanical and Physical Properties for 3form Chroma

		TYPICAL VALUES	
PROPERTY	ASTM METHOD	US CUSTOM	METRIC
GENERAL			
Density	D1505	1.19 g/cm3	1.19 x 10-3 kg/cm3
Water Absorption	D579 24hrs @ 73°F	0.2%	0.2%
MECHANICAL			
Tensile Strength	D638	10,000 psi	69 MPa
Elongation at Rupture	D638	4.5%	4.5%
Tensile Modulus	D638	400,000 psi	2800 MPa
Flexural Strength (rupture)	D790	17,000 psi	117 MPa
Flexural Modulus	D790	480,000 psi	3300 MPa
Compressive Strength (yield)	D695	17,000 psi	117 MPa
Compressive Deformation	D621 4000 psi, 122°F, 24 hours)	≤0.85%	
Shear Ultimate Strength	D732	10,000 psi	703 kg/cm²
Shear Modulus	D5279	167,000 psi	1151 MPa
Impact Strength (charpy method)	D256 notched	2.1 lbf*in/in	0.9 kgf*cm/cm
	D256 un-notched	7 lbf*in/in	3.17 kgf*cm/cm
Izod Impact Strength	D256 notched	≤0.25 ft-lb/in	≤13.3 J/m
Rockwell Hardness	D785	M-93	M-93
Barcol Hardness	D2583	48	48
Residual Shrinkage (internal strain)	D702	2%	2%
Coefficient of Friction	D2047 dry D2047 wet	0.73 0.79	
Dynamic Coef. of Friction	ANSI A137.1	.043 (average of 3 tests, all above 0.42)	
Poisson's Ratio	E132	0.35-0.40	
OPTICAL			
Refractive Index	D542	1.49	1.49
Light Transmission (total)	D1003	92%	92%
Haze	D1003	<1%	<1%
THERMAL			
Max Continuous Use Temperature		180°F	82°C
Max Instantaneous Use Temperature		212°F	100°C
Deflection Temperature	D648 @ 264 psi	195°F	90°C
Vicat Softening Point	D1525	239°F	115°C
PROPERTYASTM METHODUS CUSTOMMETRIC			
Forming Temperature		300-330°F	149-157°C
Coefficient of Thermal Conductivity (k-factor)	cenco-fitch	1.3 btu/(hr)ft²(°F)	0.19 w/m°K
Coefficient of Thermal Expansion	D696 @ 60°F (16°C)	4.0 x 10 <sup>-5</sup> (in/in/°F)	7.2 x 10 <sup>-5</sup> (mm/mm/°C)