SCHNELLER

AerForm® LHR Processing Guide

Technical Bulletin

NOTE: Most often the problem is trying to heat the AerForm® LHR sheet too quickly.

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
Inadequate definition of part	• Heating too rapidly-glossy areas will appear on part • Uneven heating of AerForm™ sheet • Inadequate heating • Weak or inadequate vacuum	• Reduce heat and increase length of heating time to compensate if necessary • Replace aged heaters and use screening if needed to level heating • Increase length of heating time • Inspect vacuum lines. Increase vacuum holes. Inspect seals.
Part with pits or voids	• Heating too rapidly or excessively • Dampness in AerForm™ sheet	• Reduce heat and increase length of heating time to compensate if necessary • Dry according to recommendations
Part warpage	• Removing part too quickly • AerForm™ sheet core too cold during forming	• Increase length of cooling time on mold or utilize a cooling fixture • Reduce heat and increase length of heating time to compensate if necessary
Glossy areas	• Heating too rapidly or excessively • Uneven heating of AerForm™ sheet	• Reduce heat and increase length of heating time to compensate if necessary • Replace aged heaters and use screening if needed to level heating
Chill marks	• Mold too cold • Poor draft angle	• Mold should be 150ºF (66ºC) before forming • Increase draft angle
Thinning of walls	• AerForm™ sheet too cold during forming • Mold too cold or insufficient heat distribution • AerForm™ sheet gauge too thin • Uncontrolled (insufficient) heat distribution • Inadequate forming method	• Increase length of dwell time • Process mold through a cycle before forming first part of day, or redesign mold heat distribution • Increase sheet gauge • Inspect heaters for operability. Utilize screening. Inspect for drafts or air currents. • Try billow-snap back (male) or billow-plug assist (female)