



The Enclosure & Instrument
Case Designer & Manufacturer

PERANCEA

Vacuum Forming: A Designer's Guide

Where tooling cost is a major project consideration in plastic applications, vacuum forming is a highly viable alternative to injection moulding, dramatically reducing tooling outlay by a factor of 10 or more.

The following table provides a guideline for designers to help select the correct material and set the design parameters for vacuum formed components.

Material	ABS	Flame Retardant ABS	PVC	HIPS	CAB	Polycarbonate
Forming Characteristics	E	G	G	E	G	G
Flame Retardance	F	E	E	P	F	E
Chemical Resistance	G	G	E	F	F	G
Max Usable Temp (°C)	100	100	75	90	90	130
Tensile Strength (kg/m ²)	350	280	420	250	740	250
Colour Range	G	F	F	G	F	P
Nominal Thickness Max	4.75	4.75	6.00	4.00	6.00	4.00
Range (mm) Min	1.50	1.50	0.50	0.75	1.50	1.50

E = Excellent G = Good F = Fair P = Poor
The above figures are provided only as a guide and should not be taken as binding upon the manufacturer

Maximum Component Size: 1950 x 1450 x 425mm deep

Component Depth: Should not be greater than 0.8 of the shorter of the plan dimensions

Draft Angle: Minimum 1.5° depending on depth

Minimum Corner Radii: 2.5mm

General Tolerance: +/-0.5mm

Stock Colours: Clear, Black & White, with other colours available

Dimensions: Specify as internal where possible

If vacuum formed plastics is your solution, call Perancea now and see what we can do for you.

PERANCEA LTD

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