

Heat Forming



Culvert Pipe



The following pages have general information on heat forming AZEK Trim and Moulding Products using a culvert pipe setup.

Example of Culvert Pipe Setup 1



Pg 2-Culvert Heat Forming

Example of Culvert Set Up 2



Pg 3-Culvert Heat Forming

Heat Forming- Culvert Pipe:



Please refer to the pictures on pages 2 and 3 for examples of culvert pipe/torpedo heater setups for this method of heat forming.

By directing the heat into a metal stove pipe a more uniform heating occurs. Care must be taken to not overheat the AZEK product, which can cause it to become rough and possibly discolored. A test piece of AZEK product should always be heated first to more accurately determine heating time and avoid overheating.

Culvert Pipe Set Up-More Info:



- Since every set up can be different, the following are guidelines only. It is up to the fabricator to test their set up to make sure the AZEK product is not overheated causing surface damage and to determine more accurate heating times.
- It is always recommended to test a scrap piece of AZEK product first.
- Place clay bricks every 36" or so inside culvert pipe. Place a fiber cement board on top of the clay bricks to allow for circulation and to keep AZEK product from directly resting on the pipe.
- Surface temperature should not exceed 320 degrees for more than 10 minutes. Heating times are approximately 3 minutes per ¼" thickness of the AZEK product. Longer times may be required when heating is not uniform.
- Wrinkling on larger radius pieces may be an indication the AZEK Product has not been heated enough or it has cooled too quickly.
- 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.
- AZEK Frontier finish will flatten out if heat formed.

- **If you need further assistance:**
- Call ASK AZEK: 877-275-2935 or email: info@azek.com

