

FLIXwall

# STEP BY STEP INSTRUCTIONS FOR PRODUCT DEVELOPMENT

You will need to buy:

1. PET( Polyethylene terephthalate)  
of 4mm and 2mm thickness



2. Rivets - dome headed



3. Screw washer

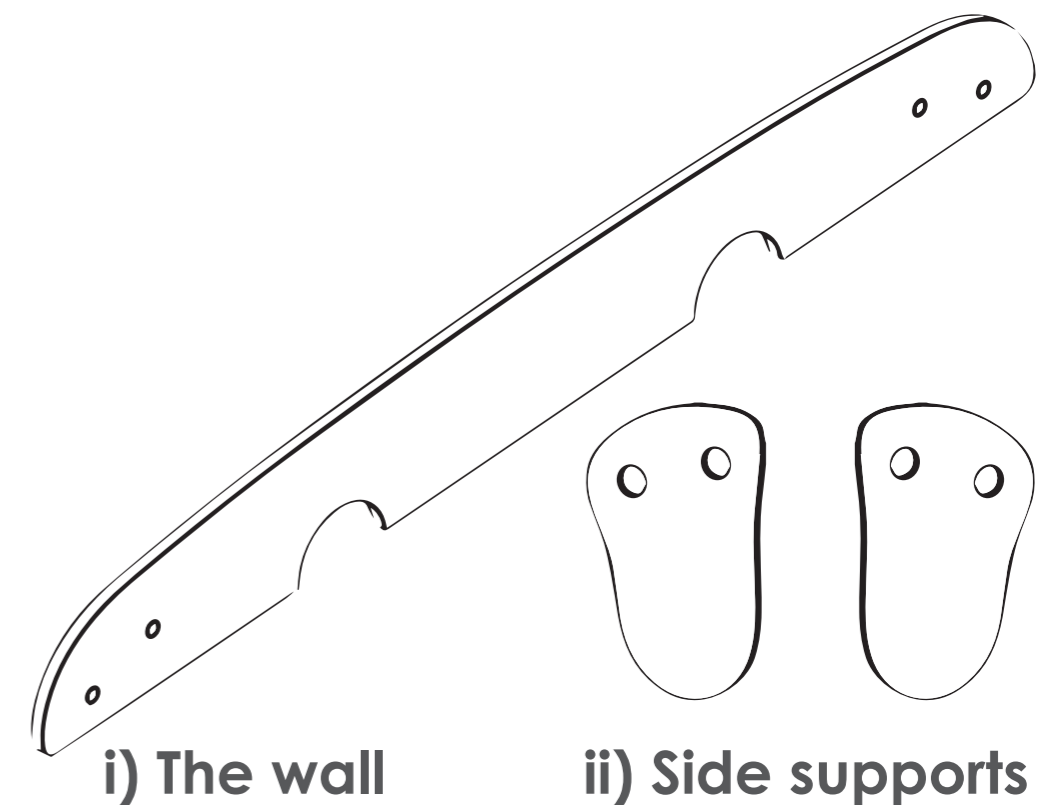


