

Heat Forming AZEK Trim & Moulding

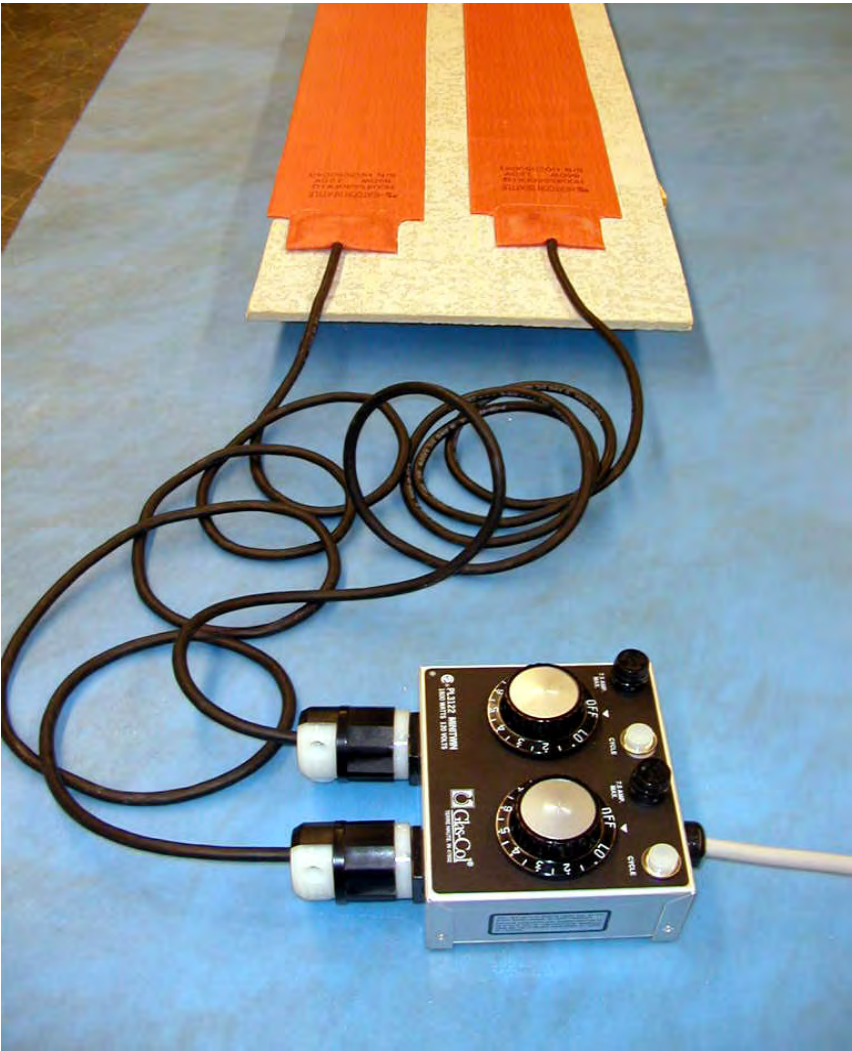


Heat Blanket



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



- Cement Boards
 - One at 10" x 65"
 - One at 5" x 65"



