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Any fabrication procedure or technique not contained within the Wilsonart® THINSCAPE™ Performance Tops 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® THINSCAPE™ Performance Tops.
- 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



Figure 4C

## Adhesive Safety:

A variety of different adhesive types can be used effectively with Wilsonart® THINSCAPE™ Performance Tops. These different “families” of adhesive require different types/levels of protection and/or precautions. (FIG. 4C) ALWAYS refer to the specific Technical Data Sheet AND Material Safety Data Sheet for usage instructions and health/safety concerns, respectively. For information concerning Wilsonart® Adhesives, contact [www.wilsonartadhesives.com](http://www.wilsonartadhesives.com) or the Wilsonart Hotline at 1-800-433-3222.



## Handling:

Wilsonart® THINSCAPE™ Performance Tops are very heavy. Therefore, care should be taken when handling to protect employees and the decorative surface of the product.

Large panels should be transported by pallet/fork-truck or rolling table. Vacuum lifts are also recommended for handling large (thick) panels.

Additional tips for working with Wilsonart THINSCAPE Performance Tops include:

- Place padding (slip-sheet or protective cardboard strips) between panels when stacking.
- Carry vertically to limit flex and possible breakage.

## Storage:

- Store Wilsonart® THINSCAPE™ Performance Tops flat on pallets or other suitable racks.
- Wilsonart THINSCAPE Performance Tops should be stored in a controlled, moderate climate.
- Avoid storing in excessive heat/humidity extremes.
- All materials should be acclimated for a minimum of 72 hours before fabrication/installation.
- Material should not be stored near exterior doors that may result in exposure to rain or temperature/humidity variations

## Inspection:

Every effort has been made to supply high quality materials, free of defects. However, as the fabricator, you must conduct a final (pre-cut) inspection for manufacturing defects or damages to continue the quality control process prior to fabrication.

## Sheet Selection Process:

Wilsonart® THINSCAPE™ Performance Tops have product information on labels that are adhered to each sheet for proper identification.



The following suggested tool list is only a minimum requirement for professional and successful Wilsonart® THINSCAPE™ Performance Tops fabrication. Various woodworking and specialized fabrication tools are available in the market today.

## Stationary Tools:

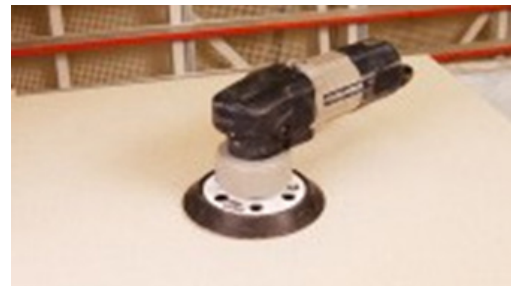
- Table or Panel Saw
- Miter (“Chop”) Saw
- Triple Chip Carbide Saw Blades

## Hand & Power Tools:

- Routers (FIG. 6A)
  - 3¼ HP with ½” (13mm) collet
  - 3¼ HP Plunge base with ½” (13mm) collet
  - 1½ -2½ HP with ½” (13mm) collet (edge details)
- General Router Bits
  - ½” (13mm) Straight cut
  - ½” (13mm) Bottom bearing flush trim bit
  - 1” (25.4mm) Top bearing flush trim bit
  - Various profile bits
- Sanders (FIG. 6B)-Random Orbital
  - Dust collection system (suggested)
  - Sanding Disks (Micron)
  - Mirka Abralon® pads
- Straight Edges (Phenolic or Aluminum)
- Clamps (FIG. 6C)



**Figure 6A**



**Figure 6B**



**Figure 6C**

For further information, contact Wilsonart Technical and Fabrication Services at 800-433-3222



# TOOL MANUFACTURERS

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## Stationary Tools:

Powermatic 1-800-274-6848  
[www.powermatic.com](http://www.powermatic.com)

Delta 1-800-223-727  
[www.deltamachinery.com](http://www.deltamachinery.com)

Holz-Her 1-704-587-3400  
[www.holzher.com](http://www.holzher.com)

Striebig 1-781-585-4364  
[www.csaw.com](http://www.csaw.com)