# 1

## MAKING OF THE PARTS

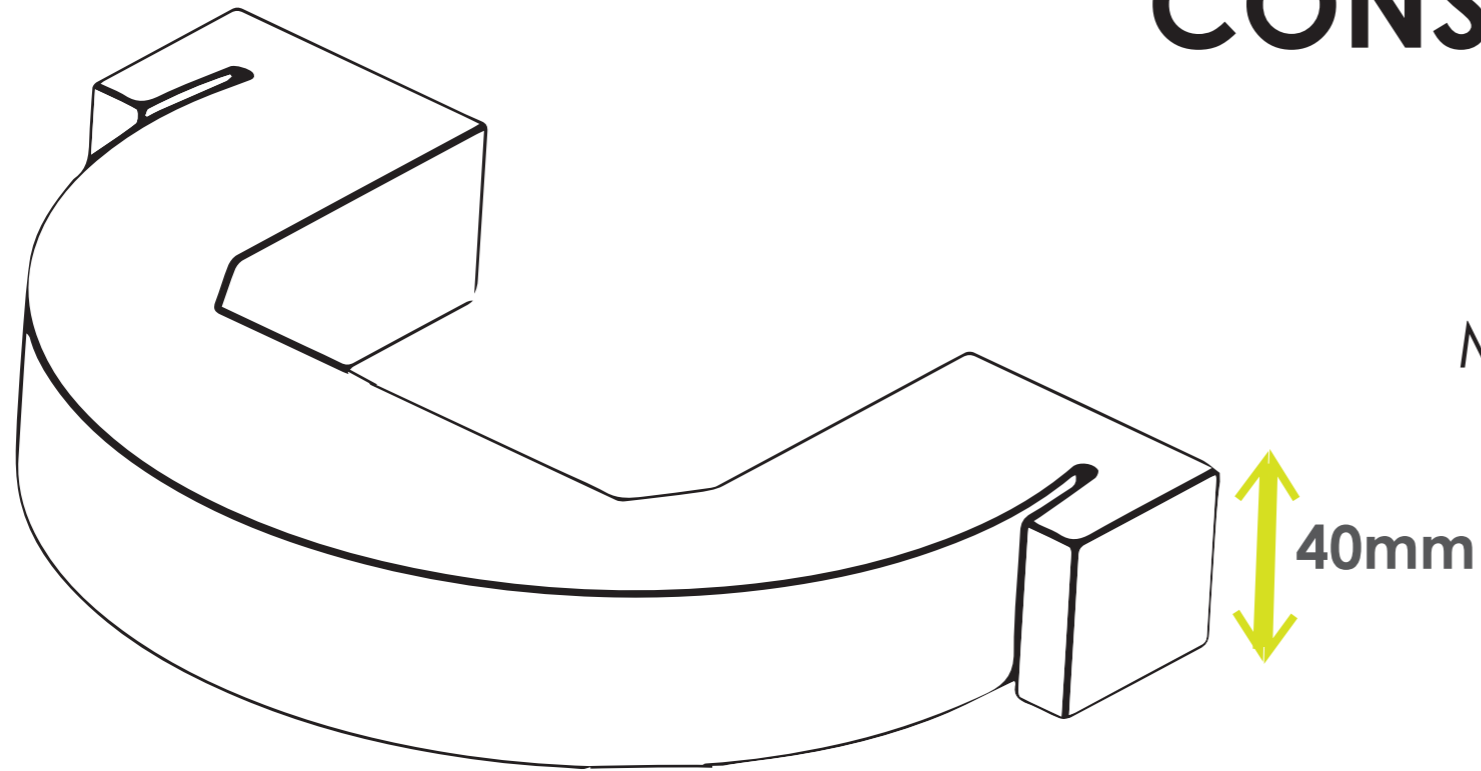
By Laser Cutting

- i) The Wall - from 4mm PET - follow wall.dxf file
- ii) Side Supports - from 4mm PET - follow supports.dxf file



