

# PLEXIGLAS® SHEET: Thermoforming

ACRYLIC SHEET

## ALTUGLAS INTERNATIONAL SHEET PRODUCTS: OPTIMUM THERMOFORMING TEMPERATURES

- All Plexiglas® extruded products such as Plexiglas® MC, Plexiglas® Impact Family, Plexiglas® Q, Plexiglas® Frosted, Plexiglas® Clear Edge Frosted, Plexiglas® SG Plus Plexiglas® ELiT II and Plexiglas® HiDef™ have a recommended thermoforming temperature of 275°-350°F.
- All Plexiglas cell cast products such as Plexiglas® G, Plexiglas® GUVT, Plexiglas® GUF3/UF4, Plexiglas® II-UVA and Plexiglas® P55 have a recommended thermoforming temperature of 290-360°F

## PLEXIGLAS® SHEET: THERMOFORMING SHRINKAGE ALLOWANCES

When the final dimensions of the formed parts are critical, forms must be built sufficiently oversize to allow for shrinkage when the parts cool from forming temperature to room temperature. A shrinkage allowance of approximately 3/32 inch per foot should be made in designing female forms for Plexiglas® sheet and about 1/16 inch per foot for male forms. Remember it is better to remove too little material from a form than too much. Also, surfaces of the forms should extend beyond the trim line. This permits the use of slightly oversize sheet, which simplifies handling and compensates for the slight tendency of the plastic to curl away from the form and flare at the edges.

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