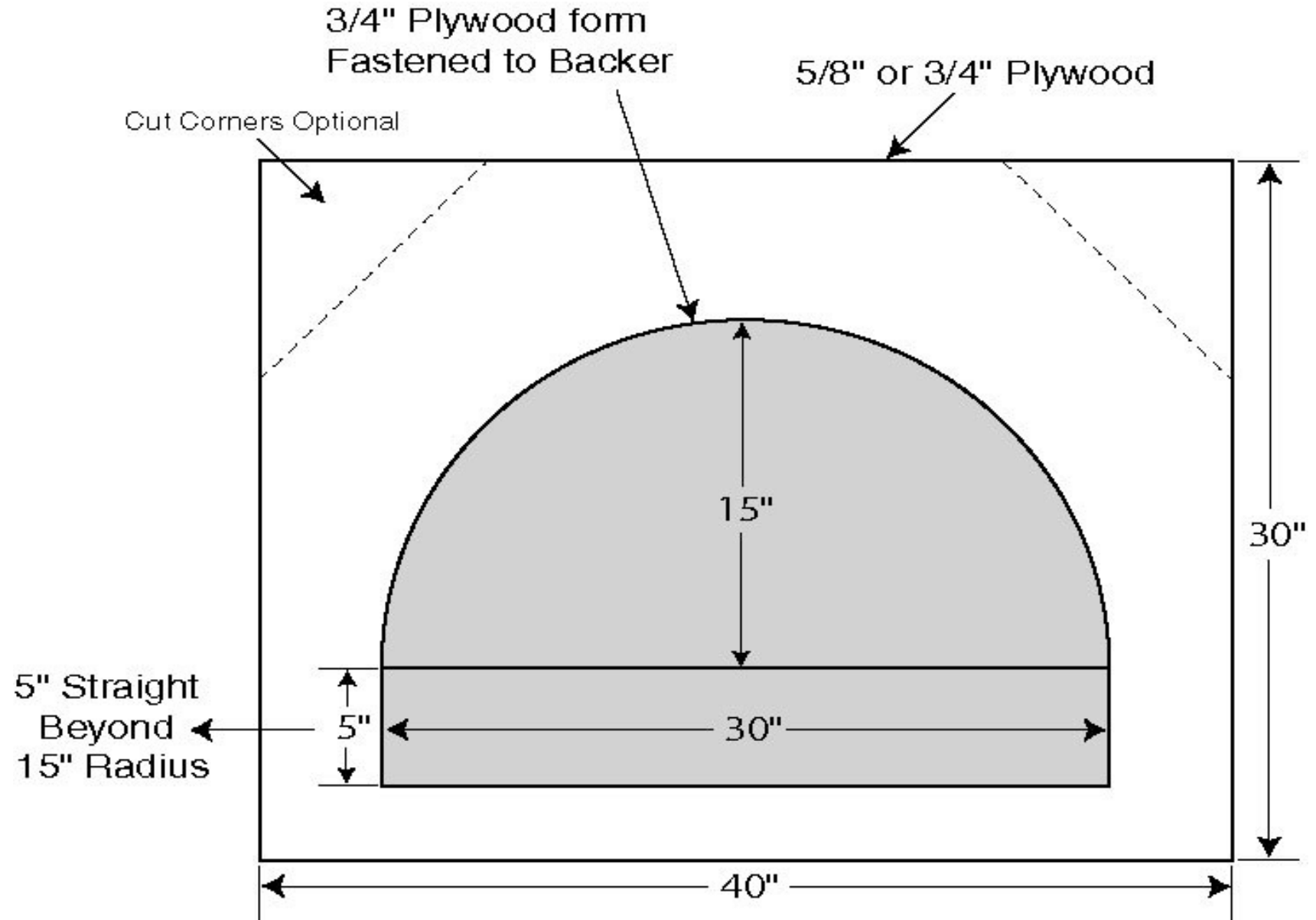
Form & Clamps



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Template

- Form dimensions

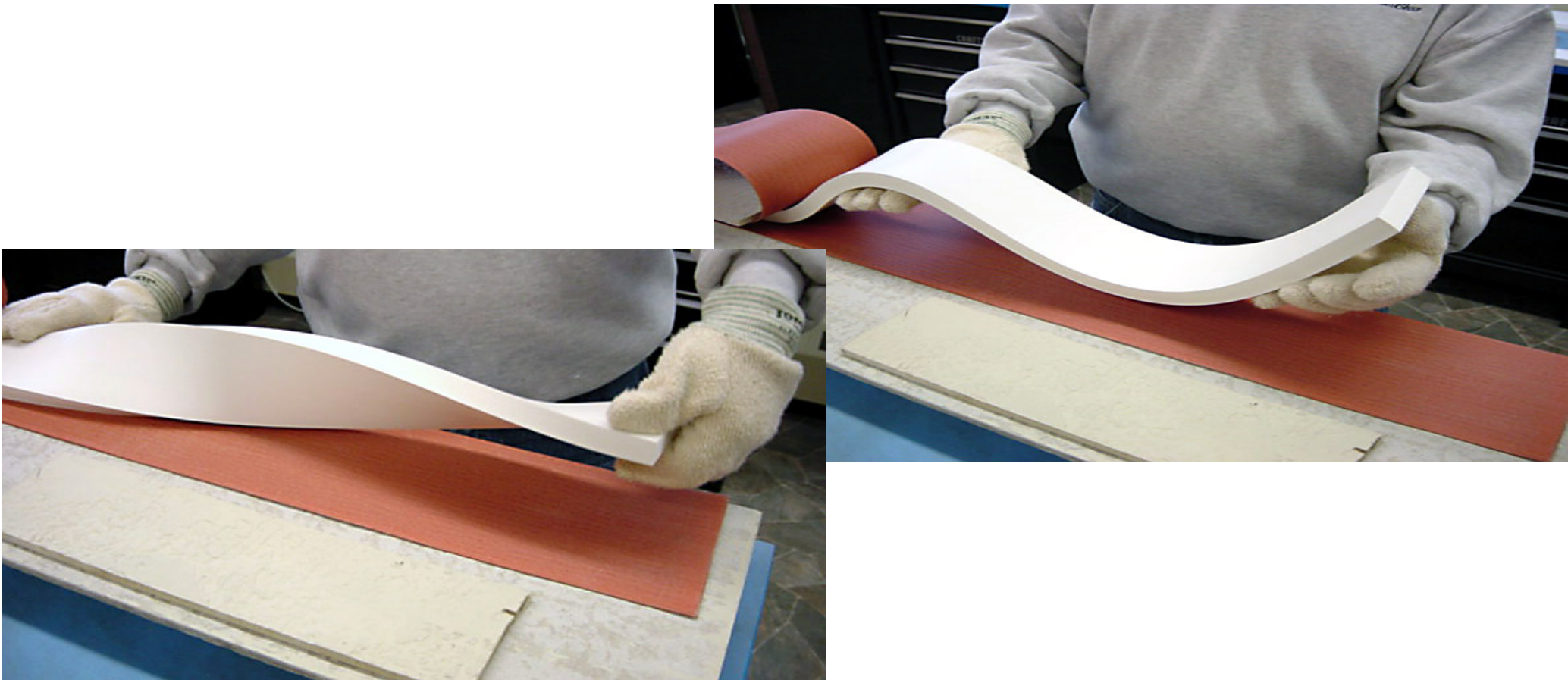


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Heat Forming



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

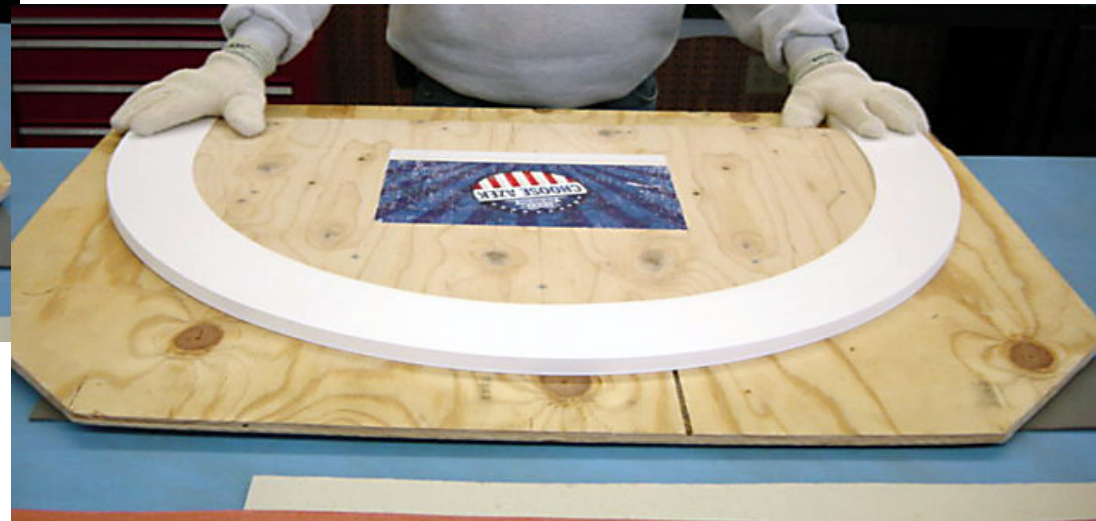