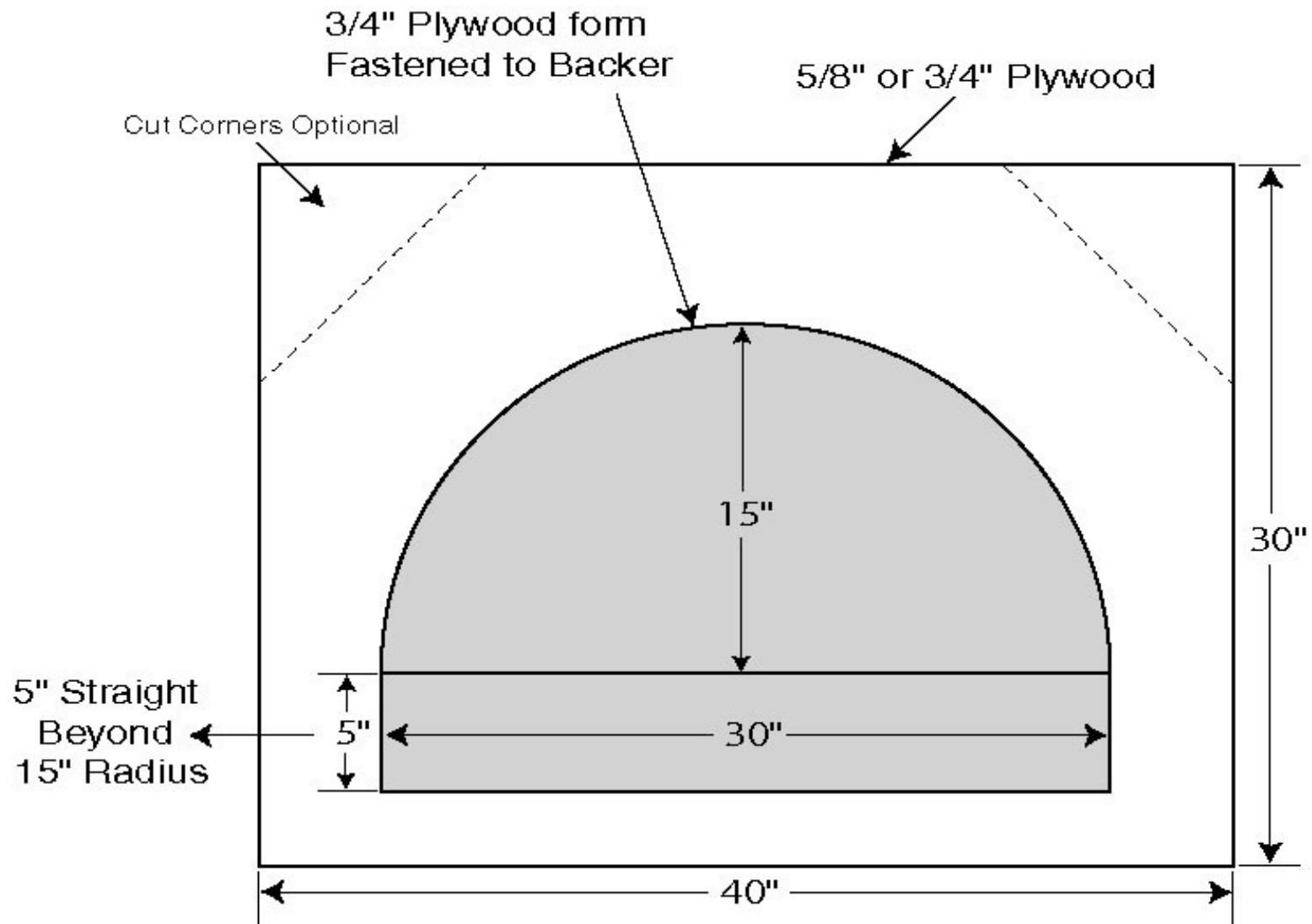
Form & Clamps



Template



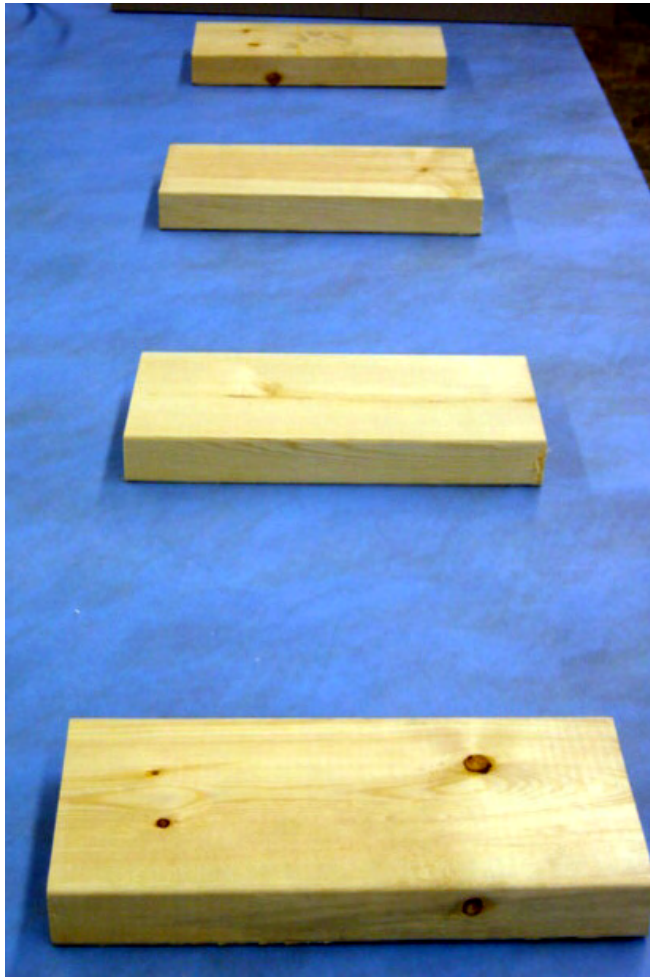
- Form dimensions



Preparing to Heat Form

