

VELSTONE THERMOFORMING

EQUIPMENT REQUIRED

Convection Oven, Jig, Clamps, Gloves

Prepare a jig of the required radius. Plywood / MDF / Hardboard combination is preferred material for the jig. For most thermoforming jobs, only a male jig is necessary. However in some cases it may be necessary to place hardboard sheet/strip over hot Velstone, prior to clamping, to prevent the sheet curling during clamping or cooling.

Cut the strip of required size of from the VELSTONE sheet. Prepare the sheet by removing all nicks or cuts on the edge as any nick or cuts on the edge might develop in to crack during thermoforming.

Pre-heat the Oven and allow the temperature to stabilise at 115-120⁰C. Place the entire VELSTONE strip in the oven and maintain the heat for about 12-15 minutes. Variations of time are expected depending upon the ambient temperature and conditions. It is very important that the heat penetrates all of the way through the entire thickness as cold spots may result in the material breaking rather than bending. The VELSTONE strip, when uniformly heated for correct time, should be as soft and flexible as rubber. When the material is sufficiently soft and flexible, take it out of the oven and lay it on the jig. Use gloves when handling hot material. Follow the jig curve gradually and clamp.

Allow the material to cool to room temperature before opening the jig clamps to prevent the material from springing back. Open the clamps and remove the strip from the jig. Practice and experience in thermoforming VELSTONE will achieve excellent results.

Notes:

1. Do not use excessive temperatures. It may discolour the material surface.
2. Minimum bending radius is dependent on the colour, width and the thickness of Velstone strip.
3. Large granule Velstone colours may show a "Stretched" effect on grain pattern when thermoformed to a tight radius.