



## Thermoforming

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## 1. Preparation

- A. Preparing the Shape
  - Thermoforming around a Template
  - Thermoforming around a Surface
- B. Preparing the CaesarStone Material Reducing the Thickness
- C. Preparing the Heating Method



### S-Shape







### Barrel Shape





## Cylinder Shape









There are 2 factors to take into consideration when planning the application:

• the required radius



• the CaesarStone material series; the 2000 series is more flexible, whereas the 9000 and 7000 series are harder.



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There are three methods of reducing the thickness:

## Method 1 – Using a Bridge Saw

Checking that the slab is level





## Method 1 – Using a Bridge Saw (cont.)

Gradually cutting a thinner slab





## Method 1 – Using a Bridge Saw (cont.)

Cutting the first full groove



Turning the slab over





## Method 1 – Using a Bridge Saw (cont.)

Cutting the second groove





#### Method 2 – Using a CNC





## Method 3 – Using a Bridge Saw and Grinding Wheel





Grinding - the final stage





Heating the water to 78°C (172°F)





## 2. The Thermoforming Process

- A. Heating the Material with Hot Water
  - In a Bath
  - Pouring
- B. Laying the Material over the Template
- C. Securing the Material to the Template
  - Strips and Clamps
  - Ropes and Clamps
  - Belts and Clamps







## Heating the Material with Hot Water - Pouring









## Laying the Material over the Template



















## 3. Completing the Application

#### A. Cooling

- B. Gluing and Clamping the Material
  - ...to the Surface
  - ...to the Template
- C. Attaching Supports
- D. Polishing

## Cooling



#### Once the material has taken on its new shape:

- Allow the material to cool down naturally with the clamps in place. This takes a few minutes.
- Loosen the clamps and leave them in place.
- Move the thermoformed piece away from the surface.
- Clean the surface with alcohol on a clean, white cloth.













## Attaching Supports





## Polishing

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Shape and polish the edges with diamond hand polishing pads or with a diamond polishing machine. Start with the coarsest polishing pad and switch to finer pads.





Polished, thermoformed edge.











































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