

Instructions for use

1. Cast and trim model into a horse shoe shape to the required depth
2. Assess undercuts and block-out were necessary with plaster or similar
3. Apply separator if required to the model (not required if you are forming cachet with the protective film on the fitting surface)

NB – We recommend that the protective film is left on both sides of the cachet blank as this will protect the finish of the appliance and ensure it is crystal clear at the finishing stage.

4. Place cachet blank in your forming unit so the opaque film side faces the fitting surface
5. Vacuum/Pressure form (see below for guidelines) and leave to cool after forming to ensure there is no distortion
6. Trim the excess away whilst on the model using a tri-cutter or similar, then remove from model and trim to the required finish using a fine pair of scissors or equivalent
7. Use a Scotch Brite Disc (purple) to smooth/polish the edges
8. Remove the film from both sides

Suggested forming times for manual vacuum forming units

	Heating Time	Cooling Time
0.80mm Cachet	35 to 40 seconds	45 to 60 seconds
1.00mm Cachet	40 to 45 seconds	45 to 60 seconds
1.50mm Cachet	80 to 90 seconds	60 to 75 seconds
2.00mm Cachet	90 to 100 seconds	60 to 75 seconds

Suggested forming times for pressure formers

Biostar	
0.80mm Cachet	Programme Code 132 (Heat 35 sec or manual set to 30 sec)
1.00mm Cachet	Programme Code 132 (Heat 35 sec)
1.50mm Cachet	Programme Code 153 (Heat 45 sec)
2.00mm Cachet	Programme Code 163 (Heat 50 sec)
Pressure 4 – 5 bar	

Bioform/Dunaform

	Heating Time	Cooling Time
0.80mm Cachet	25 to 30 seconds	45 to 60 seconds
1.00mm Cachet	30 to 35 seconds	45 to 60 seconds
1.50mm Cachet	45 to 50 seconds	60 to 75 seconds
2.00mm Cachet	50 to 55 seconds	60 to 75 seconds

Pressure 4 – 5 bar

Erkopress

	Temperature	Heating Time
0.80mm Cachet	145 degrees	30 to 40 seconds
1.00mm Cachet	150 degrees	35 to 45 seconds
1.50mm Cachet	155 degrees	45 to 60 seconds
2.00mm Cachet	160 degrees	55 to 70 seconds

Pressure 4 – 5 bar

The above is for guidance as all machines may differ slightly, due to age and condition. We recommend you carry-out tests using various timings to achieve the optimum results from your forming unit.

NB – Please be careful not to overheat the material as this can cause the material to become brittle.

Once the foil package has been opened, please ensure the remaining blanks are kept in a dry, moisture free environment and used within 4 weeks of opening. **Please note Cachet is hydroscopic and will absorb moisture, if not store appropriately.** Moisture can cause small bubbles to appear during the forming process.

Uses and indications

0.80mm Cachet	Aligners
1.00mm Cachet	Aligners / Retainers
1.50mm Cachet	Rigid Retainers or Base Plates
2.00mm Cachet	Orthodontic Appliances

NB – Cachet chemically bonds to cold cure acrylics

Manufacturer

WHW Plastics Limited, Therm Road, Hull, East Yorkshire, HU8 7BF
T: 01482 329 154/ 0800 0092 444 E: sales@whwplastics.com