

DuPont Surfaces

DUPONT™ CORIAN® SOLID SURFACE 12mm GAUGE STANDARDIZATION

PRODUCT ADVISORY

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INTRODUCTION

We are standardizing all DuPont™ Corian® sheet world-wide in an effort to provide more consistent sheet gauge to our valued partners. As a result, Corian® half-inch sheet will be produced to tighter tolerance with a target thickness of 12.0 mm (472 mils). Most of the sheet that you receive should be in the target range.

DuPont plans to make all Corian® sheet according to the new 12.0 mm standard starting March 30th. There will be a transition period as we and our distributors work through inventories. Fast moving colors, such as Maui and Glacier White will transition faster. Slower moving colors, such as, Graphic Blue or Gobi could take six or more months to move through inventory.

The edge label on the half-inch sheet will show the dimensions for the new standardized gauge. Along with the sequence number and color, the gauge in mm (12 mm) will be printed along the edge.

This notification addresses some fabrication considerations you should be aware of during the transition period. The gauges used in the examples are near the upper and lower limits of sheet that will be sold.



corian®

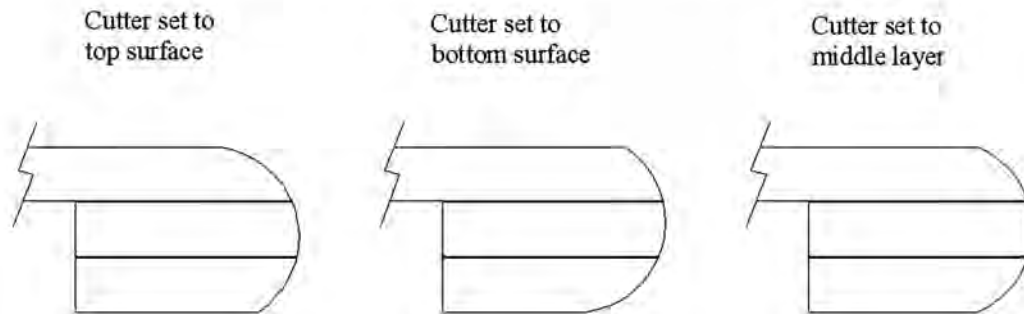
B. Bull-Nose Edge Treatment

Drop edges (as shown in Figure 12.3.D. of the Fabrication Manual) are recommended instead of stacked edges. Use a second layer of buildup to create sufficient thickness for the bull-nose.

Use the thermoforming method to create inside corners as shown in Figure 12.4.D of the Fabrication Manual and use a second layer of buildup to create sufficient thickness for the bull-nose.

Stacked edges can be used, but may require more time to finish depending on the cutters and method used. A 1½" (38mm) Bullnose cutter will leave a truncated feature either on the top surface, bottom surface or both surfaces depending on how the cut is made.

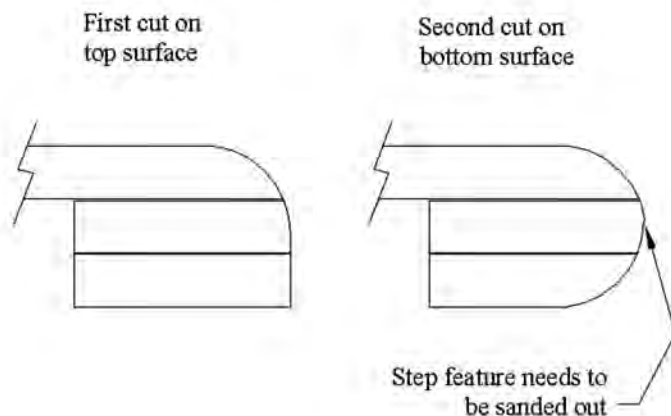
1.5" (38mm) Bullnose on 0.450" (11.4mm) stacked edge



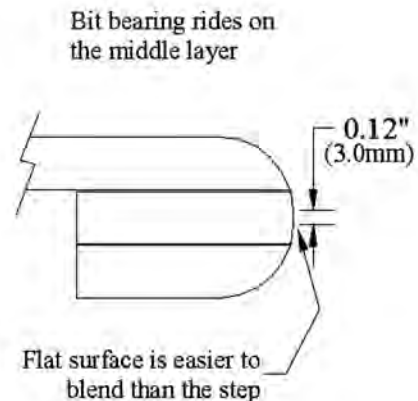
To avoid this, new cutters would need to be ordered. Bullnose cutters in 1¼" (36.5mm) are available.

