

Thermoforming Guidelines

Durat sheets thermoform at a lower temperature than other solid surface materials. Heat Durat to 212-230°F (100°-110°C) before clamping it to a pre-made jig, let cool while clamped to jig. When cooled to room temperature and removed from the jig, the sheet might pull back a little but is easily bent back to the required shape. The minimum radius for a full sheet of Durat is 98" (2500 mm), and the minimum radius for a half width sheet of Durat[®] is 40" (1000 mm). Smaller radii are possible, as you cut the strips into smaller widths. Narrow strips, 1-1.5" (20-30mm) can be thermoformed to 5.5" (220mm). Please also note that thinner sheets of Durat (9mm) may be thermoformed more easily, but these may be special order, so please check with your distributor on lead times.

Thermoforming oven temperatures may vary. A thermoforming press is more efficient, requiring a shorter time. Solid surface fabricators are familiar with their equipment and can determine the duration using these guidelines. In a platen oven 20-22 minutes is sufficient.

No yellowing of the material should occur at 230°F, however if the temperature exceeds 250°F, some yellowing may occur, and the material may expand.