

# Thermoforming Guidelines for TiGlaze™ Architectural Glazing Products

## Thermoforming Guidelines

Eastman™ Copolyester Glazing Product	Forming Range °C (°F)	Ideal Forming Temp.* °C (°F)	Max. Heat Speed mm/sec (mils/sec)	Max. Cool Speed mm/sec (mils/sec)	Max. Demolding Temp. °C (°F)	Mold Shrinkage mm (in.)	Type of Mold Required	Type of Heating Elements Required	Type of Oven Required*
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
TiGlaze™ SUV 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

\*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.

1. Keep molds very clean. Eastman™ copolyester glazing products offer great part definition and are easy to thermoform.
2. Form Eastman™ copolyester glazing products without drying the sheet.
3. Best practice is to heat the sheet uniformly. Also allow the molded part to cool for a short period of 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.

\*Horizontal thermoforming ovens are recommended when forming sheet manufactured from TiGlaze™ resins.

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