

Thermoforming of STONIA® Solid Surfaces

One of the many availabilities with STONIA Solid Surfaces is that it can be thermoformed to create a variety of different shapes to meet your needs. Thermoforming is the process of heating and bending flat sections of STONIA sheets to create curved tops and down stands. This process involves placing STONIA materials into an industrial oven, designed specifically for this purpose, at a temperatures generally between 145~ 152°C. The formability of STONIA allows the material to be crafted in to sculptures, artistic vanities, innovative furniture, and various other interior applications where curves and shapes are desired. Thermoforming is a learned technique that requires practice and experience in order to achieve optimal results. Oven preparation and calibration is the most crucial skill in thermoforming – Heating temperature and dwell time will vary depending upon the thickness and color group of STONIA products to be formed. Recommended oven temperature / dwell time and minimum radius allowances are listed below.

Sheet Thicknees	Recommended OvenTemp'/Time	Recommended OvenTemp'/Time	ColorGroup
6mm	165°C / 25~55 min	27 mm	Unicolor,
		105 mm	Small, medium Chip
12mm	165°C / 40~70 min	75 mm	Unicolor,
		125 mm	Small, medium Chip
		200 mm	Pearl

Temperature and dwell time may vary depending on oven design and the size of the piece to be formed. It is highly recommended to test a scrap piece to find the best temperature/dwell time for the oven. STONIA does not express or imply any warranty or suitability of equipment that may be used in the thermoforming process.

Titan,Home color group are not recommended for thermoforming due to its unique properties.

Failure to comply with the above recommendations may result in popped chips or cracks.

STONIA does not warrant the condition of STONIA Solid Surfaces while being thermoformed or such material that is unsuccessfully thermoformed. However, when the material is successfully thermoformed and subsequently incorporated into a finished assembly, it carries the same warranty as other STONIA Solid Surface products. If you have any questions, please contact our technical team.