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## Hand Tools - Routers, Sanders, Bits, etc:

Porter Cable 1-888-848-5175  
[www.portercable.com](http://www.portercable.com)

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## Router Bits:

Amana Tool 1-800-445-0077  
[www.amanatool.com](http://www.amanatool.com)

Velepec 1-800-365-6636  
[www.velepectools.com](http://www.velepectools.com)

Wesley Tools, Ltd.  
1-800-397-6867  
[www.wesleytools.com](http://www.wesleytools.com)

Southeast Tool 877-465-7012  
router@southeasttool.com  
[www.southeasttool.com](http://www.southeasttool.com)

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## Sanding Equipment:

Fein 1-800-441-9878  
[www.feinus.com](http://www.feinus.com)

Festool 1-800-423-3531  
[www.festoolusa.com](http://www.festoolusa.com)

Surcare 1-800-669-5519  
[www.surcare.com](http://www.surcare.com)

Dynabrade 1-716-631-0100  
[www.dyabrade.com](http://www.dyabrade.com)

Master Power 1-866-557-8316  
[www.masterpneumatictools.com](http://www.masterpneumatictools.com)

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## Sandpaper/Finishing Pads:

3M Scotch-Brite & Trizact  
1-800-742-9546  
[www.3m.com](http://www.3m.com)

Micro Mesh 1-908-788-5550  
[www.sisweb.com](http://www.sisweb.com)

Norton 1-800-446-1119  
[www.nortonabrasives.com](http://www.nortonabrasives.com)

Mirka 1-800-843-3904  
[www.mirka-usa.com](http://www.mirka-usa.com)

Sia 1-800-459-3534  
[www.sia-abrasives.com](http://www.sia-abrasives.com)

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## Pipe and Bar Clamps:

Bessey 1-800-828-1004  
[www.americanclamping.com](http://www.americanclamping.com)

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# TOOL MANUFACTURERS

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## Recommended Saw Blades:

Amana Tool 1-800-445-0077  
[www.amanatool.com](http://www.amanatool.com)

DML 1-800-242-7003  
[www.dmlwoodworking.com](http://www.dmlwoodworking.com)

FS Tool 1-800-387-9723  
[www.fstoolcorp.com](http://www.fstoolcorp.com)

Guhdo 1-800-544-8436  
[www.guhdo.com](http://www.guhdo.com)

Forrest 1-800-733-7111  
[www.forrestsawblades.com](http://www.forrestsawblades.com)

Leitz 1-800-253-6070  
[www.leitz.com](http://www.leitz.com)

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## Miscellaneous Tools:

Betterley Industries  
1-800-871-7516  
[www.betterleytools.com](http://www.betterleytools.com)

DeWalt 1-800-433-9258  
[www.dewalt.com](http://www.dewalt.com)

Specialty Tools 1-800-669-5519  
[www.specialtytools.com](http://www.specialtytools.com)

Karran@ Sinks 410-975-0128  
[www.karran.com](http://www.karran.com)

### Dustless sanding system

Fein Power Tools 1-800-441-9878  
[www.feinus.com](http://www.feinus.com)

### Specialized tools

The Pinske Edge 1-800-874-6753  
[www.pinske-edge.com](http://www.pinske-edge.com)

### Fabrication tools

Align-Rite Tool Co. 1-888-624-1942  
[www.alignritetool.com](http://www.alignritetool.com)

### Straight edge

A.M.P.S. 1-800-669-5519  
[www.ampsedge.com](http://www.ampsedge.com)

### Vacuum base seam leveler/clamps

Perfect Seam 1-770-463-8321  
[www.omnicubed.com](http://www.omnicubed.com)

### Vacuum base seam clamps

Wood's Power Grip Co. 1-800-548-7341  
[www.powergrip.com](http://www.powergrip.com)

### Dust containment

Zip Wall 1-800-718-2255  
[www.zipwall.com](http://www.zipwall.com)

### Adhesive dispenser repair parts

Conprotec Inc. 1-603-893-2727  
[www.mixpac.com](http://www.mixpac.com)