# CONSTRUCTION OF MOLD

# 2

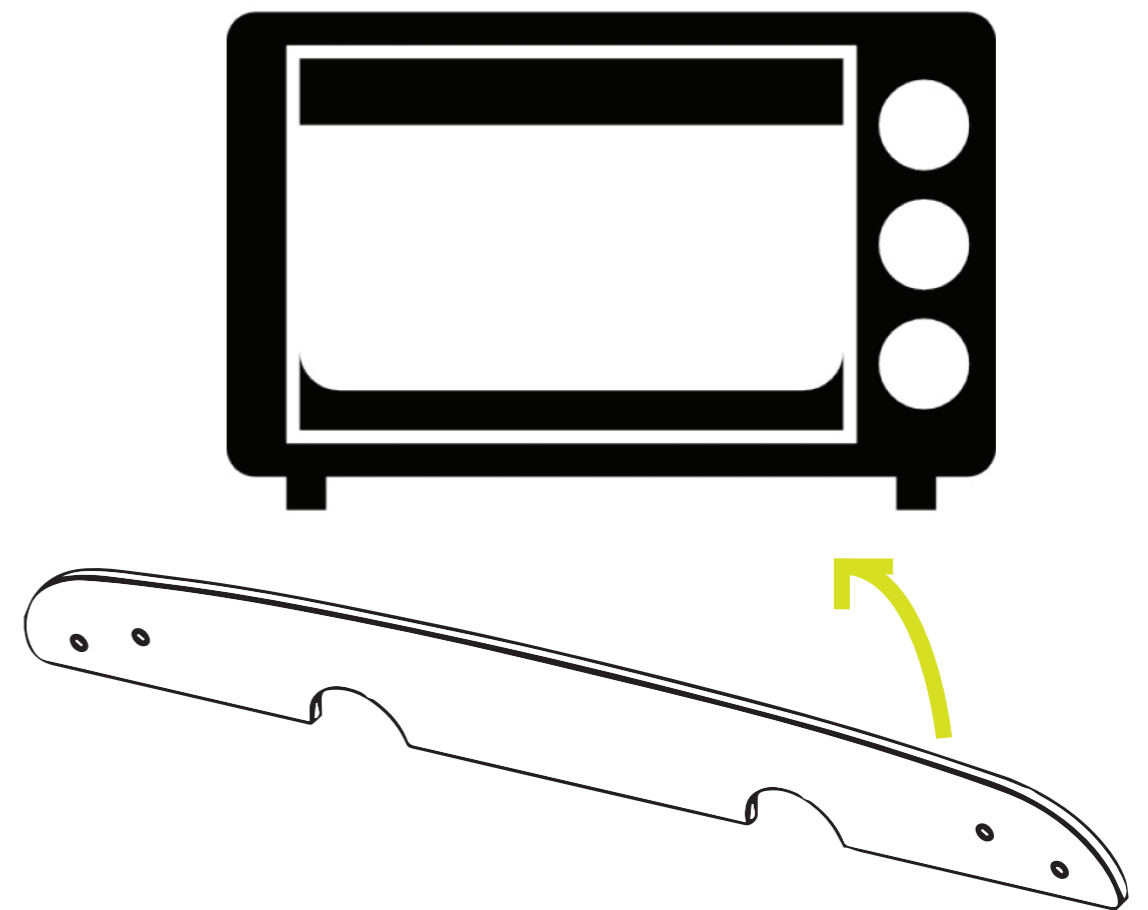


Make two molds of 40 mm height for the wall and the side supports from WOOD or MDF by following the mold for wall.pdf file and mold jig 1.pdf file.

# 3

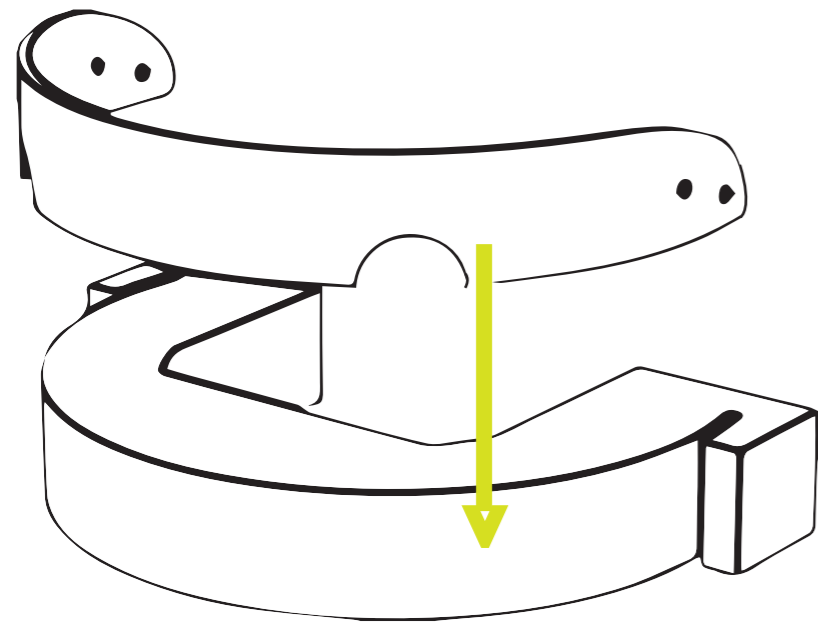
## HEATING THE WALL

Preheat your oven at 250 degrees for 5 minutes. Put the PET wall part into the oven at 300 degrees and let it heat for 2 minutes .



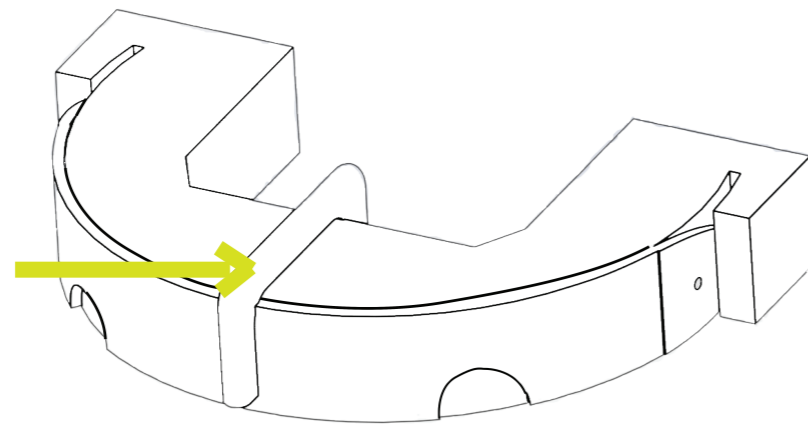
# 4

## ATTACHMENT TO THE MOLD



After 2 minutes, take out the wall from the oven and attach to the mold with clamps for 15 minutes to get a concave shape

