Bend the sides

Goal: thickness, bend, and fit the two sides in the pineapple mold with the hot pipe.

Class: 1.5 hr | **Home:** about 1.5 hr | Buddy work



The bending iron — work the wood slowly over the hot surface.

RESULT

Bent sides held to shape in the mold.

STOP & ASK

- Before the first real side goes onto the hot pipe
- If the wood scorches or kinks
- Before trimming either side to final length

HOMEWORK

- Keep bent sides supported in the mold
- Label every side: inside/outside, head/tail
- Update final side thicknesses
- Preview the rim assembly on the full-size plan

RECORD

Final side thicknesses; any scorch or kink notes and how they were corrected.

BEFORE THE DEMO

- Confirm final side thickness: .065–.080 in (1.65–2.03 mm).
- Sand sides to 180 grit; mark center, head, tail, inside, and outside.
- Practice the bending motion on scrap first.

Heat — targets

Iron surface **350–400°F (175–200°C)** for most woods (dial ~6). Allow **45–60 minutes** to reach temperature; check with a surface thermometer on the aluminum — laser guns read poorly off aluminum. **Spritz the wood lightly only** — both khaya and koa, never soak. Keep the wood moving, about **3–4 minutes per curve**; don't park in one spot or it will scorch. Hold the finished curve ~15 seconds and slightly over-bend — the wood springs back.

WORK SEQUENCE

1. **Prepare the sides.** Thickness, sand to 180 grit, and cut the side profile. Leave 1/32–1/16 in (0.8–1.6 mm) extra width for final fitting.
2. **Bend gradually.** Practice on scrap, work a broad area on the hot pipe at 350–400°F with light, even pressure, and check the mold often.
3. **Rest in the mold.** Leave each side supported until completely cool to room temperature.