### Sink Setter Brackets/Easy Leveling Shelf and Counter Bracket

Sink Setter at Precision Works 1-714-847-3396  
[www.sinkset.com](http://www.sinkset.com)





## FAB Tips

- Based on the thickness of the final Wilsonart® THINSCAPE™ Performance Top application, consideration of cabinets and appliances must be made during the planning stages.
- When working with Wilsonart® THINSCAPE™ Performance Tops, slower feed-speeds should be expected due to the density of the material (as compared to HPL on particleboard/MDF).
- It is always appropriate to contact your tooling supplier for specific recommendations for feed, speed, and tool geometry.
- While good quality carbide proves effective for small projects, diamond cutting tips may be more durable and cost effective.
- Rate of advance of the cutter (chip load) should be .001"- .002".
- Triple chip designs have shown to provide good cut quality. Hook + 15°.
- Panel saws with a "scoring-saw" option can minimize chipping on the exit side of the panel.
- While surface wear inhibitors can be a factor in tool life, the enemy in any machining process is heat.
- Cutting rates and feed speeds play a major role in both the practical life of tooling, as well as the quality of cuts during machining. As in any machining process, specific machines and tool types will vary and specific parameters will have to be established on site.
- Only use recommended cleaners per the care and maintenance sheet.
- Colored or printed towels can leave a residue which will contaminate the seam material and cause a weak or stained bond line.
- Postforming is not recommended or approved by Wilsonart for the THINSCAPE Performance Tops. Please contact Wilsonart Technical Service Group at 800-433-3222 for further information.
- All edges should be sanded smooth and free of sharp corners and kerf marks, which result in stress points.
- Hand Routing—For best results, finished edges of Wilsonart THINSCAPE Performance Tops should be routed/milled. Rough cut panels to approximately 1/16" before finish routing. It is best to use cutters with larger diameter shanks (1/2"). However, smaller tools may be used with minimal feed rates and trim amounts. Two-flute carbide straight cutting bits work well for trimming.
- CNC Routing—The appropriate cutting sequence is largely determined by the type of machining required. For example, large panel sizing may be completely different than cutting out nested parts. In any case, the specific panel's thickness, cutting sequence, and type/condition of the machine will require that you "tune" adjustments for your particular process. A good starting point for machining is:
  - Spindle speed—16,000-18,000.
  - RPM's Feed-rate—200-900 in/min.

## Deck Seams–Conventional

- Machine both edges to be seamed. Slightly oversize both Wilsonart® THINSCAPE™ Performance Tops parts by a maximum of 1/8". Both sides must be routed for a proper dry fit and quality seam. (FIG. 10A)
- Seams should fit tightly when dry fitted.
- Alignment biscuits/wafers or slot bits are required for alignment and leveling.
- For alignment, use biscuit slot cutter or slot bit to machine slots for #20 biscuits. (FIG 10B)
- Minimum of 4 biscuits are required for butt seam or 45° seam. Biscuits on ends must be 3" from inside and outside corners. Other biscuits should be distributed evenly for maximum alignment and leveling. (10B. & 11B.)
- Place clear tape on face at seam location after dry fitting seam. Once tape is adhered use a sharp utility knife to cut tape allowing equal tape on both sides of seam to protect face of Wilsonart THINSCAPE Performance Tops. Also, place clear packing tape (or other release material) under the seam to prevent contamination of deck seam.
- Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.
- Position sheets to be seamed 3/16" (4.8mm) to 1/4" (6.4mm) apart.
- Prepare clamping materials.
- Prepare epoxy 2-part seam kits.
- Prepare tube and tip to ensure proper mixture of adhesive.
- Fill the seam to 1/2 full and biscuit slots, apply biscuits.
- Damming the ends will make this easier.
- Slide the sheets together - make sure there is adhesive squeeze out along entire seam. Clamp the seam together using bar clamps, suction cups, wood blocks or spring clamps. (FIG. 10C)
- DO NOT OVERTIGHTEN clamps.
- Over tightening will cause starved, weak seams.
- Remove tape once adhesive is fully cured. This will remove majority of adhesive material.
- Remove remaining adhesive squeeze out with plastic putty knife or razor blade being careful not to damage face of the Wilsonart THINSCAPE Performance Top.
- Do not scrape, chisel or remove adhesive prior to being fully cured.