Some fabricators use a ¾" (19mm) roundover bit and cut the edge from both the top and bottom surfaces. This will result in a step at the midpoint due to the bit bearing riding on the profile instead of the flat surface. Using a ⅝" (15.9mm) or 11/16" (17.5mm) roundover bit will eliminate the step and leave a narrow flat surface that is easier to blend. Both bits are available.

¾" (19.0mm) Roundover bit used to make Bullnose Edge



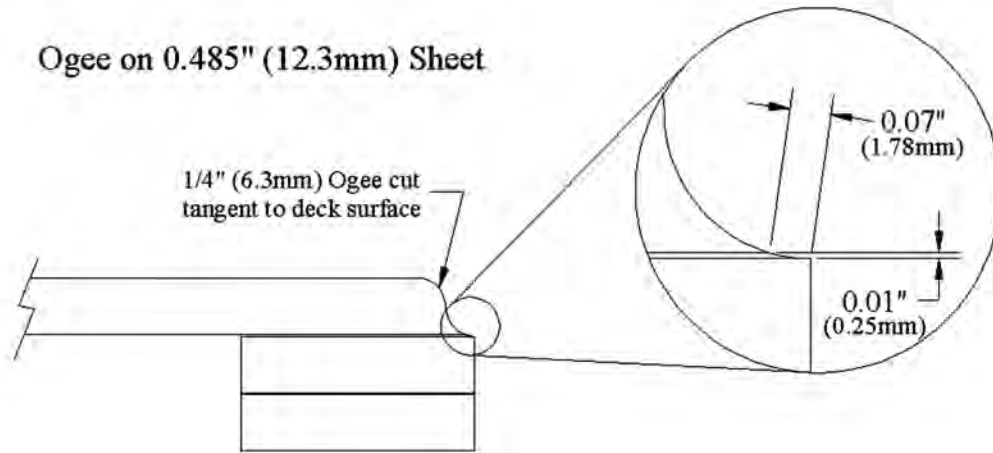
Same procedure but with ⅝" (15.9mm) Roundover



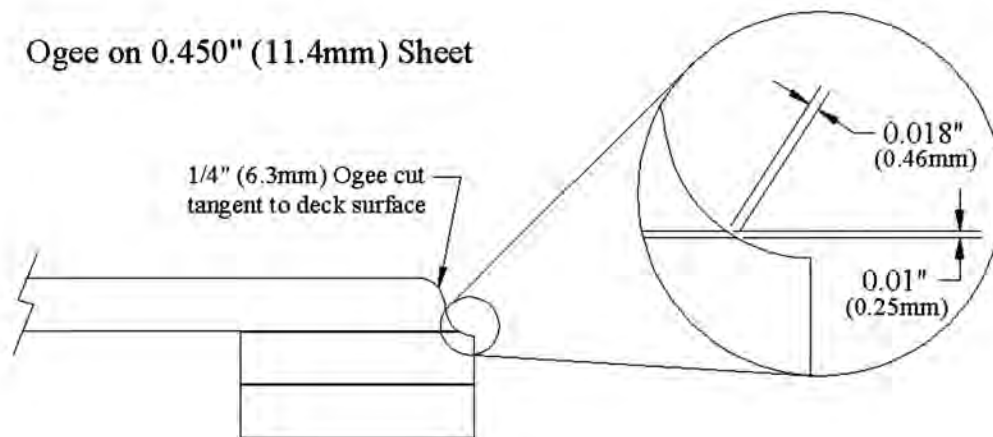
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C. Ogee Edge Treatment on Stacked Edges

Profiles using the standard $5/32$ " (4mm) Ogee bit will have no issues as the bit does not cut near the seam. Profiles using the $1/4$ " (6.3mm) Ogee bits will have a less noticeable seam. With the thicker sheet, the cut falls right at the seam making the glue line look wider. A 10 mil thick glue line will look 70 mils wide.