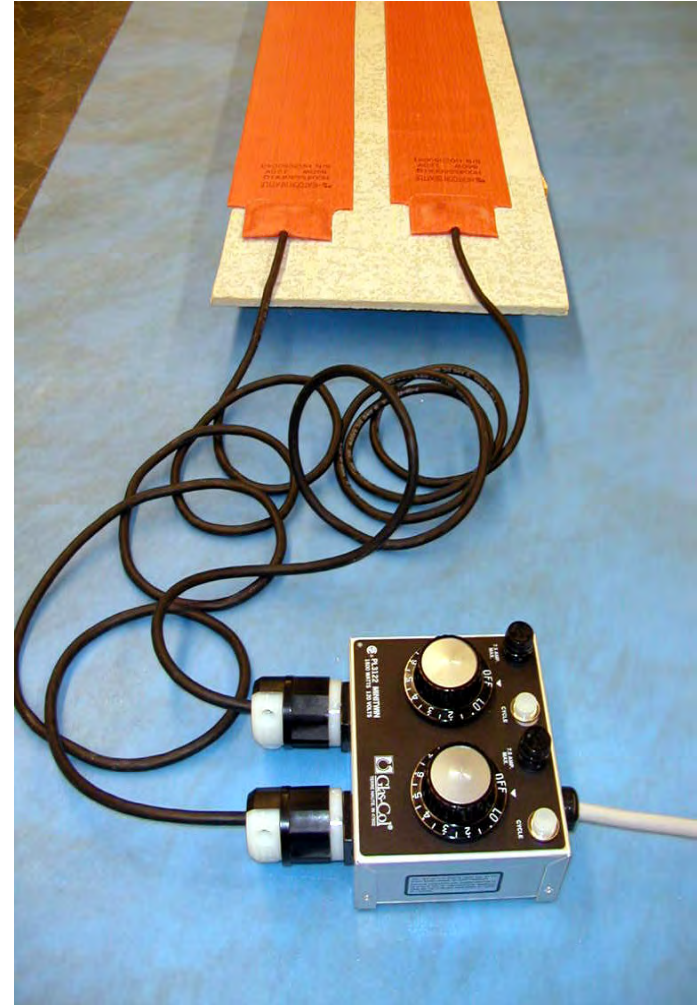


- Layout wooden blocks to support cement board (8" x 65") and to protect work surface from heat