Figure 10A



Figure 10B



Figure 10C

## Deck Seams–45° Seam

This method is recommended to be used for movement or directional designs. Conventional 45° seams are the preferred method for seaming, allowing the pattern movement to continue throughout the application and flow in similar direction through the angle or corner. (FIG. 11A)

- Machine both edges to be seamed.
- Alignment biscuits/wafers or slot bits are required for alignment, leveling and to eliminate movement of 45° seaming process. (FIG. 11B) Use of Epoxy 2-part adhesive is recommended.
- Minimum of 4 biscuits are recommended for butt seam or 45° seam. Biscuits on ends must be 3" from inside and back corners. Other biscuits should be distributed evenly for maximum alignment and leveling. (FIG. 11B)
- Seams should fit tightly when dry fitted.
- Place clear tape on face at seam location while dry fitting seam.
- Once tape is adhered, use a sharp utility knife to cut tape allowing equal tape on both sides of seam to protect face of Wilsonart® THINSCAPE™ Performance Tops.
- Place a release material (such as packing tape) under the seam to prevent contamination of deck seam.
- Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.
- Position sheets to be seamed 3/16" (4.8mm) to 1/4" (6.4mm) apart. Prepare clamping materials. (FIG. 11C)
- Prepare epoxy 2-part seam kits.
- Prepare tube and tip to ensure proper mixture of adhesive.



Figure 11A

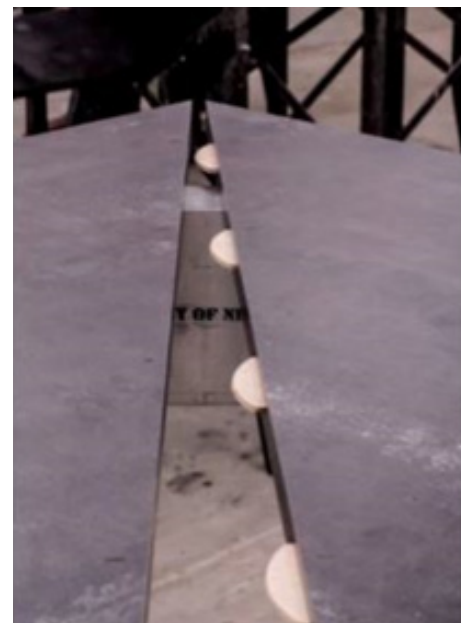


Figure 11B



Figure 11C

**Note: Based on kitchen dimensions, seam location and movement design may vary and should be taken into consideration.**

## Wilsonart® THINSCAPE™ Performance Tops and Sink Installation Drop-In/ Self-Rimming

Stainless steel and other material type drop-in (FIG. 12A) sinks/bowls can be installed by following these instructions:

- Inspect sink for imperfections and verify color.
- Identify the location. The distance between the drop-in sink cut-out and a seam location must be a minimum of 3" (75mm), while the distance from the front edge of the countertop must be a minimum of 1.5" (40mm).
- Position sink using center-line dimensions. Place the sink upside down on the face of the countertop and mark around the perimeter of the sink flange. (FIG. 12B)
- Using a template, draw a second line at least 3/8" (10mm) to a 1/2" (13mm) inside the first line of the sink perimeter, or to the manufacturer's guidelines. This should allow the drop-in to fit properly inside the cutout once the cutout section is removed.
- Ensure all countertops are adequately supported during all cutting processes.
- Using a 1/2" (13mm) bit, drill each of the 4 corners of the inner line to create a clean radius corner. Minimum 1/4" (6mm) radius required at all inside corner cutout locations. This will prevent any potential stress cracking in the corners.
- Following the inner line, plunge with a hand router using a 1/2" router bit (13mm) (FIG. 12C) or use a circular saw with a guide rail and TCT triple chip blade. Recommend cutting in stages of 1/8" (4mm) depth increments. Always use a router bit cut to finish final cut into the radius corners.



