



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.

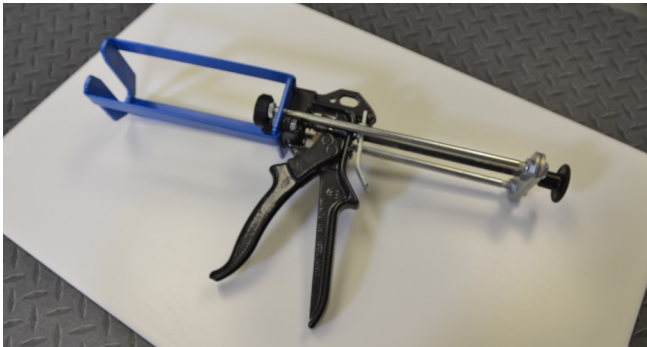


Figure 5A

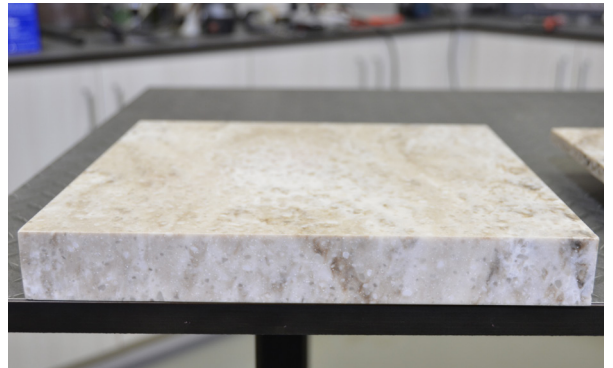
FAB TIP:

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

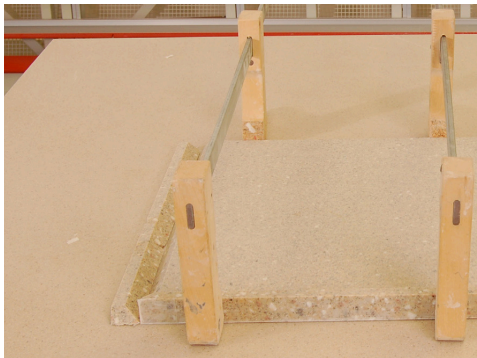
Drop Edges: V-Groove/Miter Fold

Drop Edges - V-Groove/Miter Fold

- V-Grooving and Miter Folding allow for smooth, crisp and inconspicuous seamed edges. Wilsonart professionals are encouraged to use this method on all their edge opportunities, but is strongly suggested on movement designs to allow design flow from the surface through the edge.



- Tooling and machining is typically conducted on a standard stationary V-groove machine, V-grooving equipped vertical panel saw, CNC routers and even hand-held single and/or twin V-groove routers. Standard woodworking carbide and diamond cutters are recommended.
- V-Groove/miter folding is typically routed along the back side of the solid surface material to create a typical drop-edge, waterfall or apron, but can also be V-grooved on the face/finish side to create a backsplash (cove).
- A strong tape must be applied to the opposite typically the face/finished side, a minimum 3 MIL polyester tape designed for V-Grooving solid surface material is recommended.
- Tape should have good adhesion and high tensile strength to prevent vibration during the machining process and stretching when folding to bond parts.
- Clean surface area with denatured alcohol to receive the tape to ensure a good bond. After applying tape, a J-roller is also recommended to apply pressure to secure the bond.
- Place Wilsonart® Solid Surface face down on a solid, flat work surface.



DROP EDGES: V-GROOVE/MITER FOLD

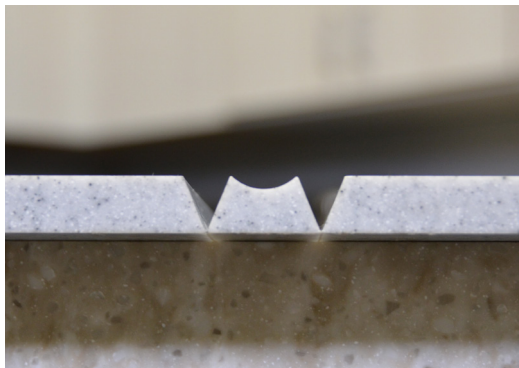
- Once material has been V-grooved, place Wilsonart Solid Surface face down on a solid flat work surface.
- Remove corner block and trim hinge tape.
- Clean v-groove/miter area thoroughly by using compressed air and/or denatured alcohol and clean white shop rag.
- Apply a 1/8" bead of Wilsonart® Hard Surface Adhesive in the entire length of the miter fold seam. Also apply a 1/8" bead at one corner to be folded. (FIG 25A)
- There are various ways of clamping V-groove components, cam-action claps (25B), 3 way clamps (25C), bar clamps, custom V-groove clamps, pneumatic clamping tables, and many other options.
- Clamps should be within 2" (50.8mm) from each corner and located every 12" (304.8mm).
- Place clamps 1/4" (6.4mm) above the face of the panel to ensure proper pressure.

FAB TIP: ALWAYS PLACE CLAMPING DEVICE ON THE TAPE AREA TO ENSURE PRESSURE IS APPLIED AT THE ENCLOSED V-GROOVE AREA AND NOT AT THE TOP EDGE OR ENDS OF THE MATERIAL, WHICH CAN OPEN THE V-GROOVE SEAM AREA.

- Fold up the end caps and secure in place with spring clamps or 3 way clamps.
- Clamps should be placed every 2" (50.8mm). (FIG. 25C)
- Place 3 way clamps 1/4" (6.4mm) above the face of the panel.
- Adhesive squeeze-out is required along entire length of seam and at all corners.
- Allow seam adhesive to cure completely before machining.



Standard V-Groove Miter Fold



Cove Backsplash Miter Fold

