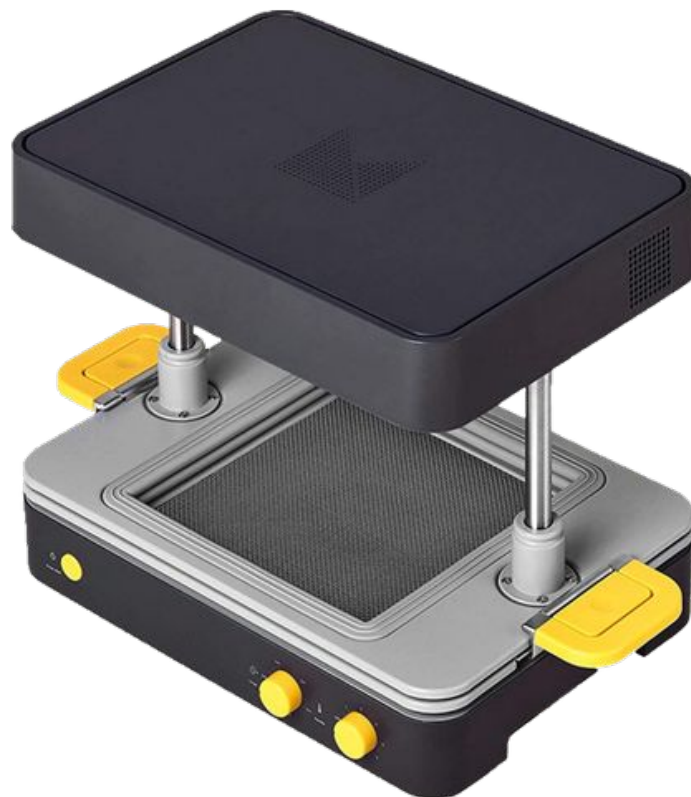


# VACUUM FORMER

**Form Box**

**Bed size 200 x 200 mm**

**Max mold size 150 x 150 mm**



# MATERIALS

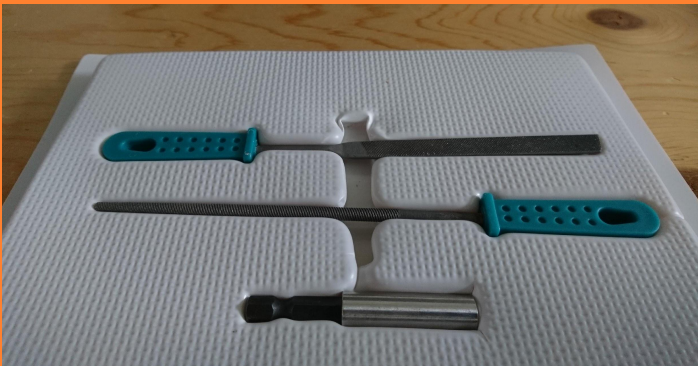
	Material	Colour
Form Sheet	HIPS	White
Cast Sheet	PETG (food safe)	Transparent

