Bend the sides — jig method

Goal: thickness, bend, and fit the two sides in the pineapple mold using the side-bending jig.

Class: 1.5 hr | **Home:** about 1 hr | Buddy work



The side-bending jig — stack draped over the form, shoes on the dowel, crossbar clamped.

RESULT

Bent sides held to shape in the mold.

STOP & ASK

- Before powering the blanket
- If the wood scorches, kinks, or resists
- Before trimming to final length

SAFETY

Blanket burns — don't touch powered, unplug when done. Water away from blanket/cord. Slats are spring steel under tension.

HOMEWORK

- Bend the second side
- Label: inside/outside, head/tail
- Log thicknesses and wood temp/time

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, outside.
- Review the **side-bending jig** page — know the parts by name.

Heat — targets

Start bending when steam shows, around **240–275°F**. Finish the bend at **300–325°F**; **khaya (mahogany) up to 350°F** to set it. Then turn down to **250–275°F and cook 10–15 minutes**. Controller reads **blanket temperature only** — read wood temperature on a meat thermometer between blanket and wood. **Spritz lightly only** — both khaya and koa, never soak.

WORK SEQUENCE

1. **Clamp the base** to the bench so the form cannot walk.
2. **Lay up the stack:** slat, side wood, slat — blanket beneath the wood. (Koa: parchment before foil.)
3. **Drape over the form,** centered. Let slat and blanket ends hang clear — intentional.
4. **Initial clamping:** crossbar down; shoes on the dowel to pressure points, snug, don't force.
5. **Heat to target:** steam (~240–275°F), bend at 300–325°F (khaya to 350°F), cook 10–15 min at 250–275°F.
6. **Complete the bend:** both roller clamps on, work the wood around the form.
7. **Cool in the jig.** Power off; leave clamped until cool to room temp (overnight best), then fit and trim.