

# THINSCAPE® Performance Tops Fabrication Highlights



Working with a new surface material often feels like a risk. But when that new material is actually easier to work with than the ones you're used to – when it takes less time and labor to fabricate using familiar tools and methods – the risks disappear. That's THINSCAPE. A surface that's so easy to fabricate, you can complete **three times the number of tops** as other surfaces in the same amount of time.

## Less cost. Less labor. More profit.

### SAVE ON MATERIAL

High-end, nature-inspired designs at entry level cost

#### 30% SAVINGS

- Domestically produced and readily available
- Lower material cost
- No dye lots
- Jumbo slabs up to 5' x 12'

### SAVE ON FABRICATION

Fewer fabrication steps mean fewer hours of labor required

#### 3X AS FAST

- No surface sanding
- No edge build down
- Easy to handle at 3.6 lbs./sq. ft.

### SAVE ON INSTALLATION

Durable material makes transportation and handling easier

#### 2X AS FAST

- Stacks flat on pallets
- Easy to carry tops
- Easy field adjustments
- No breakage

## Comparing Fabrication Steps

	THINSCAPE	HPL	Solid Surface	Quartz or Granite
<b>PANEL PREPARATION</b>	Acquire substrate	■		
	Glue panels together		■	
	Trim panels		■	
<b>FABRICATION</b>	Cut to size	■	■	■
	Cut holes	■	■	■
	Cut edge strips			■
	Glue edge strips			■
	Edge band		■	
	Trim edges		■	
	Build down edges		■	■
	Profile edges	■		■
	Sand edges	■		■
	Sand top			■
	<b>TRANSPORTATION</b>	Transport vertically		■
Stack horizontally on pallet		■*		
Machine unload on A-frames				■
Hand carry with ease		■*	■	

\*At 3.6 lbs./sq. ft., THINSCAPE is easier to handle than other materials.

# THINSCAPE® Fabrication Overview

With a couple of minor adjustments to optimize your tools & settings, you'll find that THINSCAPE is fabricated with less cost and labor than other surfacing materials. Plus, its quality, durability and structural integrity make it easier to handle and less susceptible to breakage during fabrication, shipping, and installation.

► For complete details, download the [THINSCAPE Fabrication Manual](#).



## Cutting

You can use a vertical panel saw, circular saw or jig saw to rough cut THINSCAPE. The key is choosing the right blade for the density of THINSCAPE:

- triple chip grind
- negative to no hook
- carbide tips



## Routing can be done by hand or with a CNC router

### CNC Routing

Use the following settings on a dry bed CNC:

- Spindle Speed 14,000 – 16,000 RPMs
- Feed rate 250-300 in/min

Typically, 2 passes are made with a thin onion skin remaining to keep the vacuum in place. The final cut is with a slow up-spiral finishing bit. Use 3/8" or 1/2" shank carbide or diamond bits for strength.



### Hand Routing

Use a panel or table saw to rough cut to 1/16" to 1/4" oversize. Trim with a 3.25HP plunge type router with a double flute carbide bit. Operate the router at a slower feed rate due to the density of the material.



## Seaming

THINSCAPE can be seamed at 45 degrees or with a butt seam. Use a biscuit cutter and #10 or #20 biscuits, and always dry fit panels with biscuits in place. For final seaming, use a two-part epoxy adhesive designed to bond plastics.



## Edge Profiling

THINSCAPE can be given a flat, thumbnail, or reverse knife/shark nose profile. Set the profile bit using a straight edge. Limiting the amount of material removed will extend the life of the bit.



## Sanding & Finishing

THINSCAPE only requires sanding and finishing on the edges – not the surface. We recommend a 4-step finishing method using a random orbital sander. Start at 100 Micron (120 Grit) and end with Mirka Abralon.