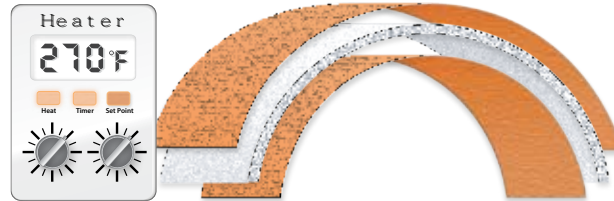


Heat Bending Guidelines



TUF Board can be easily heated and bent into a variety of shapes. More time and money is spent when constructing the same shapes from wood, wood composite, plywood, and engineered wood products. Wood products must be routed, sanded, glued, and finish coated to get the same results.

Some proper tools and equipment are required when bending TUF Board. That includes hot air circulating ovens, band heaters, heating blankets, or radiant heaters. It is all depended on the shape, area, thickness and quantity of the job to decide which equipment should be used.

Safety Warnings and Guidelines:

1. Bent material must be evenly heated.
2. We recommend heat of about 270°F, but not to exceed 320°F. If heated with band heaters or heating blankets, a lower temperature around 250 °F is recommended due to direct heat contact.
3. Heat $\frac{3}{4}$ " \times 3 $\frac{1}{2}$ " TUF Board for approx. 10 minutes in ovens, or 15 minutes if using heat blankets (approx. 3 minutes per $\frac{1}{4}$ " thick). Heating time should be adjusted according to the following conditions:
 - Thickness, width, and length of TUF Board
 - Heating equipment and its capacity
4. Once the heated TUF Board reaches workable state, flexible enough to bend, bend it to the proper mold and hold it in place with clamps for best results. Cool it down with natural air or forced air to room temperature.
5. Indications of overheating are rough surfaces, bubbling, discoloration and yellowing.
6. Always handle with care and wear heat protection gloves during the process. Refer to our material safety data sheet for material handling specifications.



INTEPLAST GROUP

WEB SITE: www.TUFboard.net

E-MAIL: TUFboard@inteplast.com

TEL: 800-452-2117 EXT 2

FAX: 800-889-8807