



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.

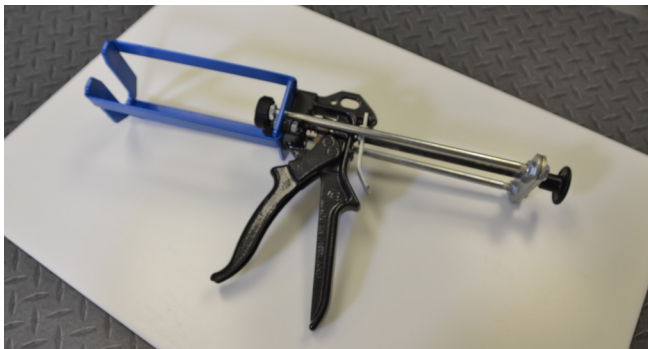


Figure 5A

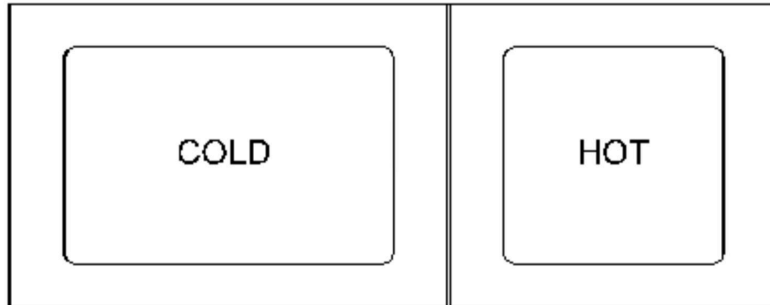
### FAB TIP:

- For Wilsonart Solid Surface hard seam design color chart, refer to [www.wilsonart.com](http://www.wilsonart.com)

## Food Service Countertops:

Hot/ Cold Food cutout should follow the recommendations below to ensure longevity of application. When fabricating a hot/cold food well make sure the recommendations of the appliance manufacture are also taken into consideration. Fabricator assumes all responsibility for performance of the cutout and countertop.

- Substrate must be flat and level. Key to a successful application is well supported cabinet with adequate ventilation.
- Crate built inside cabinet to withhold the weight of the appliance.
- Overhang supports recommendation must be followed.
- No hard seams located within 3 inches of a cutout. Soft seam are allowed utilizing 100% silicone.



- All cutouts must have reinforcement minimum 5x5 solid surface pad with 45 degree miter on all 4 corners. (See illustration)
- Any seams between cutouts must have soft seam with 1/8" expansion joint.
- All corners of cutout must have a min 1/4" radius.
- Cutout must be sanded smooth with a min 1/8" radius on tops and bottom of cutout. (See illustration)
- Nomex insulation must be use before cooktop is installed. (See illustration)
- Heat reflective tape must be used in conjunction with Nomex insulation. (See illustration)
- 100% Silicone between Cooktop and Wilsonart Solid Surface must be use. (See illustration)



## **Food Service Countertops:**

- Do not hard seam any other sink onto the bottom of Wilsonart Solid Surface sinks. Use 100% silicone to fastened to bottom of Wilsonart Solid Surface.
- After cutout is prepped position the sink centered on the cutout. Use 1x1 solid surface block with hot glue to secure position.
- Install sink clip with adhesive to bottom of prepped and positioned sink cutout.
- Sink of choice is now ready for install onsite or install at the shop.