

Thermoforming Guidelines for KYDEX® 2210LT

GENERAL GUIDELINES

- Do not utilize a flash heat forming technique as the process does not allow sufficient soak time for heat to reach the core of the material.
- The core sheet temperature should be within 5.6°C (10°F) of the surface temperature.
- Ideal heating cycle should be 1.0 – 1.5 seconds per 0.025mm (0.001") thickness.
- KYDEX® 2210LT does not form like other KYDEX® sheet products; do not expect the sheet to 'rebound' at the end of the forming cycle once most stresses have been removed.
- KYDEX® 2210LT does not form like other polycarbonate-based sheet products; the sag will generally be less than other polycarbonate sheets due to its higher melt strength.

FORMING PARAMETERS

- Typical heater settings are 30 – 50% top heaters (primary sheet side) and 50 – 70% bottom heaters (secondary sheet side).
- Two-sided (sandwich) heaters are recommended for forming KYDEX® 2210LT and may be necessary for thicknesses above 2.03mm (0.080").
- Base forming cycle on sheet temperature rather than a fixed cycle time.
- The forming temperature of KYDEX® 2210LT will range from 171 – 210°C (340 – 410°F) depending on the thickness of sheet, the complexity of the part, and the depth of draw.

Thickness	Forming Temperature
1.52mm to 3.18mm (0.060" to 0.125")	171 - 193°C (340 - 380°F)
≥ 3.18mm (0.125")	193 - 210°C (380 - 410°F)

- Forming temperatures should not exceed 215°C (419°F).
- Mold temperature should be set at 71.1 – 76.7°C (160 – 170°F) to prevent chill marks.

DRYING CONDITIONS

- Always pre-dry KYDEX® 2210LT before forming to avoid issues caused by moisture.

Thickness	Drying Time (hr) at 73.9°C (165°F)
2.03mm (0.080")	10
3.18mm (0.125")	16
4.75mm (0.187")	20
6.35mm (0.250")	24



Customer Collaboration

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