

THE PINSKE EDGE

#48109 THERMOFORMING OVEN

To assemble oven:

Set oven on saw horses or hold it elevated with a forklift. Oven should be 36" off the floor. All four legs are numbered; oven is numbered in each corner; the leg braces are numbered in the same manner. The #1 corner goes with the #1 leg and the #1 leg brace. Mount the four legs with the hex-head machine screws (5/16 x 1/2). Attach the leg braces to the legs using the 1/4-20 x 1/2 stove bolts. Once all screws are installed (finger tight), then go back and securely tighten with a wrench.

The oven requires a 50 amp breaker with a 50 amp range receptacle. Voltage is 220, Single Phase.

When you receive the oven, it will have an oil residue on the inside. Open the door and run the oven to burn off the inner residue.

Start the oven by setting the thermostat to desired temperature and turning the timer ON. For safety reasons, the oven will turn off once the timer runs out. When the oven elements are heating, the red light will be illuminated. When the oven reaches the set temperature, the light will go off.

Each solid surface material bends differently - size, color and thickness have an effect. We recommend, on 1/2" material, that you set the temperature at 275 to 280 degrees Fahrenheit. Preheat the oven for 20 minutes prior to placing any material in the oven. As previously stated, material color and thickness will make the time for thermoforming vary.

It is always best to test the various solid surface materials before working on the entire job. By testing, you will get a feel for the desired end effect. To check for the correct time, we suggest taking three pieces of the material to be thermoformed and cutting them in 1/2" x 1/2" x 24" pieces. Place all three pieces in the oven. After 15 minutes, take the first piece out and check to see how pliable it is. If you can tie a knot with the material and have no stress marks, you have reached the correct time. If the material breaks, wait five additional minutes and try the procedure again. When a knot can be tied (without breaking or any stress marks showing), you have reached the optimum time and temperature for your material. In most

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cases, 25 to 30 minutes should be sufficient time. Always check the pieces to see how they are doing.

You must use a form for bending your material. The material must be clamped securely and evenly to your form. Leave material on your form until completely cooled.

Safety Note: The oven door is very hot to touch. Always use oven gloves when handling hot material.

If you have any questions, please fax us at 320-238-2385 or call us at 320-238-2196.

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