



PAN FORMED FACE INFORMATION

Standard molds:

Our pan molds are made using a metal framing system. The frames can be adjusted in 1/2" increments. The minimum size is 12". The maximum size without using a mold seam is 8' x 16' trim size. ANY FACE OVER 8' x 16' WILL NEED A MOLD SEAM.

Our standard pan depth is 2.25"

We have standard corners to fit CABINETS with 6", 8", 9", 10" & 12" radius corners.

Mold Top (Copy Area) Calculation:

Cabinet size - [(Flange + draft) x 2] = mold top

For example; 4' x 8' cabinet with a 1.5" retainer:

$$4' - [(2" + 1.375) \times 2] = \text{mold top}$$

$$4' - (3.375 \times 2) = \text{mold top}$$

$$4' - 6.75 = 3' 5.25"$$

Embossed letters & shapes (dies):

Our standard letters are embossed with a 7 degree bevel to allow the plastic to release from the dies. Embossing should be kept 1" away from the mold top edges.

Standard letters are embossed 1/2" deep.

4" to 5" letters are embossed 1/4" deep.

Letters under 3" are not embossed.

Note: Any letter that has details that are less than 1/2" in width will need to be embossed using 1/4" wood with a straight cutting bit.

Pay attention to the letter sizes, strokes & spacing. These can all affect what depth the embossing will be or even if the letter can be embossed.

Spacing:

1/2" deep embossing requires a 3/8" minimum space for the beveled blade.

1/4" deep embossing requires a 1/4" minimum space.