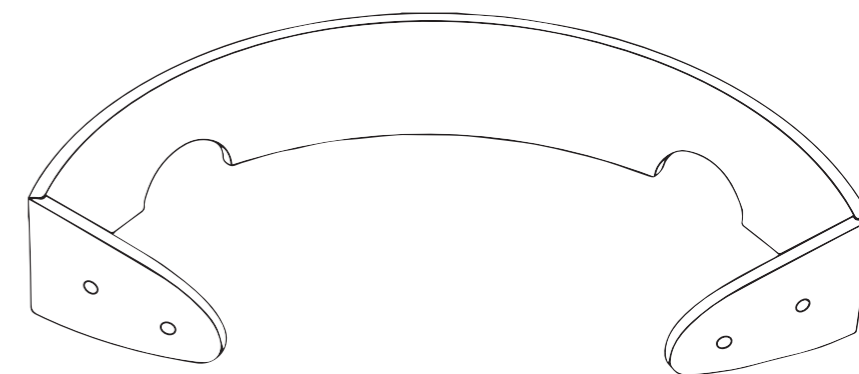
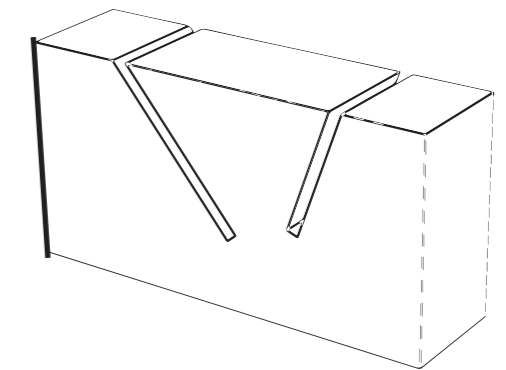
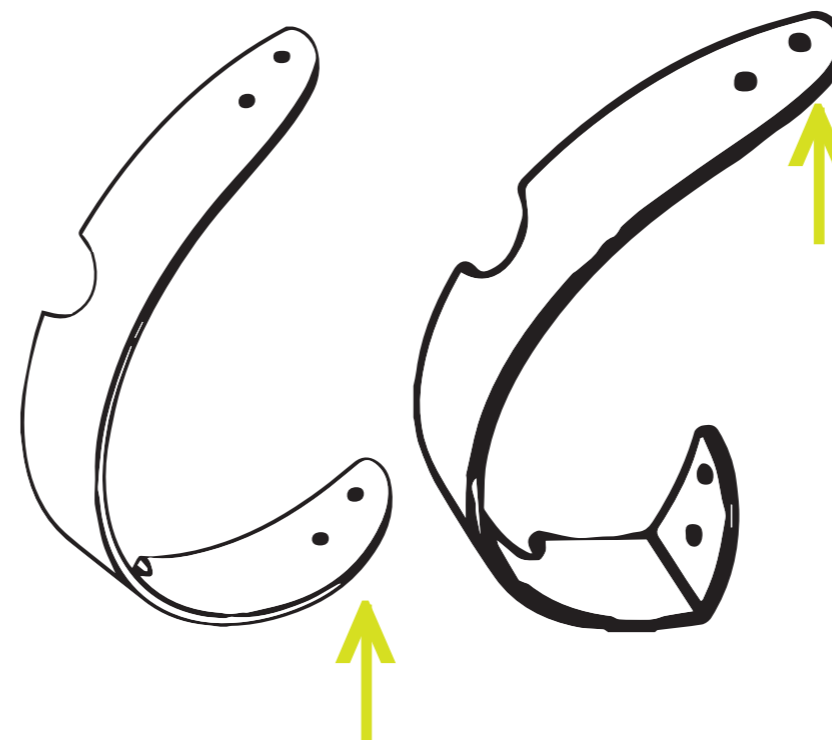
clamp it here



