

Heating and Forming Guidelines

MATERIAL USE GUIDELINES

Heating Temperature Guidelines for Forming Boltaron Sheet

- Make sure to heat the sheet uniformly. A shiny surface is evidence of heating too quickly
- Forming temperatures range between 330° - 400 °F (165 - 204 °C) depending on sheet thickness
- The internal (core) temperature should be within 10 °F (-12 °C) of the sheet's surface temperature
- Cycle times depend on oven conditions and the grade of Boltaron sheet
Refer to Boltaron product data sheets for specific forming temperatures by grade
- Heater settings or percentage timers:
 - 30-50% top
 - 50-70% bottom

Typical Heating Conditions

Sheet Thickness	Typical Dwell Times	Temperature Range
0.028 - 0.080 in. (0.71 - 2.03 mm)	15 - 80 sec	330 - 350 °F (165 - 177 °C)
0.080 - 0.125 in. (2.03 - 3.175 mm)	80 - 140 sec	350 - 385 °F (177 - 196 °C)
0.125 - 0.250 in. (3.175 - 6.35 mm)	≥ 140 sec	385 - 400 °F (196 - 204 °C)

Oven Temperature Settings

These recommendations will help achieve the desired temperature profiles for heating Boltaron sheet:

- Position the sheet at greater distance from the bottom heaters than the top heaters
- A higher temperature profile in the bottom heaters will contain the heat below the sheet, and allow it to be absorbed uniformly, reducing the necessary heating time
- A lower temperature profile in the top heaters helps avoid overheating, which can create unwanted gloss on the sheet surface
- A profile of 30% on the top heaters and 70% on the bottom provides a good baseline
- Set perimeter temperatures 5 - 10% higher than other settings, depending on ambient temperature, to compensate for the effect of ambient air flow across the oven



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