# SAFETY

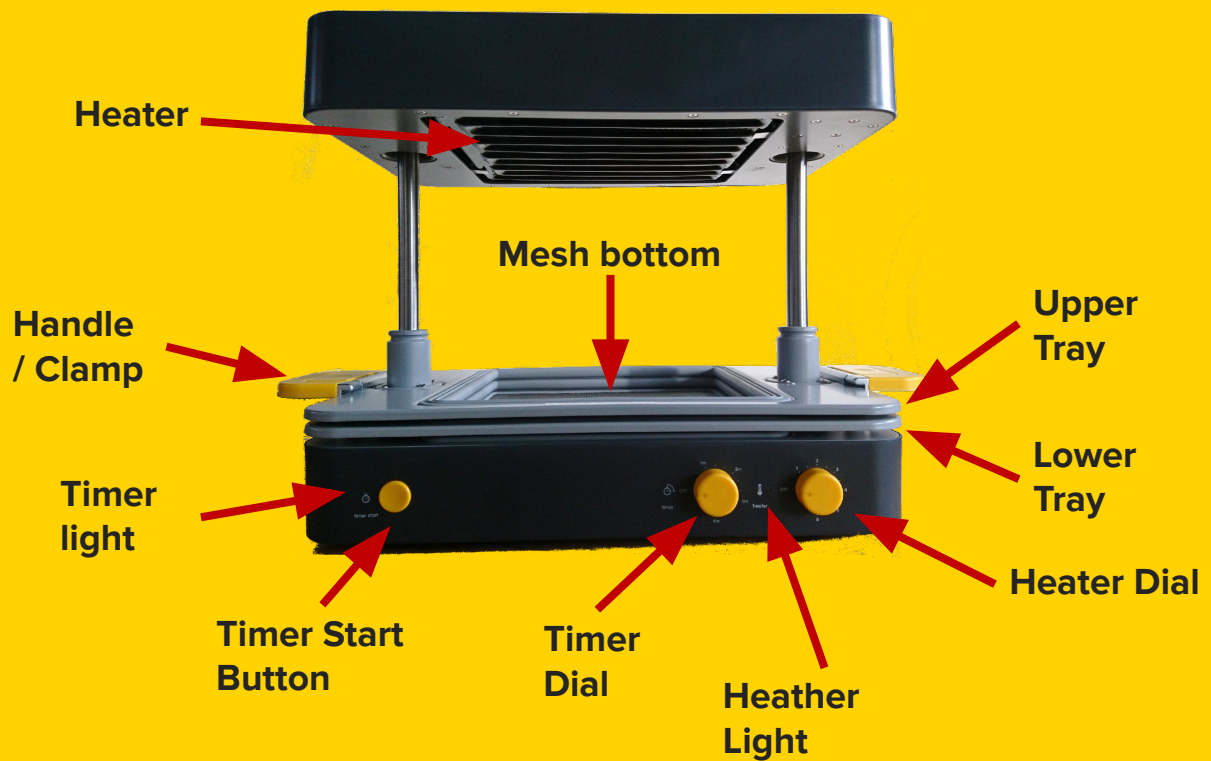
**NEVER** cover any ventilation holes.

# USAGE

quick prototyping  
molds for soap, chocolate, concrete, resin...  
form fitted packaging



# TERMS



# PREPARATION

Choose material

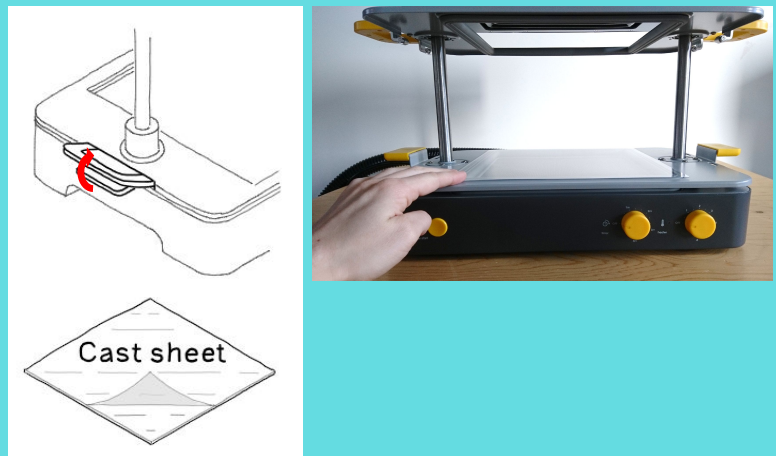
Set time and heater dials

	Temp.	Timer
Form Sheet	5	2:00 – 2:20
Cast Sheet	5	1:00 – 1:20

Unclamp and lift up upper tray

(For Cast sheet: remove film)

