



Any fabrication procedure or technique not contained within the Wilsonart® Solid Surface Fabrication Manual will not be recognized by Wilsonart, LLC as an approved method of fabrication. Deviations from these techniques must be approved in writing by a Wilsonart Representative.



General Safety:

Safety is a critical concern for any shop and key to a successful business. The following safety rules should be incorporated into your safety program to help prevent an accident. Safety training, knowledge, product use and environment are the responsibility of the facility owner and the shop employees.

CAUTION: Always follow product, equipment and/or tool manufacturer's recommendations and instructions carefully.

- Read directions carefully before fabricating/installing Wilsonart® Solid Surface.
- Read and follow the instruction manual before operating the different tools.
- Keep all guards in place and in working order.
- Ensure all tools are properly grounded. Never remove the third prong.
- Keep work area clean, uncluttered and well lit.
- Don't use electric power tools in a damp or wet work area.
- Keep visitors at a safe distance from the work area.
- Use the right tools. Don't force a tool or attachment to do a job it was not designed to perform.
- Always use safety glasses or approved eye protection and/or face shield, ear/noise protectors and safety shoes. (FIG. 4A & 4B)
- Wear the proper apparel, no loose clothing or jewelry.
- Secure all work with the proper clamp or vise to a stable work surface.
- Don't overreach. Keep proper footing and balance at all times.
- Maintain tools in top condition. Disconnect tools before servicing and when changing accessories such as blades, bits, cutters, etc.
- Keep and use denatured alcohol, adhesives and materials in a safe, ventilated place.
- Dust collection should be used when cutting, routing and sanding. Tools should be used with dust collection at all times.



Figure 4A



Figure 4B

Wilsonart® Hard Surface Adhesive:

- Wilsonart® Hard Surface Adhesive is for professional use only. Always follow the manufacturer's recommendations and instructions carefully. (FIG. 5A)
- Warning: This seam kit contains the following hazardous ingredients: Methyl Methacrylate, Benzoyl Peroxide, and Dibutyl Pathlate. Avoid prolonged breathing of vapors. Use only in a well ventilated area. Keep out of reach of children. Eye protection is always recommended. Motors and other equipment used in the fabrication and installation process must be UL labeled explosion proof.
- For further information refer to Wilsonart® Hard Surface Adhesive Material Safety Data Sheet available on request. Contact your local distributor or call 1-800-433-3222 for immediate response.

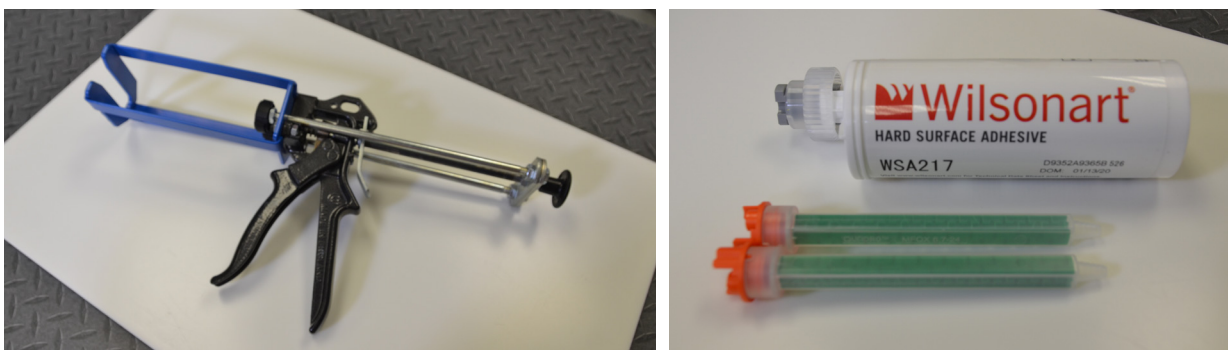


Figure 5A

FAB TIP:

- For Wilsonart Solid Surface hard seam design color chart, refer to www.wilsonart.com

Technical Bulletin

Because of the unique design, Wilsonart movement and veining patterns must be fabricated with care and consideration. Because of the unique design characteristics associated with Wilsonart Movement and Veining designs the fabrication techniques and material yield must be considered when bidding, measuring and templating a job.

Movement and Veining designs require additional consideration during the layout process of the application. Fabrication and installation methods of seams, edge detail options, integral sink/vanity areas and cutouts require attention in order to provide an acceptable and visual quality install. The movement and veining design pattern changes through the surface and thickness of the material and the color can be subtle and bold throughout the sheet. The fabricator is responsible for understanding the visual variation that will occur down the length of the sheet, across the sheet and through the thickness of the sheet. It is important to remember that variation within the sheet is inherent of the product design. Equally important is that these variations will have no impact on product performance. Additional material may be needed for desired layout of the application and the visual quality outcome to meet the expectations of the end-consumer.



