



FRIDDLE'S ORTHOPEDIC APPLIANCES

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Fabrication Instructions for Friddle's "ON THE SPOT" Paper Transfers

1. Place the plastic into a pre-heated 400 to 450 degree Fahrenheit oven. NOTE: 400 degree minimum is required for transferring image.
2. When the plastic is completely heated, open the oven and place the transfer, image side down with one corner turned up to make a pull-tab, onto the hot plastic.
3. Gently (lightly) rub the transfer onto the plastic, working out any air bubbles, for 15 seconds.
NOTE: the longer you leave the transfer on the plastic, the darker the image will be.
4. Immediately remove the transfer paper by grabbing the pull-tab that you made, and pull the paper from the plastic with one smooth motion.
5. The image should now be in the plastic.
6. Vacuum form the plastic in a conventional manner, taking care not to distort the image by excessively stretching the plastic.

Friddle's Coloring Paper Instructions

1. Measure the piece of thermoplastic that you choose to use.
2. Cut a piece of coloring paper slightly smaller than the plastic.
3. A mist of silicone spray applied to the paper prior to application may help prevent sticking.
4. Place the plastic into your oven and heat to its optimum temperature.
5. When the optimum temperature is reached, remove the plastic from the oven and place on a hard flat surface.
6. Place the coloring paper image side down on the hot plastic. Take care to prevent bubbles and wrinkles by using thermal gloves and very slight pressure.
7. Remove the coloring paper by peeling from the plastic after 15 – 30 seconds. The actual coloring process takes place at a temperature of 400 to 425 degrees F.
8. The plastic may be returned to the oven if necessary.
9. The plastic may now be formed in the usual manner. Take care not to over stretch the plastic, as this will distort the color image.

This quick and easy method of coloring keeps the surface homogeneous and the color can not be scratched off. There are no changes in the vacuum forming process. Color shades in the brochure may differ from the shades on the finished material. Color may be more intense or lighter depending on the material used. Coloring paper will stick to the plastic if it is overheated or if the paper is left in contact with the plastic for an excessive amount of time. Remove the coloring paper before vacuuming the thermoplastic. Store papers in a dry and cool place.

Instructions for Applying The **POSITIVE IMAGE** Paper Transfers

1. Place the plastic in the oven. NOTE: no extra preparation is needed to the the surface of the plastic, simply clean it off with acetone.
2. When the plastic is ready to pull, open the oven and place the transfer, IMAGE SIDE DOWN, on the hot plastic.
3. Gently rub the transfer onto the plastic, working out any bubbles. All you are doing is applying even pressure to the transfer.
4. Start counting to 7 slowly , after 7 seconds pull up the corner of the paper transfer and remove from the plastic. The image is now in the plastic. REMEMBER, if you leave the transfer on for more than 10 to 12 seconds, it will stick to the plastic.
5. Now, simply pull the plastic in a conventional manner. Take care not to stretch the plastic as you are forming it.
6. For best results we recommend using copolymer polypropylenes for Positive Image transfers.

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