



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.

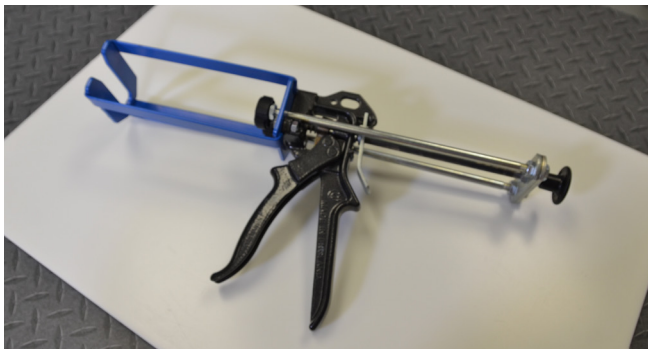


Figure 5A

FAB TIP:

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

INTRODUCTION

Procedures

- Wipe all sanding dust from countertop surface between grit changes/finishing steps.
- Darker colors will require more attention to obtain the desired final finish. (Semi-Gloss or Gloss)
- Be careful when selling dark colors and/or semi-gloss or gloss finishes. Inform your customer of the possible extra care necessary to maintain a dark color and/or finishes higher than a standard Matte or Satin finish.
- Use both horizontal and vertical strokes and overlapping your strokes by at least 50%. Inspect finish for consistency after each sanding step to aide in final finish.

FAB TIP - TAKE EXTRA CARE WHEN FABRICATING AND HANDLING THE MATERIAL TO AVOID SCRATCHES, THIS WILL REDUCE UNNECESSARY SANDING.



Recommended Finishes:

- **Light Colors** - Matte finish provides easy/low maintenance and is suitable in most cases.
 - *Satin Finish* - provides medium maintenance and is suitable in most cases. Will provide a higher sheen and more vibrant colors than matte.
 - *Semi-Gloss* - Slightly Higher maintenance needed and is not necessary in most cases. Avoid high traffic areas if possible. Care and Maintenance - Requires special customer instructions.
 - *Gloss Finish* - Recommended for vertical surfaces only. Care and Maintenance - Requires a professional to refinish.
- **Dark Colors** - Matte Finish – Although a matte finish may be used on dark colors it is NOT recommended.
 - *Satin Finish* - Provides medium maintenance and is suitable in most cases but will need more care and maintenance from the customer.
 - *Semi-Gloss* - Requires special customer instructions. Care and Maintenance- Requires a professional to refinish. Avoid high traffic areas if possible.
 - *Gloss Finish* - Recommended for vertical surfaces only. Care and Maintenance - Requires a professional to refinish.

Products

3M® Surfacing Abrasives – 1- 800-364-3577 There are 13 micron grades available. Micron grade 100 is the most coarse, is approximately equal to a grade 150, U.S. standard system. The .3 micron grade, one of the finest grades, is equivalent to a 10,000 grit.

Scotch-Brite® by 3M® – 1- 800-364-3577

3M's Scotch-Brite® Pad order of coarseness: 7447 Maroon (Fine), 7448 Grey (Very Fine) and 7445 White (Ultra Fine).

3M® Trizact™ Abrasives – 1-800-742-9546 or 1-800-364-3577 in the U.S.A. 651-737-6501 outside the U.S.A.

- The Trizact™ system, there is no need to finish the top with 3M® Scotch-Brite® pads and may decrease the amount of sanding steps.

Mirka Abralon Pads – 1-800-843-3904 Recommended for dark colors.

Sia -1-800-459-3534

www.sia-abrasives.com

Standards

U.S. standard system: 16 grit (coarsest) to 2,000 grit (finest).

- Trizact™: 60mx (coarsest) to 20,000mx (finest)
- Micron system: 100 micron (coarsest) to .3 micron (finest)
- Abralon: Medium (coarsest) to mirror fine (finest)



FAB TIPS - FOR BEST RESULTS USE LARGE SANDER (EX: GEM 11") IN DECK AREAS TO ACHIEVE MORE CONSISTENT FINISH AND TO MINIMIZE VISIBLE SANDING PATTERN. USE SMALLER SANDER (EX: 5" ORBITAL) ON EDGE DETAIL AND AROUND SINK AREAS.

FINISHING

Abrasives Sanding Steps “Quick Steps” to Final “Finish”

For final finishing use the following steps located in the Abrasive Cross Reference Chart below:

Finish Type	Grit Scotch Brite™	3M™ Micron Scotch Brite™	Trizact Film™	Mirka Abralon	Sia	Notes
Matte	180 220 7447	80u 60u 7447	268XA Green A35 268XA Blue A10/7447	N/A	1950 Siaspeed Grit: P180 1950 Siaspeed Grit: P280 6120 Siavlies Very Fine	Standard Finish Easy/Low Maintenance
Satin	180 220 280 7448	80u 60u 40u 7448	N/A	80u 60u Medium 360	1950 Siaspeed Grit: P180 1950 Siaspeed Grit: P360 * Additional step only used on dark surfaces 1950 Siaspeed Grit: P600 7940 Siaair Grit: K1000 (dry)	Slightly More Difficult Medium Maintenance
Semi Gloss	180 220 280 7445 7448	80u 60u 40u 7445 7448	268XA Green A35 268XA Blue A10 268XA Orange A5	80u 60u 40u Medium 360 Super Fine 1000	1950 Siaspeed Grit: P180 1950 Siaspeed Grit: P280 1950 Siaspeed Grit: P360 * Additional step only used on dark surfaces 1950 Siaspeed Grit: P600 7940 Siaair Grit: K1000 (dry) 7940 Siaair Grit: K3000 (dry) 7940 Siaair Grit: K4000 (dry) 7940 Siaair Grit: K1500 (wet) 6120 Siavlies Microfine Dry (wet)	Requires special customer instructions Requires Fabricator to refinish
Gloss	180 220 280 7448 7445 Buffer with Polishing Compound	80u 60u 40u 7445 7448 Buffer with Polishing Compound	268XA Green A35 268XA Blue A10 268XA Orange A5 568XA White CeO or Buffer with Polishing Compound	80u 60u 40u Medium 360 Super Fine 1000 Mirror Fine 4000		Recommended for vertical surfaces only Requires fabricator to refinish

The gloss finish is not recommended for high traffic areas. It requires a trained fabricator to maintain its finish.

** Use with Microhook Interface Pad