Heat Blanket

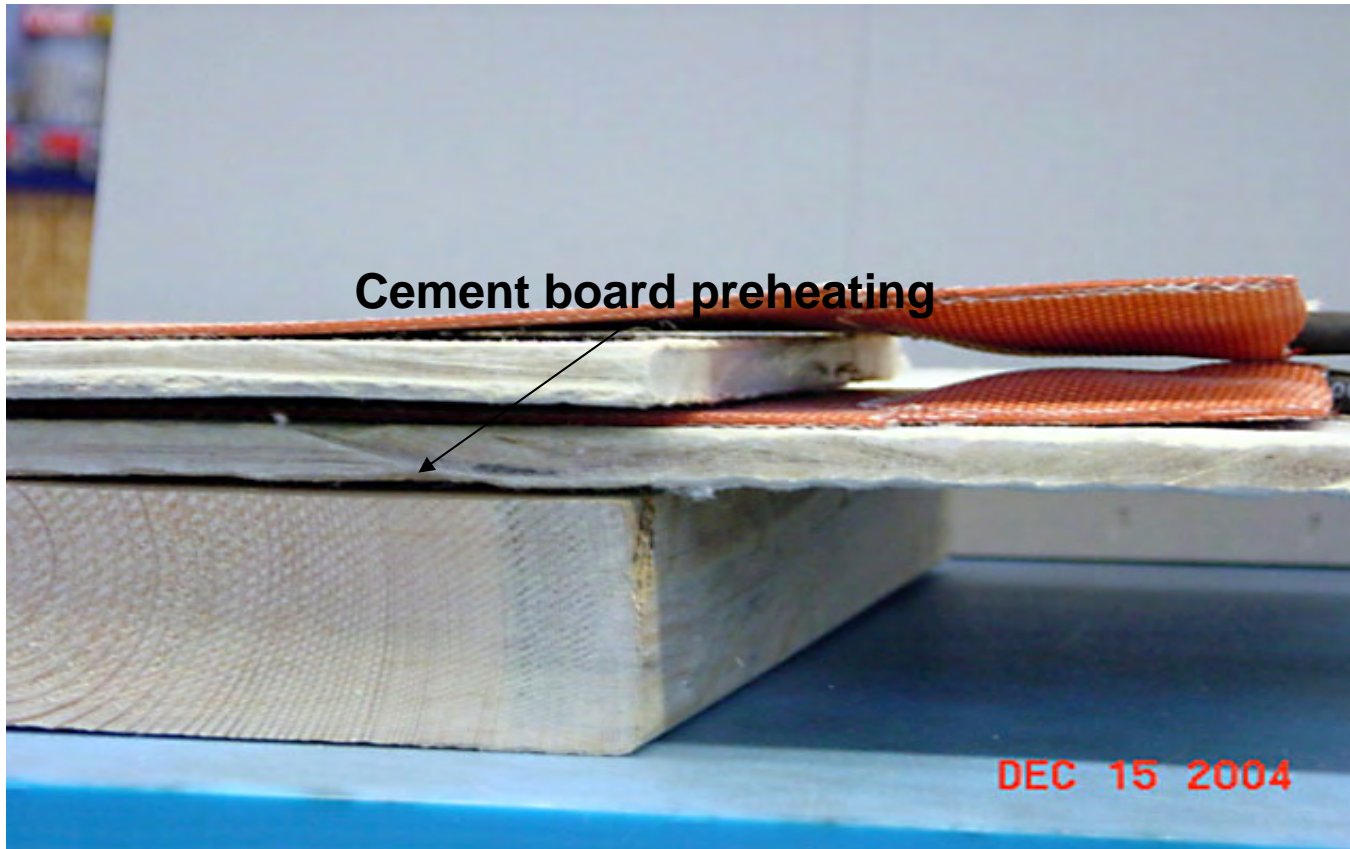
- Place heat blankets on Cement board



Preparing to Heat Form



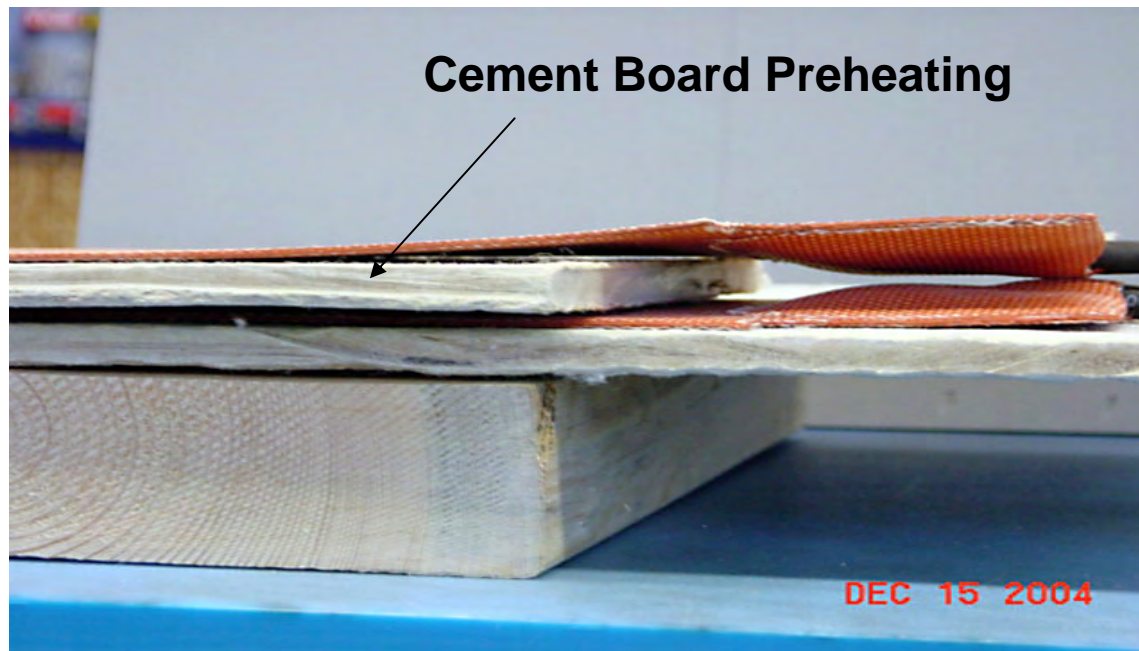
- Begin preheating
 - Place 5" x 65" cement board between blankets
 - Set Controller to High
 - Preheat for 15-20 Min.



