

# Thermoforming guidelines

## Eastman TiGlaze™ copolyester architectural glazing products

### Thermoforming guidelines

Eastman TiGlaze™ copolyester	Forming range °C (°F)	Ideal forming temp. <sup>a</sup> °C (°F)	Max. heat speed mm/sec (mil/sec)	Max. cool speed mm/sec (mil/sec)	Max. demolding temp. °C (°F)	Mold shrinkage mm (in.)	Type of mold required	Type of heating elements required	Type of oven required <sup>b</sup>
TiGlaze SV™ copolyester	143–155 (290–310)	149 (300)	0.05 (2.0)	0.063 (2.5)	60 (140)	0.10–0.15 (0.004–0.006)	Any	Any	Horizontal recommended
TiGlaze ST™ copolyester	135–157 (275–315)	149 (300)	0.05 (2.0)	0.05 (2.0)	63 (145)	0.10–0.15 (0.004–0.006)	Any	Any	Horizontal recommended

<sup>a</sup>Maximum forming temperatures are taken as the temperature measured by an infrared temperature measurement device placed in the center of the top oven and measuring the temperature of the center of the top of the sheet sample. Temperatures will vary depending on how and where the temperature of the sheet is measured and depending on the thickness or gauge of the sheet.

<sup>b</sup>Horizontal thermoforming ovens are recommended when forming sheet manufactured from Eastman TiGlaze™ copolyester.

1. Keep molds very clean. Eastman TiGlaze™ copolyester products offer great part definition and are easy to thermoform.
2. Form Eastman TiGlaze™ copolyester products without drying the sheet.
3. Best practice is to heat the sheet uniformly. Also allow the molded part to cool for a short time (5 seconds) prior to cooling with fans, if so equipped.
4. Use a minimum draft angle of 5° in male molds for easy part release.
5. Allow for generous, internal corners (radius > sheet thickness) in part design to prevent breakage.



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Material Safety Data Sheets providing safety precautions that should be observed when handling and storing Eastman products are available online or by request. You should obtain and review the available material safety information before handling any of these products. If any materials mentioned are not Eastman products, appropriate industrial hygiene and other safety precautions recommended by their manufacturers should be observed.

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