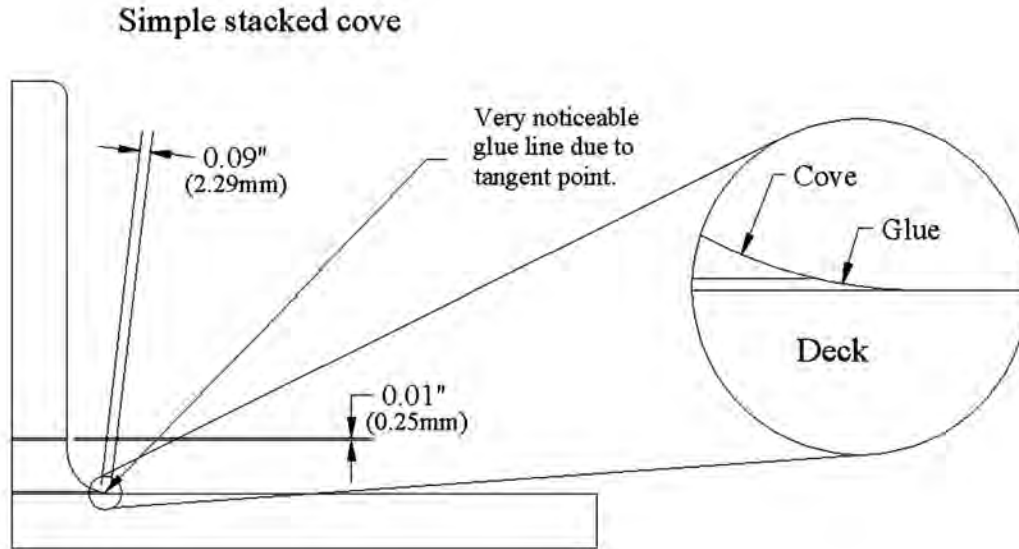


With a sheet thickness of 450 mils, the seam is moved up the profile so that a 10 mil thick glue line appears 18 mils thick instead of 70 mils.



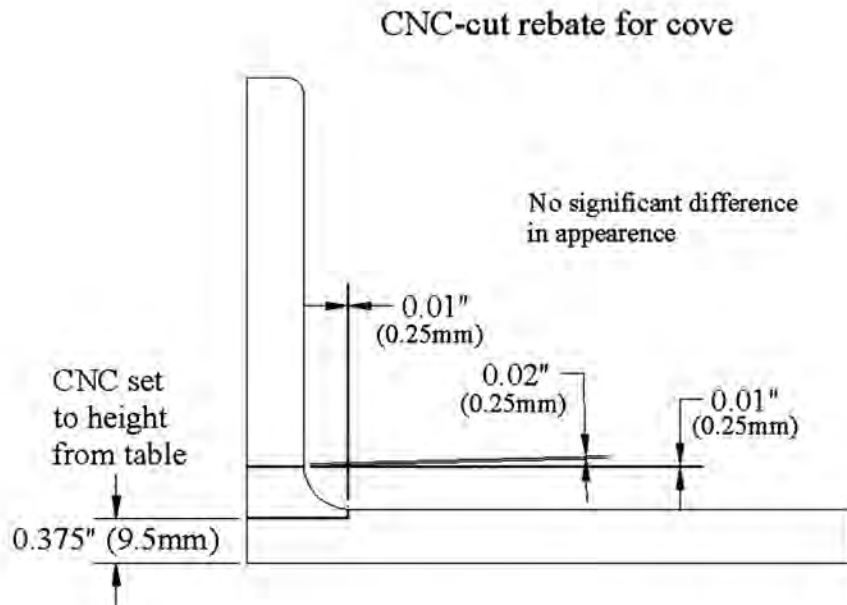
D. Coved Backsplashes

The original method to add a cove backsplash was to simply stack the cove strip and the backsplash onto the deck. This method had the potential to make the lower glue line look wide. This is because the cove cutter cuts the glue at the blend point. A 10 mil thick glue layer looks 90 mils wide.