# 5

## BENDING THE SIDES of the wall

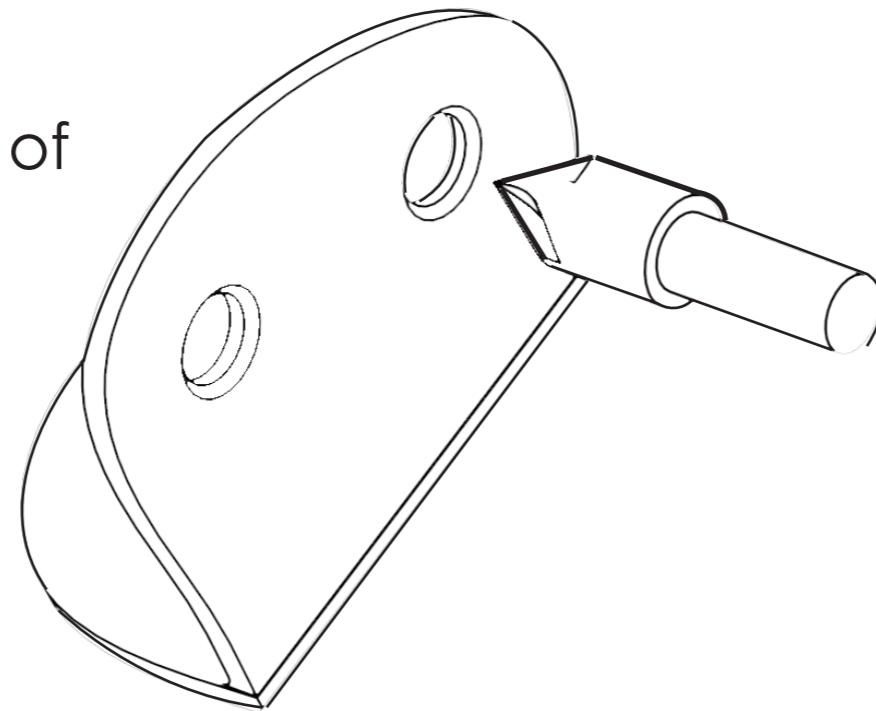
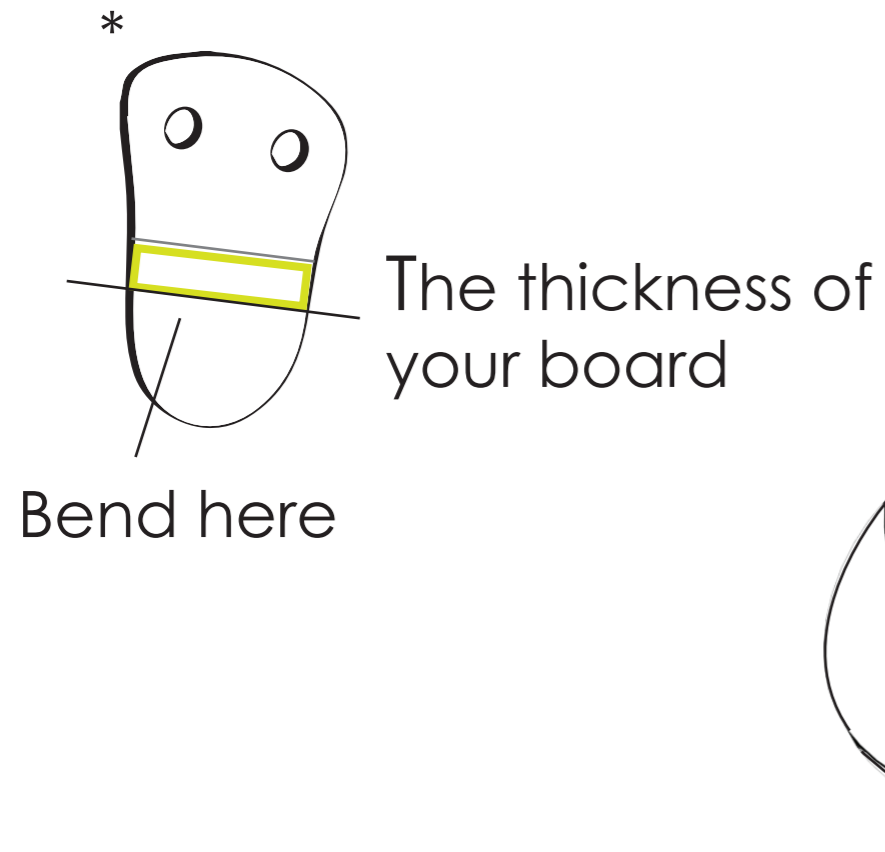
Bend both the sides of the wall at an angle of 50( use mold jig 2.pdf file) degrees along the dotted lines by placing it on a Plastic Bending Heater (Hot Heating Bender)