Preparing to Heat Form



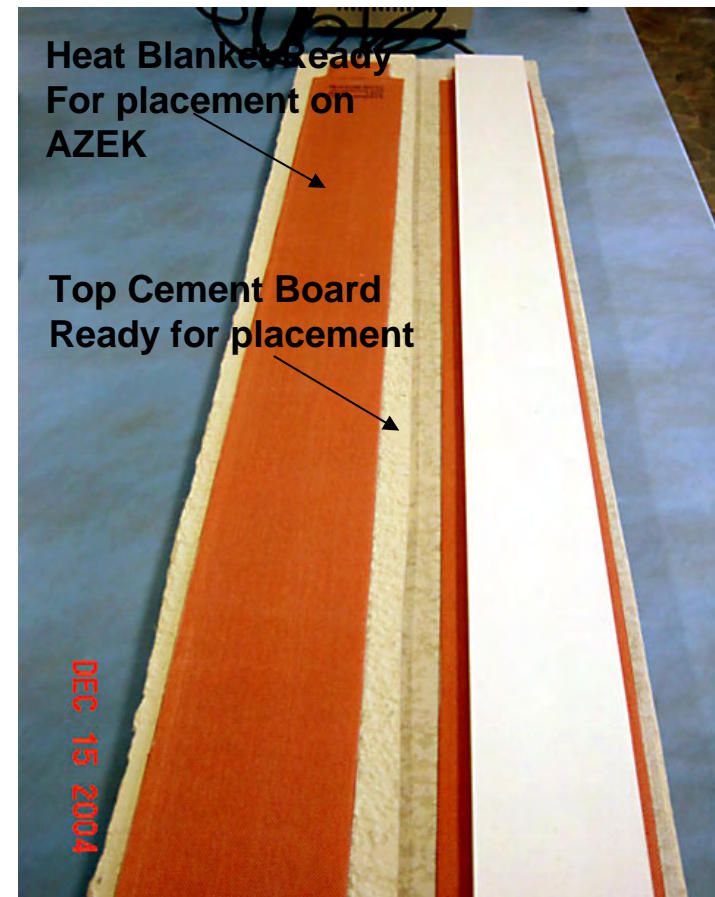
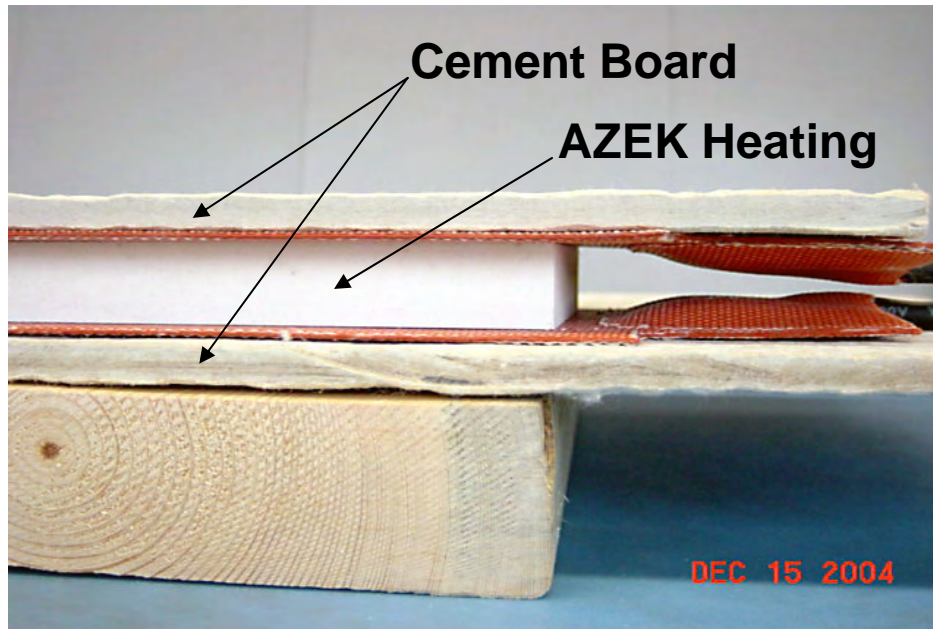
- Preheating system
 - Do not allow heated portion of blankets to come in direct contact
 - Temperature should reach about 290 -300 degrees F
 - Lower heat if forming will not begin for some time



