



FORMING GUIDELINES

1. Remove blue or clear film from both sides of plastic before heating.
*Tru-Tain DX material may be formed with film on if you wish
2. Turn on the heating element of the vacuum machine. Allow 2-3 mins to pre-heat; heating element will be orange
3. Place plastic into vacuum frame & close. Slide frame with plastic up toward heating element, swing heater over to heat plastic
4. Heat Tru-Tain DX plastic & splints 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

TRU-TAIN DX MATERIAL				
Thickness	.030 (0.75MM)	.035 (0.88MM)	.040 (1.0MM)	.050 (1.27MM)
BioSTAR	Code 113	Code 123	Code 133	Code 144
MiniSTAR	Code 123	Code 133	Code 143	Code 154
MiniSTAR S	Code 133	Code 143	Code 153	Code 164
Drufomat	Heating - 1:10	Heating - 1:15	Heating - 1:20	Heating - 1:30
	Cooling - 1:40	Cooling - 1:45	Cooling - 1:50	Cooling - 2:00

TRU-TAIN DX MATERIAL - MAYKU MULTIPLIER								
	Thickness (mm)	Temp (°C)	Pressure (psi)	Heat-on (psi)	Power (%)	Soak (s)	Form/Hold (s)	Cool (s)
DX30 (.030")	0.75	165	52	40	100	0	30	30
DX35 (.035")	0.88	165	53	39	100	0	30	35
DX40 (.040")	1	168	54	39	100	0	32	40
DX50 (.050")	1.27	171	57	36	100	0	40	55

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