



## Alingers, Retainers & Splints (Forming Instructions)

**Note:** This material will absorb moisture. Store in bag with desiccant. Use all materials within 6 months for the best results.

1. Remove blue/clear film from both sides of plastic before heating.
2. Turn on heating element on vacuum machine. Allow 2-3 minutes to pre-heat; the heating element will be orange.
3. Place plastic into vacuum frame and close. Slide frame with plastic up toward heating element, swing heater over to heat plastic.
4. Tru-Tain retainer plastic and splints heat until ½ inch sag appears, turn vacuum on and slide frame with plastic over model.
5. Leave vacuum on for 20-25 seconds, let cool or spray with *Insta-Cool* for immediate handling.
6. Remove and trim.

Thickness	Drufomat	Biostar® Code
.020" (0.5mm)	0:50	103 (20s)
.030" (0.75 mm)	1:00	113 (25s)
.035" (0.88 mm)	1:05	123 (30s)
.040" (1.0mm)	1:10	133 (35s)
.060" (1.5mm)	1:25	144 (40s)
.080" (2.0mm)	1:35	154 (45s)
.100" (2.5mm)	1:45	164 (50s)

*Acrylic will adhere to material*

Any Questions Call TRU-TAIN at 1-800-843-0904

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