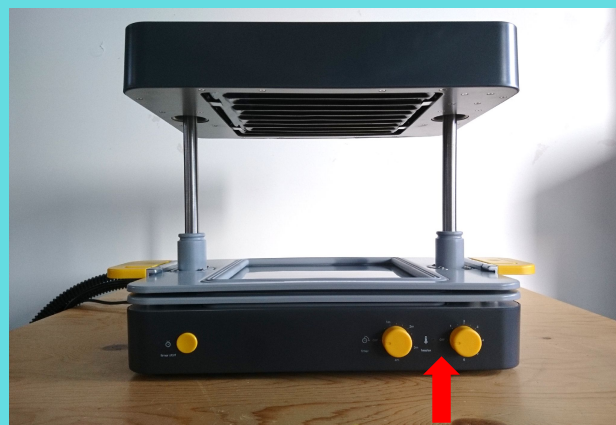
Place sheet on the lower tray



Push upper tray back down

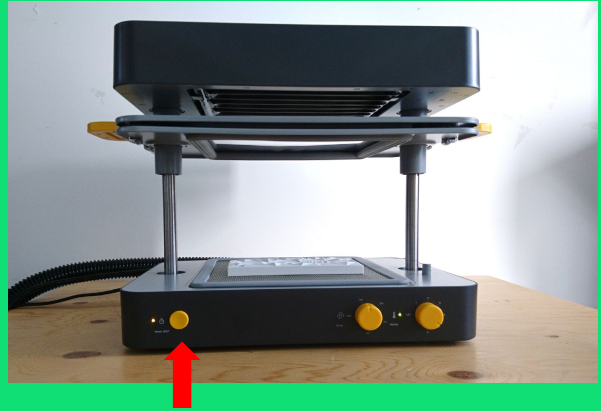
Clamp trays together

Wait for heating light to switch from blinking orange to green

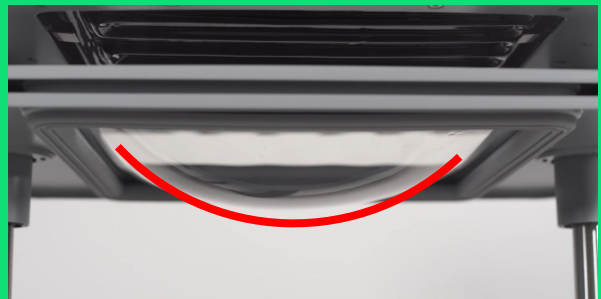


# FORMING

- Move trays up
- Start timer
- Place template in centre of mesh
- (Leave at least 3 cm between multiple objects)



- Once the ticking sound get faster, check if sheet is warm (→ it bends downwards)



- Pull down on the handles to bring both trays over the template

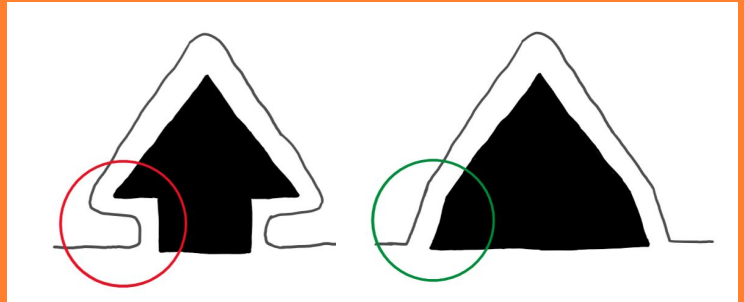
The vacuum will switch on automatically

- Wait for form to cool down
- Unclamp the forms and take out your form
- Switch off the heater dial

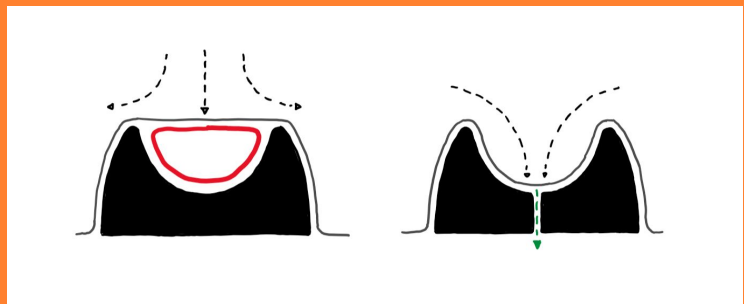
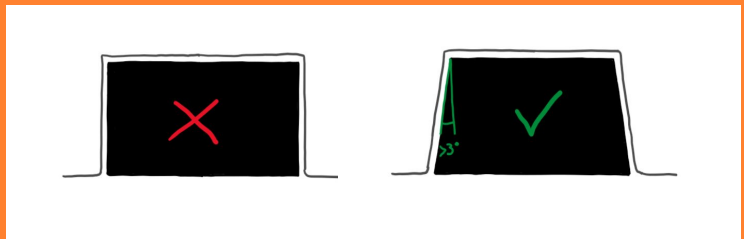


# DESIGN RULES

No undercuts, all sides need to be visible from the top.



Add draft angles ( $>3^\circ$ ), vertical walls will not work.



Avoid sharp corners (might otherwise lead to rupture or folding of the sheet).