FABRICATION TECHNIQUES

These recommended procedures and techniques will assist all parties involved and support an acceptable and quality installation.

Job planning and fabrication should consist of these key points:

- Customer Expectations - Understanding the full scope and the Aesthetics of movement and veining designs.
- Provide samples and/or photos to customer of the edge detail in various formats such as stacked, vertical or miter-fold/v-groove methods, sink or cutout edges and movement /veining layout on the surface of the application. See Figures 6A & 6B. **Self-rimming or topmount sinks may be preferred.*
- Sheet orientation - direction layout best for the job.
- Horizontal or vertical application considerations should be noted during the layout process to ensure acceptable outcome when working with movement or veining designs.
- Variations will occur when using stacked and vertical edges. These variations will be visible throughout the length of the drop edge. These variances can be from part-to-part on the edge components creating the edge final detail.
- Miter folding/ V-groove methods are recommended when applicable to ensure continuous flow of the design.
- Deck seam selection - Butt, Serpentine or 45° Miter Seam.
- Cove - Understanding best fabrication method for cove backsplashes - Conventional or V- groove.



Figure 6A



Figure 6B

Conventional Seams:

Conventional deck seams may be used when fabricating movement or veining patterns. However, pattern orientation must be taken into consideration. Refer to the Wilsonart Solid Surface Fabrication Manual for fabrication on conventional deck seam. For conventional deck seam and pattern orientation: see Figure 7A.

**Always review movement or veining design at seams, edge profiles, cutouts and integral sinks because movement and veining will be apparent and random.*

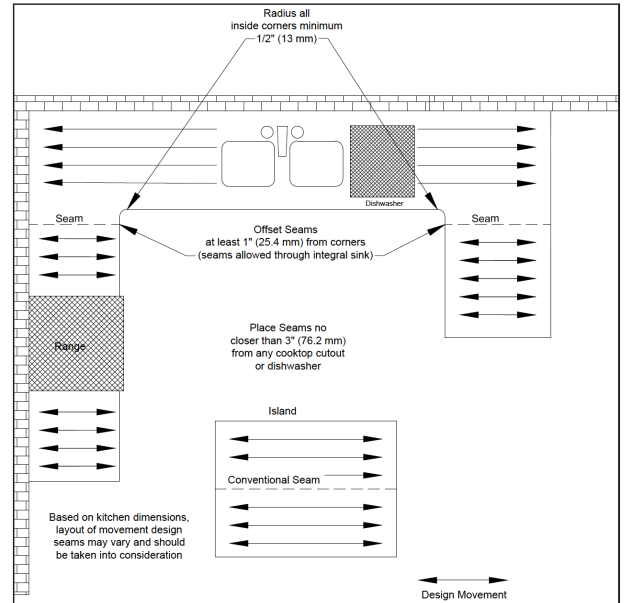


Figure 7A

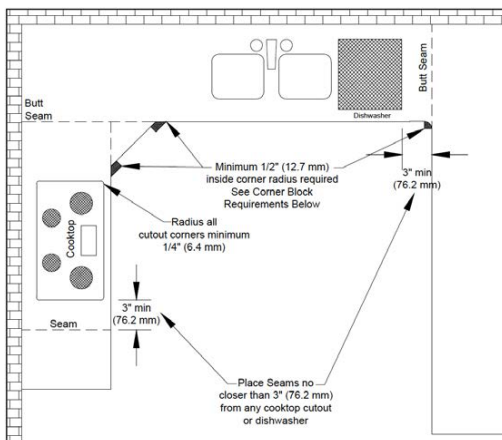


Figure 7B

45° Seam:

The 45° Miter deck seam is a great option because it allows the pattern to flow in the same direction. Refer to the Wilsonart Solid Surface Fabrication Manual for fabrication on the 45° seam. For 45° seam and pattern orientation: See Figure 7C.

**Always review movement design at seams, edge profiles, cutouts and integral sinks because movement and veining will be apparent and random.*

Miter-Folding Seams:

Miter Fold seams is a good option when fabricating movement or veining patterns, pattern orientation must be taken into consideration. Refer to the Wilsonart Solid Surface Fabrication Manual for fabrication on PT Butt seam. For PT Butt seam and pattern orientation: see Figure 16A.

