

<p><i>This bulletin summarizes the procedures for use with the DuPont™ Corian® Private Collection in order to produce the installations aesthetically acceptable to the consumer. All typical fabrication and installation requirements, seam reinforcement, for example, must be followed.</i></p> <p><b>CTDC-143 July 2002 (effective 8/1/02)</b></p>	<p>Technical Bulletin</p>
<p><b>Fabrication of The Corian® Private Collection Colors</b></p> <p>The Corian® Private Collection consists of exciting new patterns that will allow you to offer completely unique aesthetics to your customers. For best visual results, you will need to use some new layout and assembly techniques. This Bulletin contains several design ideas to get you started. With experience, you will likely find additional techniques to maximize the beauty of your installations. It is the responsibility of the CFI to be sure to blend the patterning into the assembly. Also, be sure to show samples to your customer to be sure that the blending will meet their expectations.</p> <p>The two series, <b>Palladio</b> and <b>Artisan</b>, have similarities as well as differences in the methods of fabrication. For clarity, each will be discussed separately in the wording below. For complete details of assembly procedures, refer to the “Corian® Fabrication Manual” (C956-H71343).</p> <p>The <b>Palladio Series</b> consists of Camel, Cirrus White, Ecu, and Natural Gray. The <b>Artisan Series</b> consists of Aubergine, Chamois, Slate and Verde.</p> <p><b>Key Fabrication Points:</b></p> <ul style="list-style-type: none"> <li>• All three edge types of assembly methods work with <b>Artisan Series</b>; stack and v-groove edges work best in <b>Palladio Series</b>.</li> <li>• Due to the flakes in <b>Palladio Series</b>, tool life will be shorter than normal.</li> <li>• Corian® Private Collection appears to be softer when finishing so use care to get the proper finish.</li> <li>• The <b>Palladio Series</b> appears to thermoform best at cooler temperatures than normal. Be sure to calibrate your system at the lower end of the temperature range before beginning. See Chapter 16 of the Fabrication Manual (C956-H71343).</li> </ul> <p><b>1. Edge Details</b></p> <p><b>Palladio Series</b> has a very busy and random surface pattern. The edge of the sheet shows the pattern in layers. If a drop edge is used, the surface pattern contrasts sharply with the layers in the edge, therefore a more suitable aesthetic is obtained using a stack edge. A large edge detail, such as a ½” or ¾” roundover makes a smoother transition from the surface to the face of the edge.</p>	<p>DuPont Surfaces Corian® Solid Surfaces Wilmington, DE 19898</p>

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**Artisan Series** has a mix of particles and veins, which runs throughout the sheet. So either a stack or a drop edge will yield satisfactory results. V – groove edges should prove acceptable with the entire Corian® Private Collection line. However, edge details may be limited with **Palladio Series** so as not to expose the layers in the folded down edge piece. For example, a large round over or Ogee design may reveal too much of the inner layers.

## 2. Seams

Because both **Palladio** and **Artisan** have directional patterns, deck seams may require more than a typical 90° butt seam to be acceptable to the consumer. In these cases, a miter seam may give the most acceptable aesthetic. You may find that some colors, especially lighter colors, may yield acceptable results with either seaming method. As always, it is best to have samples showing seaming and edge assembly alternative methods.

When using a miter seam, all requirements for a deck seam, as set forth in the Fabrication Manual must be followed.

When making a miter seam, use the insert block method to get the proper inside corner radius. This combined with two blocks, which are attached to the underside of the deck in the corner, makes for a very strong seam. However, this requires that the reinforcement strip fits against the backside of the first block. (See Fig. 1) There are several ways to accomplish this. Among them are:

- Cut a square notch in the reinforcement strip
- Rout the notch in the reinforcement strip and round the back corner of the block
- Square off the back corner of the block to make a butt seam

Be sure the joint between the reinforcement strip and the corner block is completely filled with adhesive.

