

## Recommended Thermoforming Temperatures

The following temperatures are recommended for use to produce hot-tub shapes using AcrySpa™ .125 in (3.2mm) continuous cast acrylic sheet products. Due to the fact that thermoforming ovens vary dramatically, the recommendations should be considered just that and not a warranty.

Aristech Surfaces LLC offers several families of products to the Hot Tub and Swim Spa Industry and listed below you will find most of the common materials used in the industry. Also listed will be temperatures for top-only ovens as well as double-sided ovens. Consistency of the heat across the entire surface is of great importance. There are temperatures listed for both the top and bottom surfaces.

The time required to achieve a given temperature is of great importance as well, and variation from the following time guidelines require that you adjust your temperature targets. Should your oven require more time to reach temperature, you may be required to reduce your temperature target. On the other hand, should you have the inclination and ability to run faster cycle times you may have to increase your target temperatures. In all cases the temperature range listed works that if you are in the shorter side of the time range you can target the upper recommended temperature, if your oven requires the longer end of the times listed you should target the lower end of the temperature spectrum.

For top-only ovens it is normal to run 4 to 6 minute heating cycles. When using a double-sided oven, the normal heating cycles vary from two to four minutes.

<u><b>Product</b></u>	<u><b>Top-Only Heat</b></u>	<u><b>Double-sided Heat</b></u>
<u><b>Marbles</b></u>	Top Surface 187C – 199C (368F - 390F)	Top Surface 182C – 193C (360F – 380F)
6427 Silver Marble	Bottom Surface 154C – 171C (309F – 340F)	Bottom Surface 171C – 193C (340F – 380F)
for example		
<u><b>Quarite</b></u>	Top Surface 187C – 199C (368F – 390F)	Top Surface 182C – 193C (360F – 380F)
9583 Sahara	Bottom Surface 154C – 171C (309F - 340F)	Bottom Surface 171C – 193C (340F – 380F)
for example		
<u><b>Pearlescent</b></u>	Top Surface 193C – 210C (380F – 410F)	Top Surface 193C – 204C (380F – 399F)
6696 White Pearl	Bottom Surface 160C – 171C (320F – 340F)	Bottom Surface 176C – 204C (349F - 399F)
for example		
<u><b>Opals</b></u>	Top Surface 193C – 210C (380F-410F)	Top Surface 193C – 204C (380F – 399F)
6811 Ocean Wave	Bottom Surface 160C – 171C (320F – 340F)	Bottom Surface 176C – 204C (349F - 399F)
for example		

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