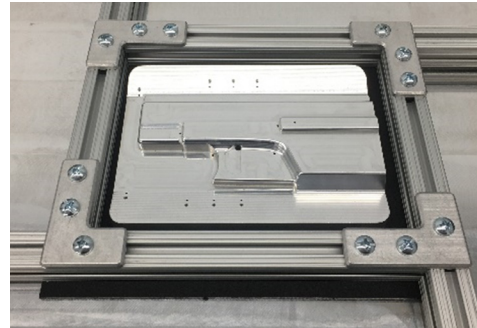
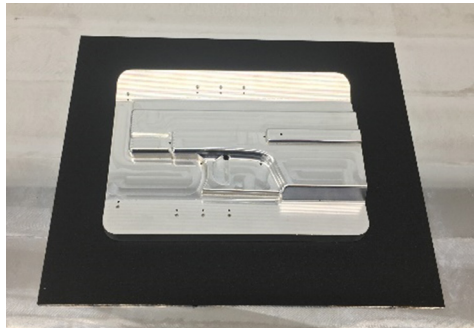


KYDEX® Thermoplastics Forming Parameters for Holsters & Sheaths

FORMING PARAMETERS

Cut a sheet blank slightly larger than the holster/sheath mold.

A 2 – 3” parameter around the mold should provide sufficient material to create a vacuum seal when forming.



Heat the blank in oven, heat press (like a toaster oven), or a clamshell heat press used for t-shirt graphics.

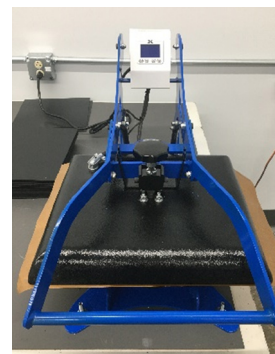


Table 1: Recommended Forming Parameters

| Heating Type | Oven Temperature | Heating Time | Forming Temperature |
|--------------|------------------|---------------------|---------------------|
| Toaster Oven | 370 – 380°F | 4:00 – 5:00 minutes | 320 – 340°F |
| Heat Press | 370 – 390°F | 3:30 – 5:00 minutes | 320 – 340°F |

- Since multiple variables affect forming time and subsequent sheet temperature, the use of a IR thermometer is recommended to ensure the proper forming temperature.
- For more complex geometries, a forming temperature of 340 – 360°F may be necessary to achieve definition
- KYDEX® sheet should never be heated above 400°F, as it will begin to degrade and emit fumes
- It is not recommended to heat KYDEX® sheet in kitchen stove because there is risk of damage to the oven if the material is accidentally overheated

Align heated blank over mold and pull vacuum as quickly as possible to prevent sheet from cooling. Maintain vacuum on formed blank for three (3) to four (4) minutes as the material cools.

- A fan may be used to assist in cooling
- Do not quench/rapidly cool the form as it will trap stress that may cause warping or lower physical characteristics in the final part
- Demold the formed blank from the mold
- Form should be cool to the touch before demolding
- Demolding when warm can result in the form warping or losing shape



Customer Collaboration
 6685 Low St, Bloomsburg, PA 17815 USA
 Phone: 800.325.3133, +1.570.389.5810
 Email: info@kydex.com

appLab™
 Phone: 800.682.8758
 Email: applab@kydex.com

kydex.com