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



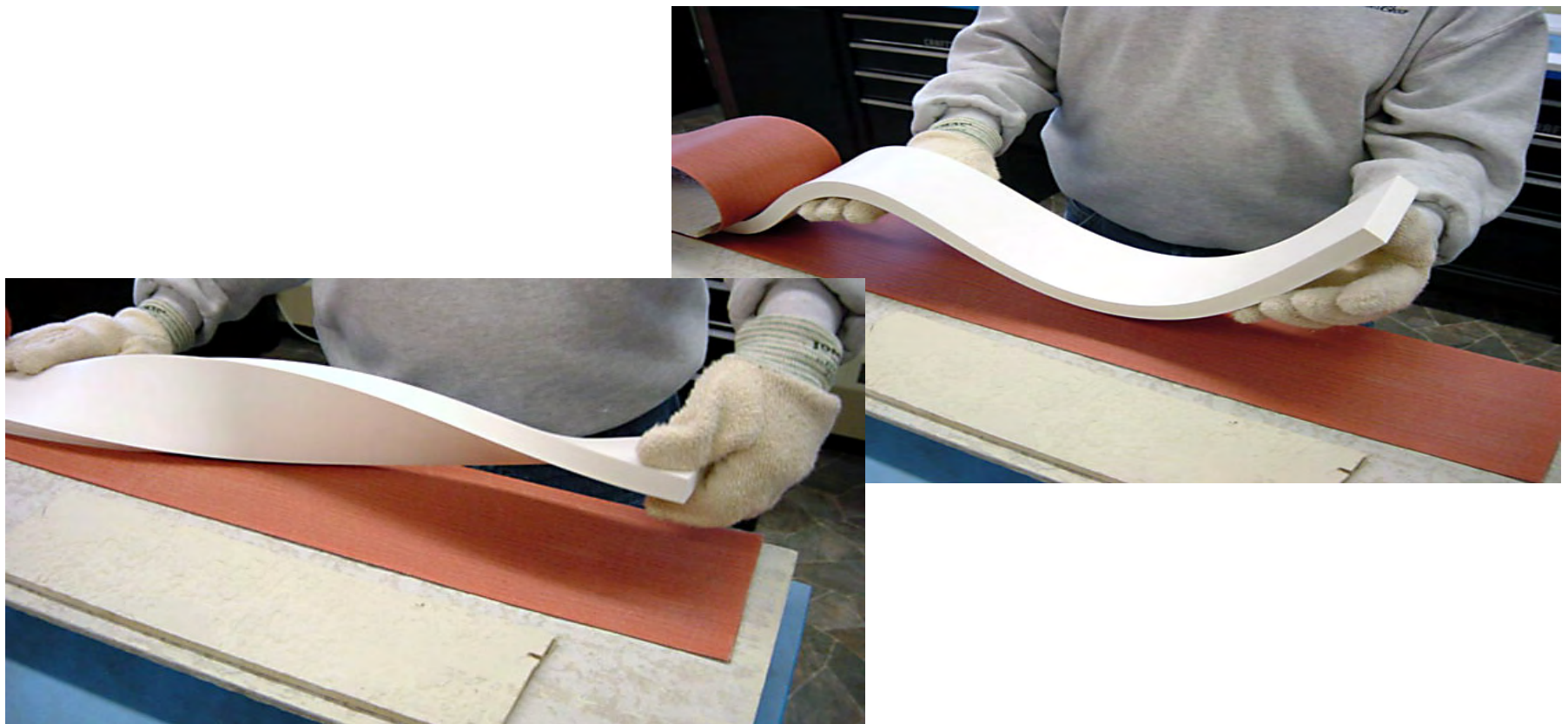
- Continue heating for 7 – 10 minutes temperature should reach about 300 F
- Periodically check temperature



