

Quick Reference for vacuum forming

1.



Make sure the main power is connected and the air is on.

2.



Make sure the power switch on the machine is on.

3.



A: Start the machine
- Wait until you hear the machine click.
B: Turn on the vacuum
- Make sure the vacuum builds up to the red mark.

4.



Start up as many heating element you need, depending on the size of the frame you put up.

- Small frame = heating element I and II
- Middle frame = heating element I, II and III
- Large frame = heating element I, II and III

*** Sheet sizes:**

Small frame = 250x250 mm
Middle frame = 500x500 mm
Large frame = 1000x800 mm

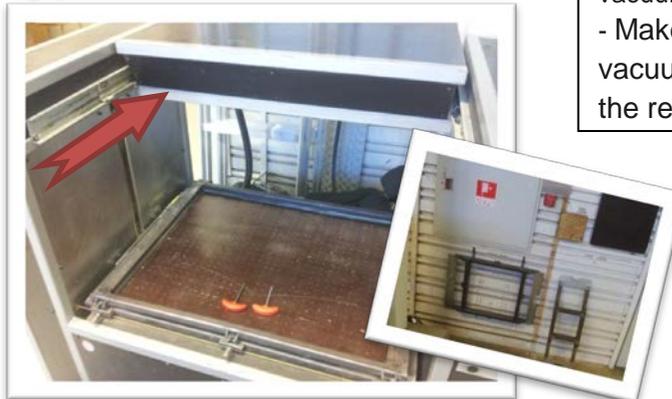
- In order for the model to come off easily from the plastic you can apply a thin layer of Vaseline.

5.



Wait for the heating elements you have chosen to reach the right temperature.

6.



Push off the upper part of the machine. **NOTE!** Ensure that there are no combustible materials behind the machine.

- * Mount the frame you want to use.
- Tighten the screws diagonally into the frame to get even pressure.

7.



Fit the plastic plate on the frame. Pull back the top and then raise the frame.
The speed of the frame can be adjusted with the knob.

8.



Place the model centered and ensure that there is adequate air holes positioned around the model.

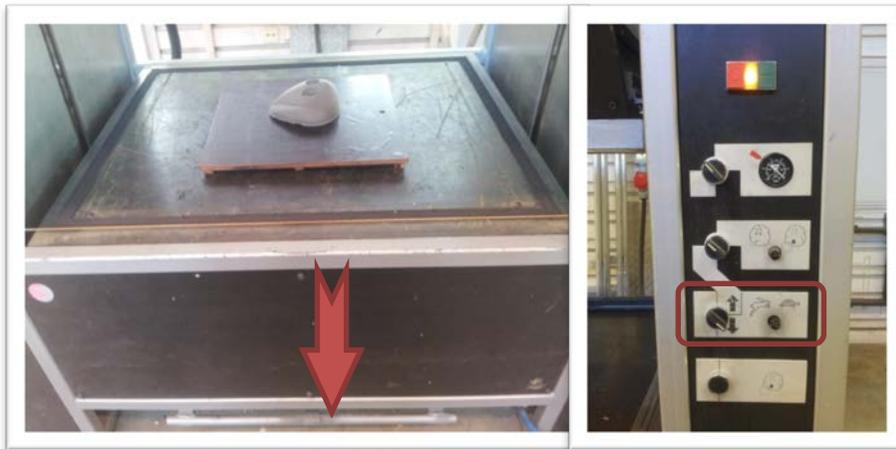
9.



Approximate temperatures for different materials:

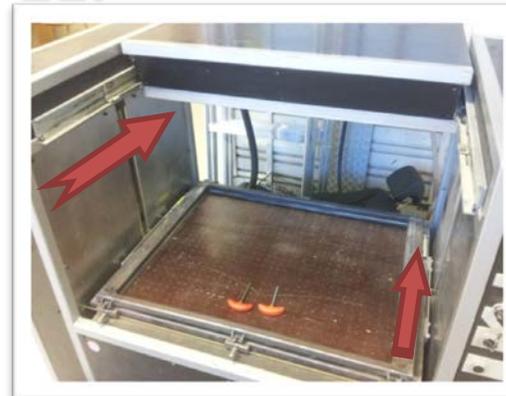
Material:	Thickness:	Elements:	IR gauge:
PMMA	3 mm	245 °C	130-135 °C
Vivak	3 mm	220 °C	105-110 °C
ABS	3 mm	230 °C	115-120 °C
PVC	1 mm	220 °C	115-120 °C
PS	1 mm	220 °C	115-120 °C

10.



When the correct temperature is reached, reduce the frame over the model. Evacuate the air by pressing down the foot pedal just when the frame reaches its lowest position.

11.



When all the air is evacuated pull off the upper part and raise the frame.
NOTE! Do not forget to pull off the upper part before the frame is raised.

**Good luck
with your
vacuum
forming!**