Figure 12A



Figure 12B



Figure 12C



## Wilsonart® THINSCAPE™ Performance Tops and Sink Installation Drop-In/ Self-Rimming Continued

- Dry fit vanity or sink to ensure proper fit.
- Clean Wilsonart® THINSCAPE™ Performance Tops and vanity/sink flange with denatured alcohol.
- Apply ample amount of 100% silicone to the Wilsonart THINSCAPE Performance Tops in areas to receive flange of vanity/sink.



Figure 13A

## Wilsonart® THINSCAPE™ Performance Tops and Sink Installation Undermount

Stainless steel and other material type undermount vanities (FIG. 13A) and sinks can be installed by following the instructions below. It is always recommended to review and follow vanity/sink manufacturer instructions.

- Develop a sink template from particleboard or Wilsonart® THINSCAPE™ Performance Tops by taking dimensions from vanity/sink and transferring to template material along with center lines.
- For best results, all cutouts must be conducted using a router for template and Wilsonart THINSCAPE Performance Tops cutouts. (FIG. 13B)
- Fasten template with clamps to the face side of the countertop. The use of an inner template is recommended to support router and can be fastened to face with hot melt.
- Using router with top bearing bit or template guide and ½" (13mm) router bit, follow the template with router. Recommend cutting in stages of 1/8" (4mm) depth increments. Always use router bit to complete cutout.
- Dry fit sink to ensure proper fit and that dimensions are accurate.
- Wilsonart THINSCAPE Performance Tops edges can be finished using a multi-step sanding process that utilizes a sequence of small-to-large grit. (FIG. 13C) See finishing section on page 18 for steps in finishing the sink cutout prior to fastening vanity/sink to Wilsonart THINSCAPE Performance Tops countertop.



Figure 13B



Figure 13C

## Sink Installation Undermount Continued

- During the dry fitting process mark locations of sink clips. Use 4-6 sink clips for vanities and 6-8 clips for kitchen sinks. (FIG. 14A)
- With sanding materials, scuff the Wilsonart® THINSCAPE™ Performance Top at the bonding location of flange or clip system stems. (FIG. 14B)
- Sink clips can be fastened by using Rotoloc® threaded stems and clips, or by using inserts with threaded stems and clips.
- Clean vanity/sink flange and area with denatured alcohol to receive Rotoloc® stems and Devcon/ Plexus MA300 or equivalent plastic welder adhesive to adhere to the backside of Wilsonart THINSCAPE Performance Top. (FIG. 14C)
  - SinkSetter, an under mount sink installation kit is also recommended to install sinks in Wilsonart Thinscape material. [www.sinksetter.com](http://www.sinksetter.com)
- For insert installation, please follow recommended manufacturer installation guidelines providing best support scenario.
- Avoid securing sink clips to plumbing fixture areas.
- Avoid screwing through the material unless adding wooden strips or plate to secure to.
- Apply ¼" bead of 100% silicone to the center of the vanity/sink flange. Fit vanity/sink, apply pressure and fasten sink clips using wing nuts. Fasten wings equally and apply pressure evenly. Prior to tightening, secure vanity/sink to ensure proper installation and then tighten. Ensure 100% squeeze out around the perimeter of the vanity/sink.
- Remove squeeze-out with clean water, moistened finger or tool.
- Adhering vanity/sink may take place during the installation process in the actual application location.



Figure 14A



Figure 14B



Figure 14C

## General Cutout Requirements

These procedures are for cutouts that do not involve heat generating/producing appliances or items. See Cooktop Cutout requirements on page 16 for cutouts involving heat generating items installed in or over a cutout.

- Cutouts must be completed and performed with a router only. (FIG. 15A)
- Inside corners of all cutouts must be radiused.
  - Use 1/2" (9.5mm) or larger diameter bits.
  - A 1/4" (6.4mm) minimum radius required or larger preferred at all cutout inside corners.
  - See page 16 for Cooktop Cutouts requirements.
- Round over top and bottom edges of cutouts to a minimum of 1/16" (1.5mm) radius.
- Remove any roughness, nicks and/or router "chatter" with 150-grit (80 micron) or finer sandpaper. (FIG. 15B)
- Allow at least 1/8" (3mm) clearance space on all sides for drop-in sinks and appliances.
- Allow at least 1/16" (1.5mm) clearance space on all sides for outlets.