# COUNTERSINKING

6

Using COUNTERSINKS for the holes of the side supports before bending them

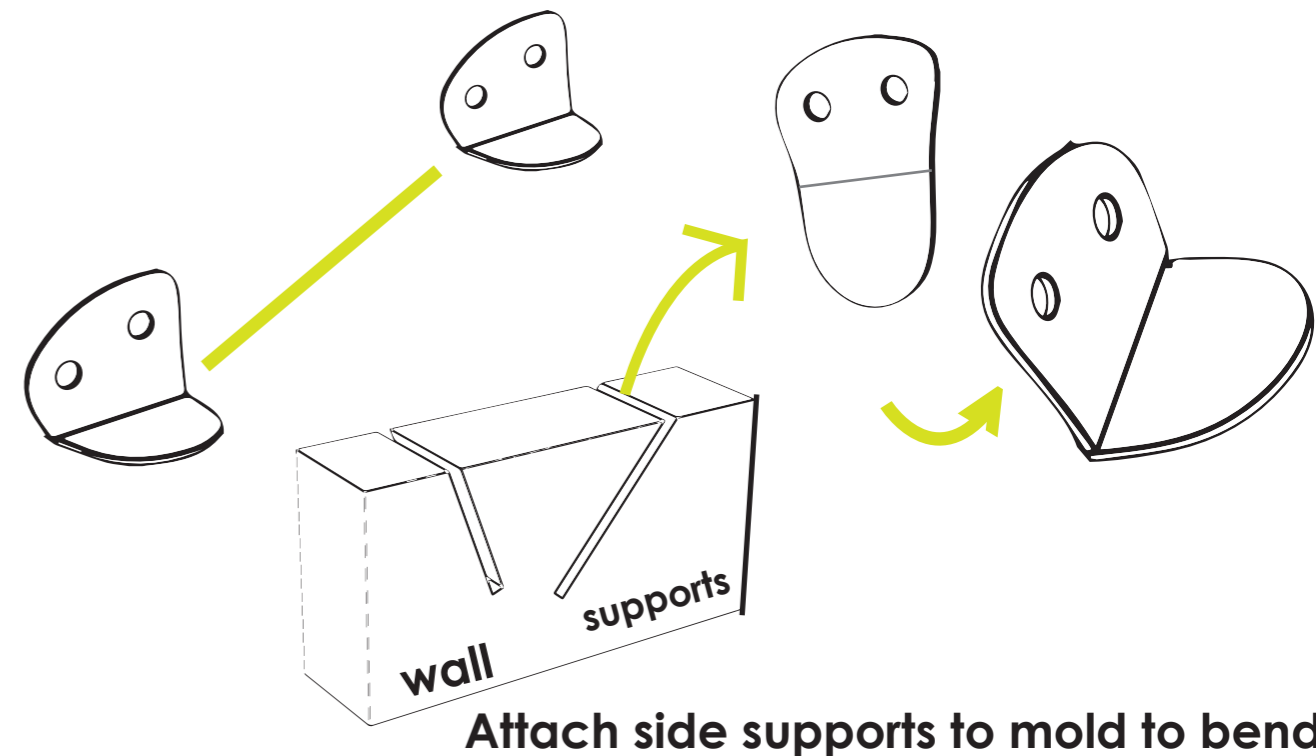


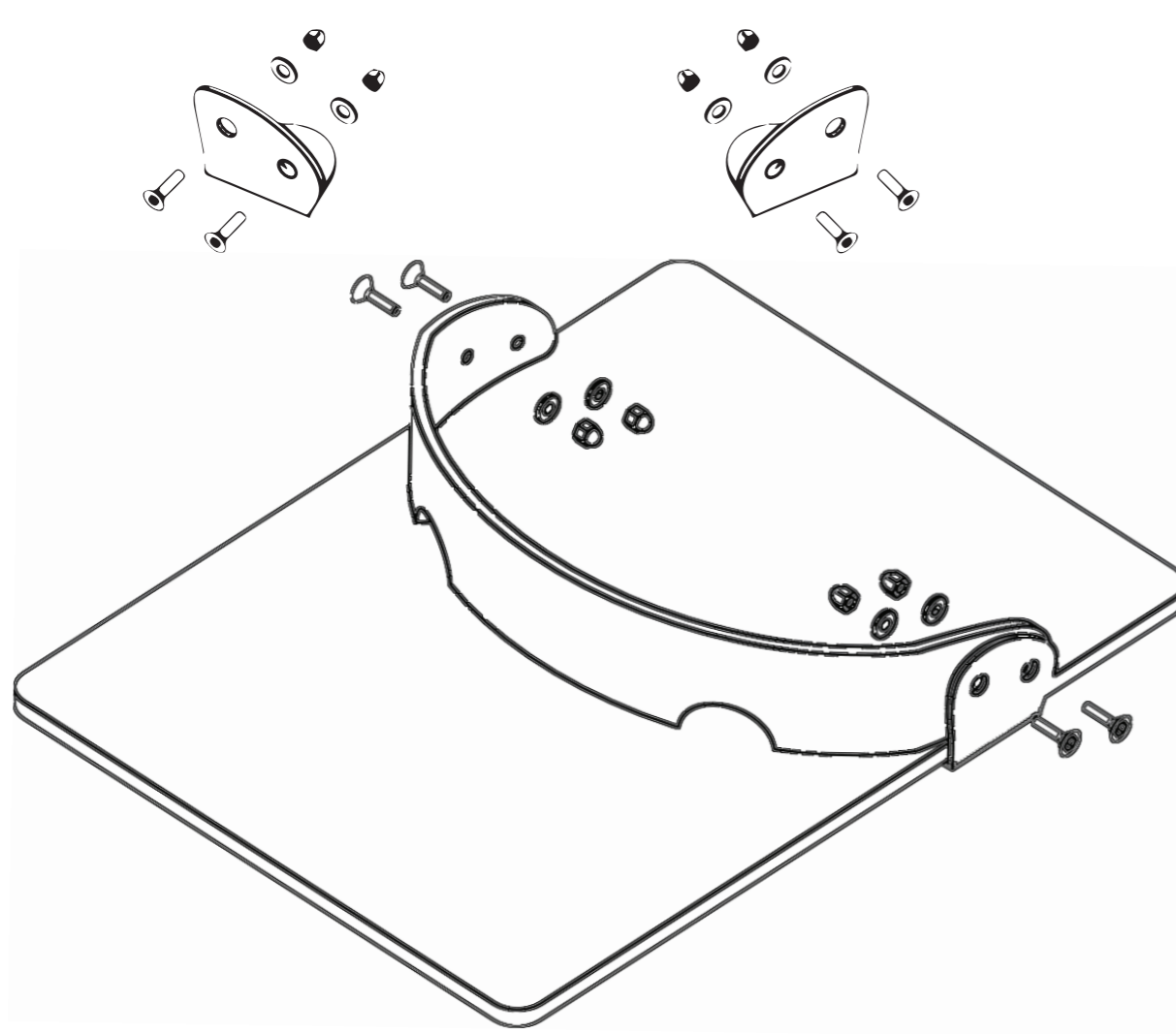
7

# BENDING THE SUPPORTS

Bend both the side supports at an angle of 110 degrees (use mold jig 2.pdf file) along the dotted lines by placing it on a Plastic Bending Heater (Hot Heating Bender)

