Heat Forming AZEK Trim & Moulding

Heat Blanket

The following pages have general information on heat forming AZEK Trim and Moulding Products using a heat blanket and are not intended as a Users Manual. You should always use the heat blanket manufacturers User Manual instructions when using their product.
Heat Blanket
2 x 6 Boards

- 2 x 6 Boards 8” Long
Cement Boards

- One at 10” x 65”
- One at 5” x 65”
Form & Clamps
Template

- Form dimensions

3/4" Plywood form Fastened to Backer

5/8" or 3/4" Plywood

Cut Corners Optional

5" Straight Beyond 15" Radius

15"

30"

40"
Preparing to Heat Form

- Layout wooden blocks to support cement board (8” x 65”) and to protect work surface from heat
Heat Blanket

- Place heat blankets on Cement board
Preparing to Heat Form

- Begin preheating
  - Place 5” x 65” cement board between blankets
  - Set Controller to High
  - Preheat for 15-20 Min.
Preparing to Heat Form

- Preheating system
  - Do not allow heated portion of blankets to come in direct contact
  - Temperature should reach about 290 - 300 degrees F
  - Lower heat if forming will not begin for some time
Heat Forming

- Place AZEK material (3/4”x 3.5”x 64”) between blankets with preheated cement board on top and bottom as shown.
Heat Forming

- Continue heating for 7 – 10 minutes temperature should reach about 300 F
- Periodically check temperature
Heat Forming

- When product is approaching final temperature check for consistency
- Consistency should be like cooked spaghetti
Heat Forming

- When proper temperature is reached place material over center of form
- Gently form material around radius
- If product wrinkles or feels too rigid to form straighten piece out before it cools too much and place back in heat blankets.
- If top edge wants to roll away or curl from form; a block of wood can be used to gently hold material flat while it cools. Too much pressure will mark the AZEK surface.
Heat Forming

- Clamp Product and allow to cool
- Product can be removed once cool enough to maintain its shape
Tips & Techniques

- Longer pieces of AZEK can be heat formed by heating one side at a time.
  - Lay blankets end to end without overlapping blankets
  - Begin heating product one side at a time. Flip product periodically until board reaches proper temperature.
  - A piece of preheated cement board can be used to keep top face warm during the heating process.
- A tight radius may have a tendency to wrinkle slightly on the inside edge of the formed piece. A router can be used to clean this edge up.
- Wrinkling on larger radius pieces may be an indication that the part has not been heated enough or that it has cooled too quickly
Where to Buy:

- Heat Blankets are available through your AZEK Building Products Dealer
- Or direct from Heatcon-
  AZEK Trim Heat Forming Kit HC99-100
  Phone: 800-556-1990
  Email: wainfo@heatcon.com