**Always review movement design at seams, edge profiles, cutouts and integral sinks because movement and veining will be apparent and random.*

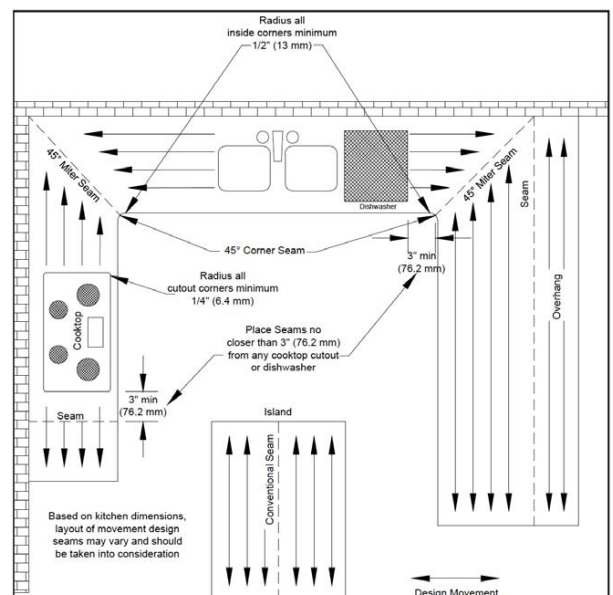


Figure 7C



Figure 8A

V-Grooved Edge :

V-groove or miterfold allows the pattern to have a continuous flow from the countertop to edge and is the most desirable and pleasing Miter-fold / V-grooving methods are recommended when applicable to ensure a continuous flow of the movement and veining design. See Figure 8A.

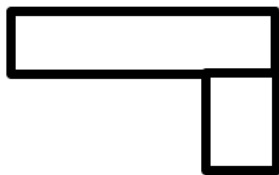
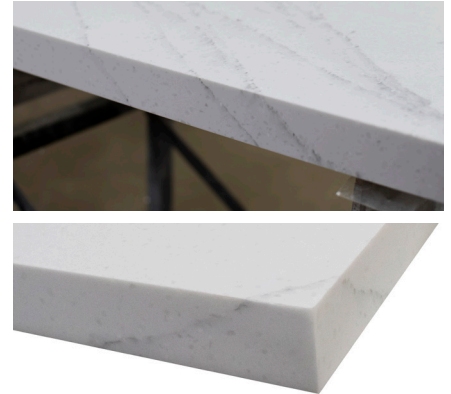


Figure 8B

Vertical Drop Edge (Rebate):

The rebate and vertical drop edge can create a belnd and break in pattern flow from countertop to edge allowing for a natural flow appearance. Each Wilsonart movement or veining pattern should be evaluated prior to fabrication since patterns will differ. See Figure 8B.



Figure 8C

Stacked Edge:

Due to the edge color and veining of the surface of the strips and on the edge of the top sheet/countertop, the stacked edges will create a different veining pattern from the surface of the sheet to the edges being stacked to create the edge detail. Each Wilsonart movement patterns should be evaluated prior to fabrication since movement and veining patterns will differ. See Figure 8C.

Sheet goods should always be inspected for visual acceptance prior to fabrication. If there is any question about the suitability of the sheet, the exchange must occur before any part of the material has been fabricated. The responsibility for repair or replacement will fall solely on the purchaser of the sheet good material.



Cove Backsplashes:

When fabricating cove backsplashes, there will be a movement and veining shift in the cove area when fabricating using the conventional method. For best result the Miter-fold/V-groove method is the best option to create the most aesthetically pleasing appearance. See Figure 9A.

Wilsonart movement and veining patterns should be evaluated prior to fabrication since movement patterns will differ. See Figure 9B.

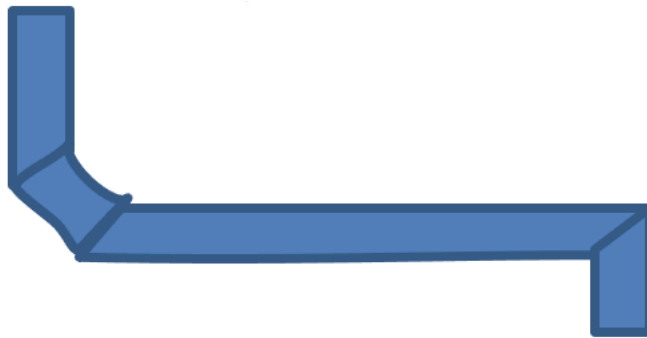


Figure 9A

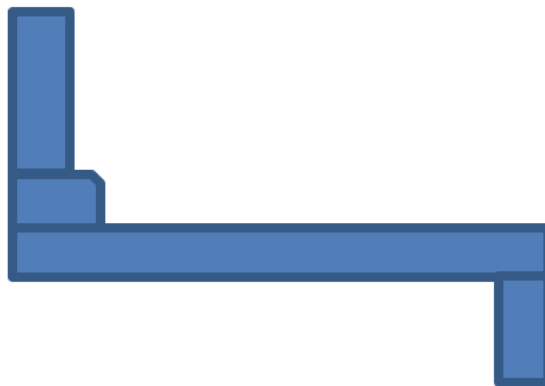


Figure 9B