\*Measure the thickness of your board and bend it in the right place





## ASSEMBLING of all parts

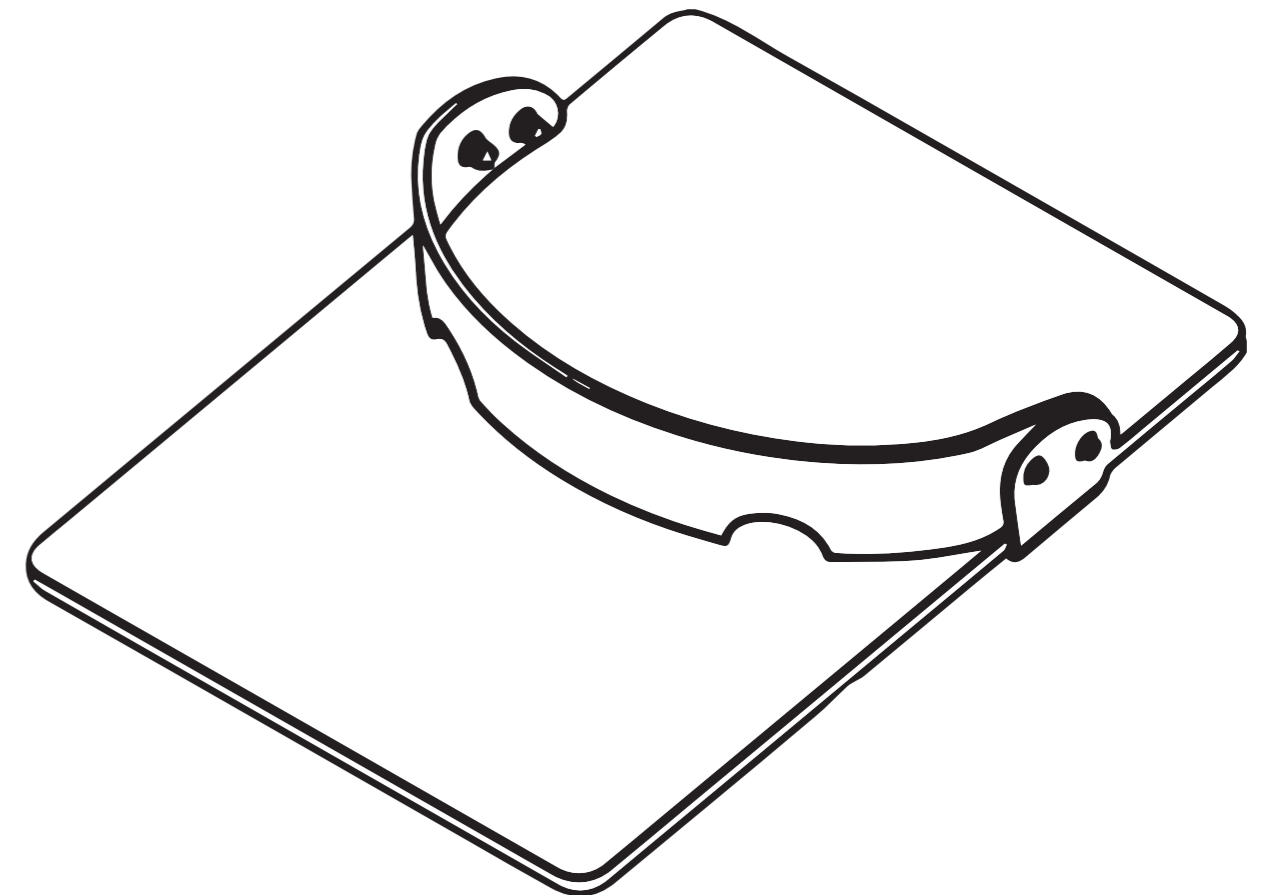
8

Assemble all the parts by riveting all the screwsthrough the holes on the wall and tighten them.





9

## YOUR PRODUCT IS READY

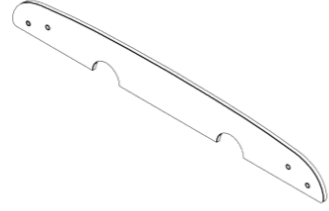





All assembled to form the final product



# TOOL CHART

NO. (T=Tool)	Tool name	Pic	Info
T1	Allen screwdriver/ Allen key		No/2.5
T2	Wrench		No/7
T3	Oven stove	N/S	Up to 300 C° or 572 °F
T4	Heat bending line		Up to 300 C° or 572 °F
T5	Countersink drill bit		Size 3/8

# BILL OF MATERIAL

Part No.	Part name	Pic	Production technology	File name	Martial	Info	Quantity	Supplier
1	Wall		Leaser cutting	Wall	PET	4mm 5/32"	1	Fridenzon LTD
2	Side holder		Leaser cutting	Side	PET	2mm 5/64"	2	Fridenzon LTD
3	Leg		Leaser cutting	Leg	PET	2mm X 30mm ø 5/64" x 1 3/16"ø	2	Fridenzon LTD
4	Allen flat head countersink screw		N/S	-	ss steel 316	4MX11 5/32"x7/16"	4	Galboreg LTD
5	Washer		N/S	-	ss steel 316	4M 5/32"	4	Galboreg LTD
6	Dome nut		N/S	-	ss steel 316	4M 5/32"	4	Galboreg LTD