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VIEW OF INSIDE CORNER FROM THE UNDERSIDE OF THE COUNTERTOP

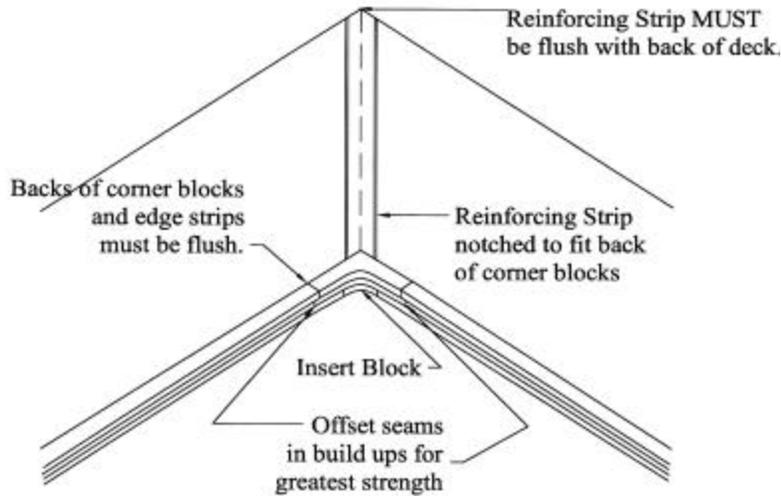
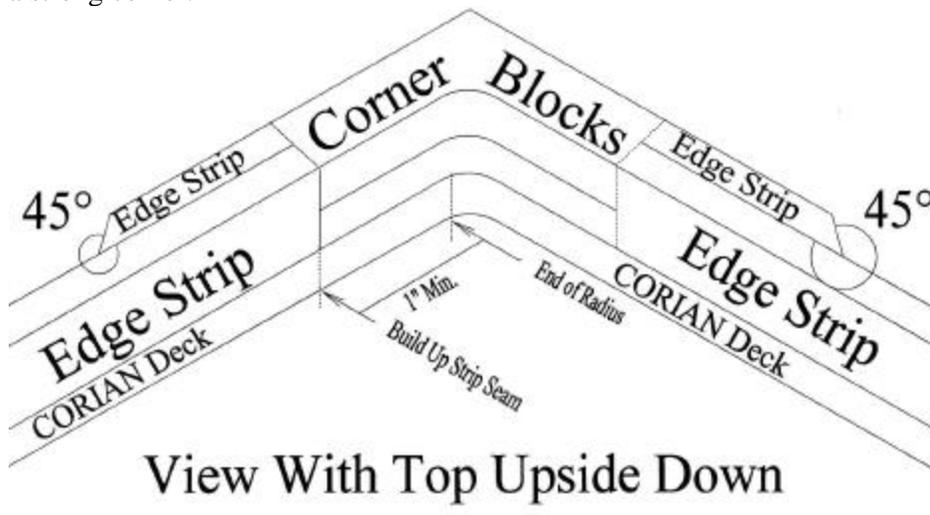


Figure 1

Offsetting the seams in the corner blocks will help strengthen the corner. When using a drop edge, a different method is used for the inside corner to assure a strong corner.



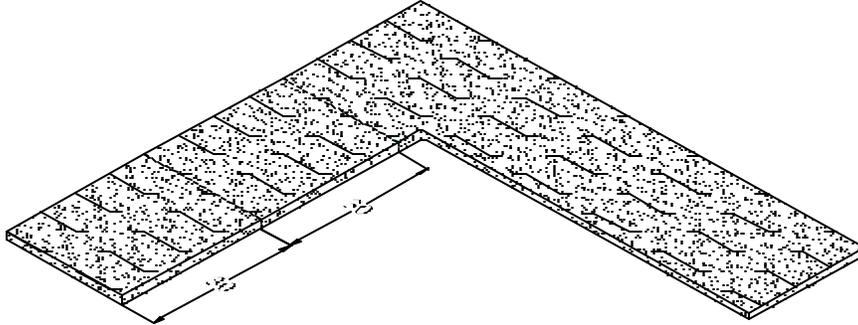
The strips extending from the corner blocks should be at least 3" long and must be fully adhered using joint adhesive.

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For “L” shaped tops with a short return leg, the pattern can be kept running in the same direction by cutting 25’ X 30” pieces and making seams every 30” down the return by gluing them to the long leg.



### 3. Thermoforming

Thermoforming the **Artisan Series** should present no problem as typical setting can be used successfully. The **Palladio Series** requires different heat settings. Preliminary testing indicates that lower temperatures may be successful. Testing is now underway to outline the proper time/temperature settings for Palladio. When finalized, the results will be published under separate notification.

### 4. Finishing

All typical finishing methods are suitable to use on Corian® Private Collection. Darker colors, such as Verde or Slate may have a slightly better appearance with a semi-gloss finish. However, the consumer should be made aware of the proper care and maintenance instructions for either gloss level. When finishing, the Private Collection gives the impression of being softer. This means that greater care must be taken to get an acceptable finish. So, more frequent checks to be sure that scratches are being removed may be in order. The use of low angle lighting will help highlight scratches for removal. It also may be necessary to finish up with a finer than normal grit of abrasive. As always, cleaning the top between grit changes is needed.

In summary, all typical fabrications can be used on the Corian® Private Collection. In addition, all requirements as set forth in Tech Bulletin, CTDC – 117, “**Required Fabrication and Installation Procedures for Corian® Products**” must be followed.

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