Figure 15A



Figure 15B



## Cooktop Cutouts

- Cutouts must be performed with a router only.
- A minimum 1/4" (6.4mm) gap is required between the edge of Wilsonart® THINSCAPE™ Performance Tops cutout and cooktop. (FIG. 16A)
- Inside corners of all cutouts must have a minimum radius of 1/4" (6.4mm). (FIG. 16B)
- Round over top and bottom edges of cutout a minimum of 1/16" radius.
- Sand sides of cooktop cutout to be free of roughness, nicks and router "chatter" with minimum 150-grit or finer sandpaper.
- Wrap entire cooktop opening with Wilsonart® 9 mil aluminum heat reflective tape.
- Place an additional layer of tape at all corners. Inform cooktop installer that tape must not be removed. Nomex® will assist with heat resistance.
- Do not fold tape under the bottom of the cutout.
- Tape must extend past the edge of cooktop flange. Trim excess. (FIG. 16A)
- Never fasten cooktop to Wilsonart THINSCAPE Performance Tops with mechanical fasteners.
- Use a wood block between the Wilsonart THINSCAPE Performance Top and the cooktop fasteners.
- If minimum cutout dimension listed above cannot be met, follow requirements for cooktop mantle or stainless steel ring.

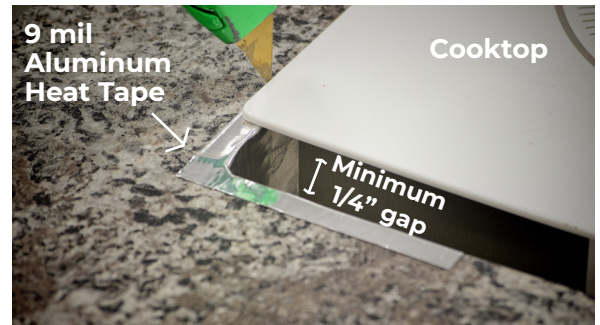


Figure 16A



Figure 16B

# CONVENTIONAL BACKSPLASH

## Backsplash

- Use 100% silicone to adhere backsplash to countertop and wall.
- Apply continuous bead to the bottom of backsplash to be adhered to countertop. Apply dots of silicone to backsplash, hot melt adhesive can be used to adhere backsplash to the wall while silicone cures. (FIG. 17A)
- Remove excess silicone squeeze-out, leaving only a small inside corner bead. (FIG. 17B)
- On full height backsplash, apply all Wilsonart® THINSCAPE™ Performance Tops fabrication guidelines.
  - 1/4" (6.4mm) radiused inside corners
  - Space for expansion
  - Cutouts must be made with a router
  - Attach backsplash with silicone
  - Do not hard seam to countertop



Figure 17A



Figure 17B

# EDGE PROFILING & FINISHING

## Edge Profiling

- Wipe all sanding dust from countertop surface between grit changes.
- Exposed edges can be shaped to enhance the appearance and ergonomics of the installation. This is especially true for Wilsonart® THINSCAPE™ Performance Tops used as a work-surface or countertop. Typical shapes in wood-working and Solid Surface applications are also obtainable with Wilsonart THINSCAPE Performance Tops:
  - Fillet, Thumbnail, Flat, Reverse-Knife
- Radius should be limited at the transition to the face in order to minimize the “feathering” of the decorative surface.
- For any other questions concerning edge profiling, please contact Wilsonart's Hotline at 800-433-3222



Figure 18A

## Finishing

- Machining edges will normally result in slight-to-moderate cutter/kerf marks.
- These edges can be finished by using a random orbital sander to smooth the edges until they possess an attractive appearance. (FIG. 18A)
- Edge finishing is a multi-step sanding process that utilizes large-to-small grit. Similar to Solid Surface finishing, the final finish using the following sanding steps are the recommend finishes:

Finish Type	USA Grit	3M™ Micron
Matte Finish	150, 180, 220 Grit Finishing with Mirka Abralon 360 or Scotch-Brite	100, 80, 60 micron Finishing with Mirka Abralon 360 or Scotch-Brite
Satin Finish	150, 180, 220 Grit Finishing with Mirka Abralon 1000 or Scotch-Brite	100, 80, 60 micron Finishing with Mirka Abralon 1000 or Scotch-Brite
Semi-Gloss Finish	150, 180, 220 Grit Finishing with Mirka Abralon 1000 and 2000 or Scotch-Brite	100, 80, 60 micron Finishing with Mirka Abralon 1000 and 2000 or Scotch-Brite



## Suggested Products

3M® Trizact™ Abrasives  
1-800-742-9546

- 1-800-364-3577 in the U.S.A.
- 651-737-6501 outside the U.S.A.

Mirka Abralon Pads  
1-800-843-3904

- Recommended for dark colors.

## 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)



## Jobsite Preparation

- Based on the thickness of the final Wilsonart® THINSCAPE™ Performance Top application, consideration of cabinets and appliances must be made during the planning stages.
- Do not install Wilsonart THINSCAPE Performance Tops over a solid substrate, except at overhangs and 45° seams.
- Supports are required every 24".
- Ensure cabinets are leveled. Shims may be used for assistance. (FIG. 20A)
- Certain unsupported areas are in need of stronger frame material. These include inside corner cabinets, especially for a Lazy Susan, dishwasher openings, sink base fronts, desks and anywhere else that the cabinet is weaker. (FIG. 20B)
- Place cabinet supports at both sides of all cutouts. Place supports no closer than 1" (25.4mm) and no further than 3" (76.2mm) from sides of cutout.
- Multiple bowl installations require special reinforcement to provide adequate support.
- Place cabinet support along both sides of the bowl installation.
- Place sink setters, solid wood, MDF or plywood supports between each bowl.
- Supports must be attached to cabinet base to alleviate flexing.
- Free standing stoves must be set at a minimum of 1/16" higher than the surface of the countertop.
- Insert method is recommended to be used for dishwasher clips only.

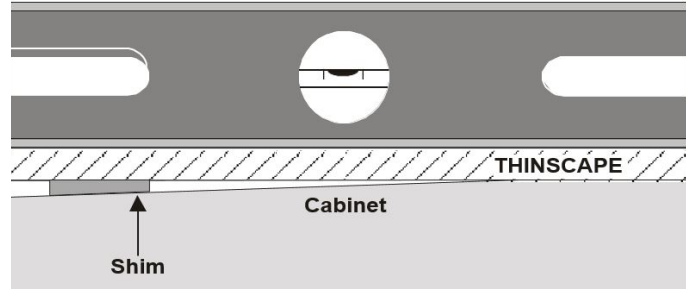


Figure 20A

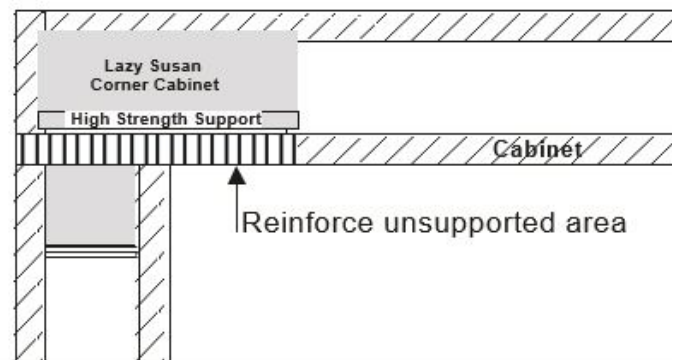


Figure 20B

## Overhangs

Additional support is required when the countertop overhangs the cabinet. Refer to the following chart to determine support required:

Overhang	Support Required
0" to 6" (0-152.4mm)	None
6" to 18" (152.4mm-304.8mm) <b>Figure 21A</b>	Brackets or Corbels
18" to 24" (457.2mm-609.6mm)	Brackets (corbels) and Supporting legs

When brackets (corbels) are used, place them no more than 24" (609.6mm) apart. In addition, place brackets 12" (304.8mm) from open ends and against wall ends. (FIG. 21A & 21B)

