

# Plastics Temperature Guide

Important: Always ensure the oven has reached the required temperature. Then consider the thickness of the sheet in calculating the time it is in the oven. A general rule is 3 minutes for every mm of thickness

<b>Polydur</b>	<b>Polymethyl Methacrylate Modified</b> Oven Temperature: 170 deg.C. Resilient Orthotic Material - A replacement for Plexidur/Rohadur
<b>Europlex</b>	<b>Polytrimethyl Hexamethyl Enterephthalamide, Modified</b> Oven Temperature: 170 deg.C. Another replacement for Plexidur/Rohadur
<b>Polypropylene</b>	<b>Copolymer Polypropylene</b> Oven Temperature: 180-200 deg.C. Oven Time at 180 deg.C is 3 minutes per mm thickness
<b>Polyethylene LD</b>	<b>Low Density Polyethylene</b> Oven Temperature: 130 deg.C Oven Time at 130 deg .C is 3 minutes per mm thickness
<b>Polyethylene HD</b>	<b>High Density Polyethylene</b> Oven Temperature: 180 deg.C Oven Time at 180 deg.C is 3 minutes per mm thickness
<b>Vitrathene</b>	<b>Press Moulded Polythene</b> Oven Temperature: 160 deg.C Oven Time at 160 deg.C is 3 minutes per mm thickness
<b>Madrilen 1000</b> <b>Madrilen 500</b>	<b>Press Moulded Polythenes</b> 1000 is 'Ultra-high' molecular weight and 500 is just a 'High' molecular weight Oven Temperature: 160-180 deg.C
<b>Transpet (P.E.T.G.)</b>	<b>Extruded Transparent Polyester Sheet</b> Oven Temperature: 160 deg.C Heat to 100 deg.C for 15 minutes before draping
<b>Surlyn</b>	<b>Low Density Co-polymer</b> Oven Temperature: 180-190 deg.C
<b>Starflex</b>	<b>Multi-Thickness Resin Blank for Foot Orthotics</b> Boiling Water: 95-100 deg.C or 'spot' heat with a hot air gun
<b>Algecast</b>	<b>Low Temperature Thermoplastic</b> Based mainly on Polycaprolactone and Polyurethane. The materials are activated by placing in Hot Water at 70 deg.C or steam at 90 deg.C
<b>Baycomp XStal</b> <b>Composite Panels</b>	<b>Glass Resin - 8 ply</b> Thickness: 2.8mm <b>Xstal Panels</b> Oven Temperature: 200 deg.C
<b>XT Sprint Foot Orthotic System</b>	<b>Oven Temperature:</b> 200 deg.C Oven Time at 200 deg .C is 3-5 minutes - dependent on the thickness of the plate
<b>Plastazotes &amp; Evazotes</b>	<b>Oven Temperature:</b> 70-120 deg.C (Dependent on Density) Oven time at 120 deg.C is 3 minutes per mm thickness
<b>EVA and Micro Materials</b>	<b>Oven Temperature:</b> Low Densities 120-130 deg.C Medium-High Densities 130-170 deg.C Oven time at 130 deg.C is 3 minutes per mm thickness