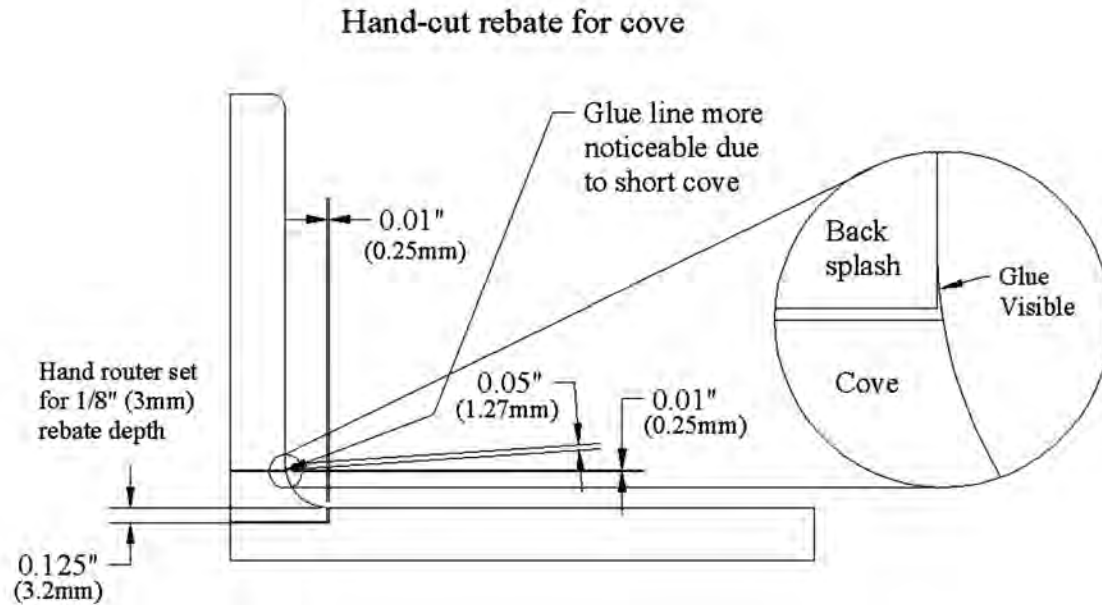
By rebating the deck to accept the cove strip, the glue line is now at a right angle to the cove cut, so only the thickness of the glue line shows.

When the rebate is cut with a CNC router, it is cut based on the height of the router table. There will be no difference noticed in the glue line with this method.



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When the rebate is cut with a hand router, the depth of cut is now based on the router plate and the rebate needs to be less than with 485 mil thick sheet. If the rebate cut is 1/8" (3.2mm) deep, then the cove cutter will cut the upper blend point above the upper seam and make the glue line appear wider. Setting the depth to 1/16" (1.6mm) will make the blend point fall below the seam and only the true thickness of the glue will show.

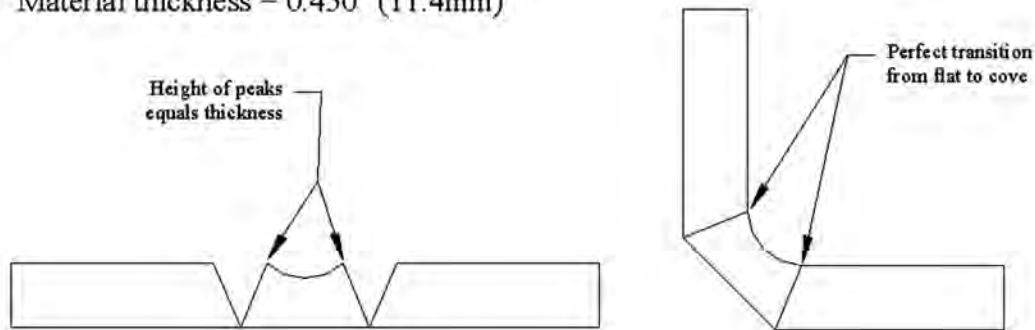


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E. V-Grooving

Caution should be used when selecting tools for v-grooving. The depth for the v-grooving should be set off the face of the sheet.

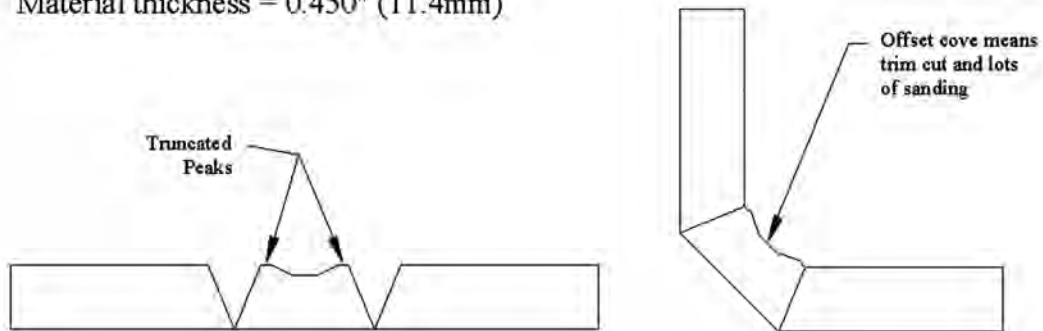
V-Groove cutter set to 0.450" (11.4mm)
Material thickness = 0.450" (11.4mm)