Heat Forming



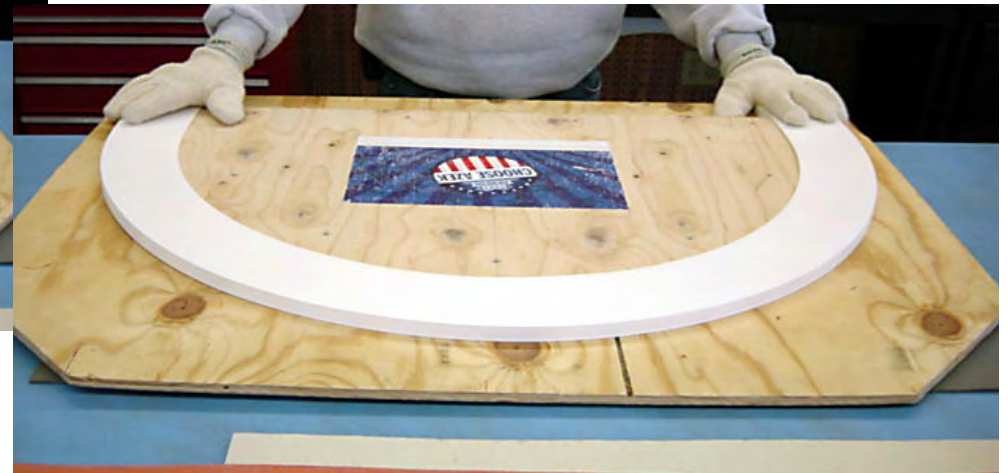
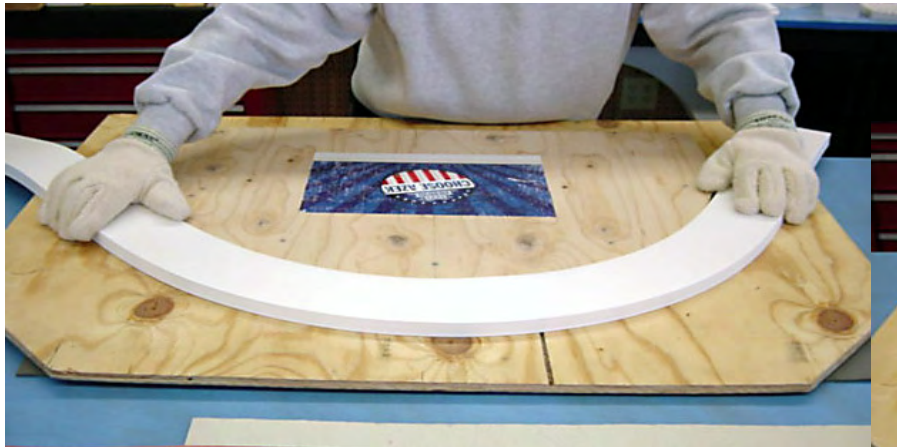
- When product is approaching final temperature check for consistency
- Consistency should be like cooked spaghetti



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