

PLASTIC QUICK REFERENCE GUIDE

IMPORTANT: Heating time may vary depending upon machine. If plastic does not adapt to model, add heating time until adaptation occurs. If plastic "folds" when thermoformed, reduce heating time until material does not fold. Below reflects times after preheat.



ESSIX ACE® PLASTIC

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
0.75mm (.030")	25 seconds	113	55 seconds	3/8" – 1/2"
0.88mm (.035")	30 seconds	123	60 seconds	3/8" – 1/2"
1.0mm (.040")	35 seconds	133	65 seconds	3/8" – 1/2"



ESSIX C+™ PLASTIC

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
1.0mm (.040")	60 seconds	163	90 seconds	No Sag



ESSIX C+™ PLASTIC COLORS

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
1.0mm (.040")	50 seconds	163	90 seconds	No Sag



ESSIX A+™ PLASTIC

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
0.5mm (.020")	30 seconds	122	60 seconds	1/2"
0.75mm (.030")	35 seconds	132	60 seconds	1/2"
1.0mm (.040")	40 seconds	142	65 seconds	1/2"
1.5mm (.060")	50 seconds	164	70 seconds	1/2"
2.0mm (.080")	70 seconds	205	90 seconds	1/2"
3.0mm (.120")	80 seconds	226	2 min. 10 sec.	1/2"



ESSIX TRAY RITE® PLASTIC

Thickness	Vacuum Heat Times	Biostar® Code	Drufomat	Sag
0.5mm (.020")	25 seconds	113	30 seconds	No Sag



ESSIX EMBRACE® PLASTIC

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
0.75mm (.030")	35 seconds	133	70 seconds	No Sag
1.0mm (.040")	40 seconds	143	75 seconds	No Sag



MOUTHGUARD MATERIAL

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
1.0mm (.010")	30 seconds	142	70 seconds	1/2"
1.5mm (.060")	40 seconds	162	75 seconds	1/2"
2.0mm (.080")	45 seconds	200	85 seconds	1/2"
3.0mm (.120")	50 seconds	225	120 seconds	1/2"
4.0mm (.150")	55 seconds	236	130 seconds	1/2"



ESSIX® DUAL LAMINATE

Thickness	Vacuum Heat Times	Biostar® Code*	Sag
2.0mm (.080")	Soft – 45 seconds	Soft – 151 (triple flip)	No Sag
	Hard – 15 seconds	Hard – 105 (triple flip)	No Sag
3.0mm (.120")	Soft – 90 seconds	Soft – 231 (triple flip)	No Sag
	Hard – 25 seconds	Hard – 115 (triple flip)	No Sag

* Triple Flip: Heat soft surface then heat hard surface then flip before pressure forming



ESSIX U-C-ME® PLASTIC

Thickness	Vacuum Heat Time	Biostar® Code	Drufomat	Sag
1.0mm (.040")	60 seconds	183	90 seconds	No Sag