

## Rowmark Sheet: Heat Bending Recommendations

Product	Gauge (Inches)	Temperature (°F)	Time (Seconds)
ADA Alternative®	1/16"	300°	30 – 35
Color Cast Acrylics	1/8"	300°	150 – 180
Contemporary Woods	1/16"	300°	35 – 40
FlexiBrass® & FlexiColor®	.020"	300°	5
Frosted Acrylics	1/8"	300°	150 – 180
Granites Deluxe	1/16"	300°	30 – 35
Lacquers	1/16"	300°	30 – 35
LaserGlow™	1/16"	300°	30 – 35
LaserMark	1/16"	300°	30 – 35
LaserMax®	1/16"	300°	30 – 35
Mattes	1/16"	300°	30 – 35
Metalgraph Plus™	1/16"	300°	30 – 35
NoMark Plus®	1/16"	300°	30 – 35
Outdoor Weatherable Metals	1/16"	300°	30 – 35
Reverse LaserMark®	1/16"	300°	30 – 35
Satins	1/16"	300°	30 – 35
Silks	1/16"	300°	30 – 35
Slickers	1/16"	300°	30 – 35
Standard Metals	1/16"	300°	30 – 35
Textures	1/16"	300°	30 – 35
UltraMatte Front Engraveable	1/16"	300°	30 – 35
UltraMatte Reverse Engraveable	1/16"	300°	30 – 35
<b>When bending 1/8" gauge versions of material, general rule is to increase time to 150 – 180 seconds.</b>			

*Intended as guidelines only, adjustments may be necessary to achieve your optimal results.*

Above results were performed bending Rowmark sheets on a 300 watt strip heater. Use extreme caution when heat bending, as the acrylics will become extremely hot. Ensure which direction the material needs to be bent, as the bend will go towards the side of the sheet that is touching the heat strip. Evidence that the sheet is nearly ready will be a faint line visible over the heat strip. This indicates the acrylic has become pliable throughout the sheet. Once material is properly heated, remove it from the heat strip, bend to the desired position and hold steady until the material cools.