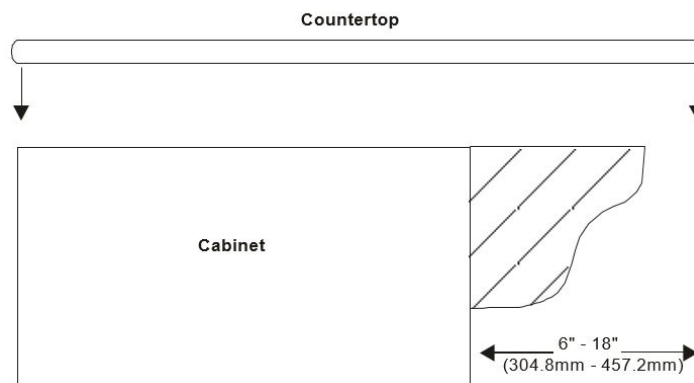


Figure 21A

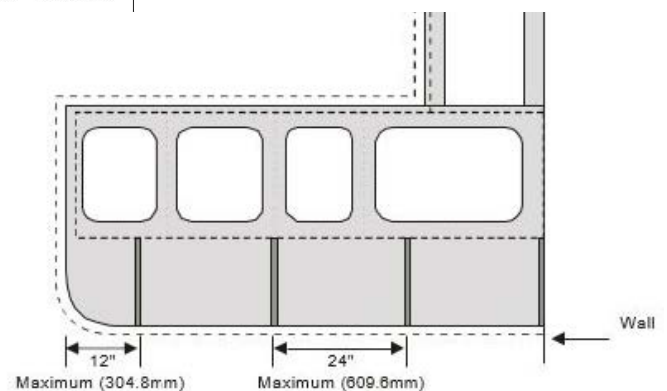


Figure 21B

## Securing the Countertop

- Ensure cabinets are secure and level prior to installation.
- Use only 100% pure silicone to secure countertop to cabinet frame - no construction mastic.
- Use lineal beads of silicone at a minimum width of 1/8".
  - Secure all outside corners
  - Apply bead along the front of application and add dime-sized dabs every 12" (304.8) to 18" (457.2mm) along the back of cabinet supports
  - Do not place silicone in the inside corners
- No mechanical fasteners should be used to fasten the countertop. Never screw, staple or nail into Wilsonart® THINSCAPE™ Performance Tops (inserts may be used if needed).

## Fitting the Countertop

- Provide minimum 1/8" (3.2mm) gap at all walls for every 12 feet of countertop.
- Scribe to wall as necessary.





## Customer Satisfaction

Customer satisfaction is achieved by using a commonsense approach. Treat your customer fairly. Word of mouth is the best and least expensive form of advertising. Quality assurance in fabrication and installation is of the utmost importance, as the fabricator's reputation depends upon this.

The following is mandatory:

- Care and Maintenance information should be provided to end user. Information can be found at the Wilsonart website, [www.wilsonart.com/care-and-maintenance](http://www.wilsonart.com/care-and-maintenance). (FIG. 23A)

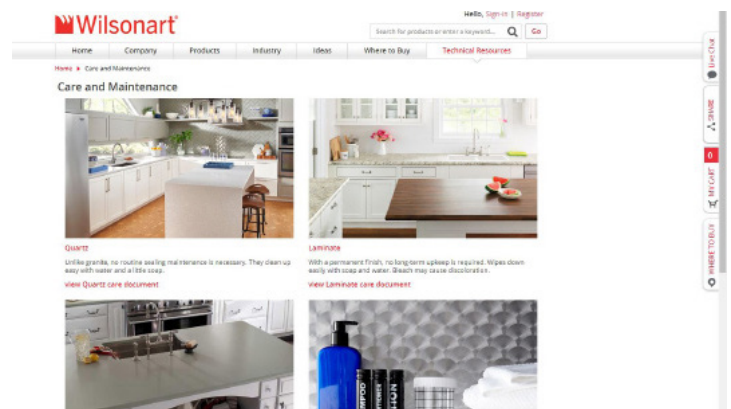


Figure 23A