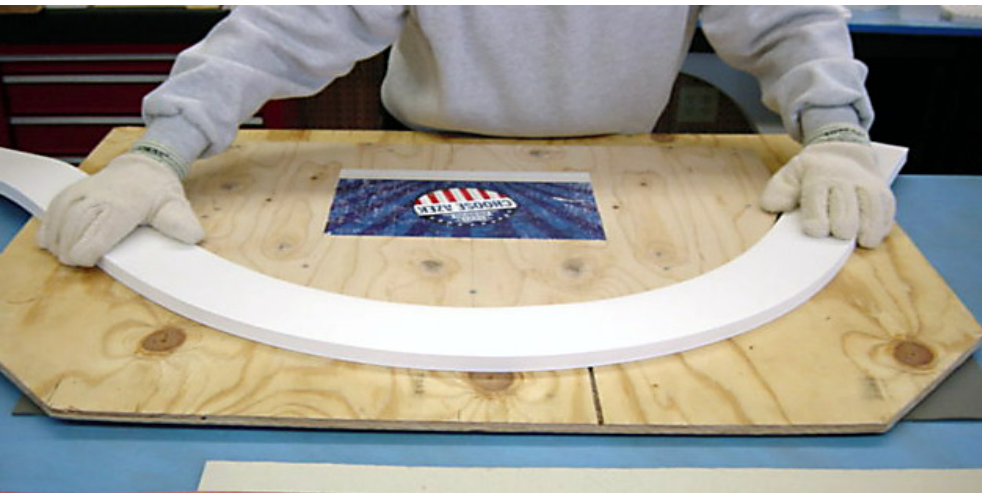


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Heat Forming



- 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.



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Heat Forming



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



Pg 10-Culvert Heat Forming-The End