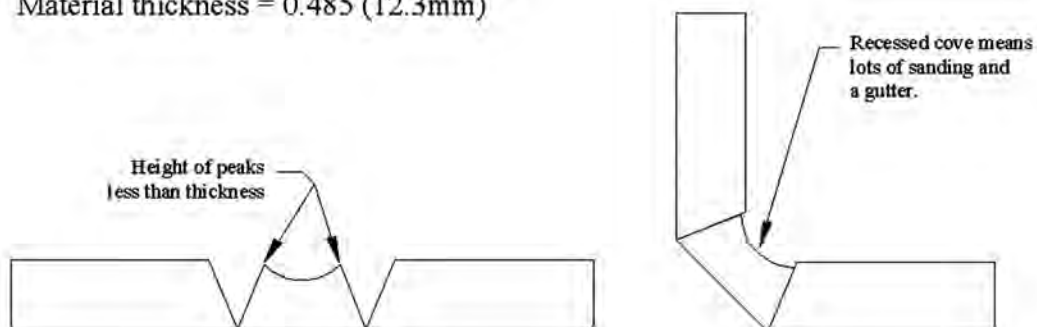
When the cutter is matched to the sheet thickness, there should be very little sanding.

When it is off either way, there will be a lot of sanding required to blend the surfaces. Excessive sanding can result in a gutter at the cove.

V-Groove cutter set to 0.485" (12.3mm)
Material thickness = 0.450" (11.4mm)



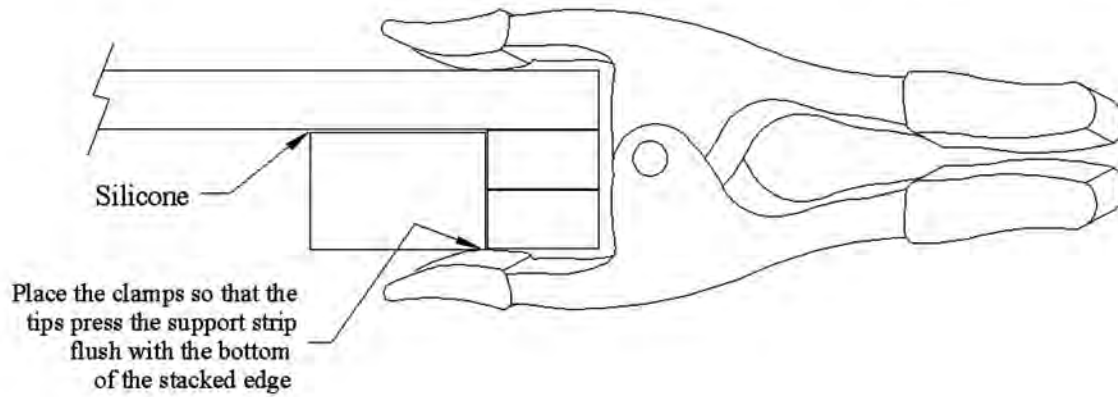
V-Groove cutter set to 0.450 (11.4mm)
Material thickness = 0.485 (12.3mm)



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F. Support Strips for Edges

When using stacked edges, the total thickness of the stacked edges could be as thin as 897 mils. To prevent the support strips from showing under the edges, the MDF or plywood strips should be planed down.



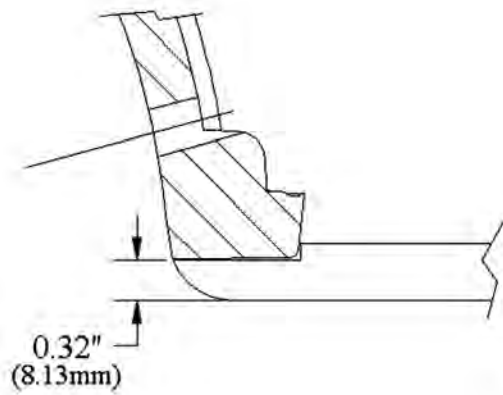
In food service, if using steel tubes for supports, dropped edges should be used.

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G. Sink Seams

There should be very little adjustment needed for attaching sinks. The rebate on the backside of the sheet should be adjusted by 1/16" (1.6mm).

1/8" (3.2mm) Rebate



1/16" (1.6mm) Rebate

