



Aglas – EASY FORMING Sanitary grade Cast acrylic sheets



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INTRODUCTION

Aglas easy forming is modified type of sanitary grade cast acrylic sheet, which main characteristics are:

- a) easy thermoforming of demanding (pretentious) forms of baths
- b) lower temperature of the sheet needed for thermoforming
- c) Modification of the sanitary sheets in to easy forming is referring to acrylic structure and not to colour performance!



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HEATING THE SHEETS IN THE HOT-AIR OVEN

The optimal temperature of sheets which goes from oven to thermoforming process (manual transport) is between 155 degrees C and 165 degrees C. This temperature is referring to the temperature of the sheet surface, measured with remote IR thermometer. It is recommended not to use higher temperature as the material is than unlikely thermoformable and will brake earlier when used demanding forms. The limitation at lower temperatures is the quality of the form, usually seen at the outlet (outflow) of the bathtubs.

In practice it is usual (in ovens with intensive circulation of hot air) to reach the corresponding temperature of AGLAS easy form 4 mm sheets in 10 - 12 min. (temp. 170 deg. C – 175 deg. C) and in 9 – 10 min. (temp. 180 deg. C). Here stated temperature is the temperature of the hot air in oven. As the heating of the acrylic sheet is dependent on circulation of air and equality of the temperature in the oven, it is recommended to check the temperature of the acrylic sheet before you make a decision about certain temperature regime.



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HEATING WITH THE IR HEATERS

Whit this kind of heating it is recommended the sheet surface to have temperature between 155 degrees C and 165 degree C for thermoforming result. When using vacuum thermoforming machine with IR heaters (radiators) the temperature differences on different parts of the sheet are bigger those heated in hot air ovens. The differences between the highest and the lowest temperature on the sheet are usually bigger than 10 degree C. In that case it is recommended to heat some parts of the sheet less than 155 degree C instead to heat some parts of the sheet more than 165 degree C.

As there are various different IR heaters (regarding heat power and the depth of heating) and as there are a lot of different combinations of heater set-up, it is not possible to define the exact set-up combination on this machines. The optimal

set- up combination can be define after user uses series of test, considering advice of the producer of the machine.



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HEATING WITH THE IR HEATERS

It is advised to:

- a) avoid overheating of the acrylic sheet
start the heating set-up at the point where the sheet start to form
supervise the temperature division on the sheet with remote
thermometer**
- b) to lower heating times rather than surface surface temperatures of
the heaters**

The optimisation of thermoforming conditions of sanitary grade acrylic sheets easy forming depends on the thermoforming machine and is not without problems. For successful implementation of this material at new customer it is advised that Akripol's technical engineer is present on the beginning of the implementation.



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