FABRICATOR UNIVERSITY

WILSONART® DECORATIVE EDGES
FABRICATION AND INSTALLATION GUIDELINES

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Wilsonart® Decorative Edges may well be the best way to attain leading-edge kitchen and bath design without a leading-edge budget.

The simple addition of decorative edges can transform an ordinary laminate countertop into a real design statement- by eliminating the brown line. In fact, our Decorative Edges are available in all promoted Wilsonart® Laminate designs, and the Virtual Design Library.

The Decorative Edges concept is a simple one. So simple that thousands of qualified fabricators across North America are creating custom looks with laminate-clad Decorative Edges everyday. They are so durable, we've given them a 10-year limited warranty against face edge delamination.

So if you're building or remodeling a kitchen or bath, Wilsonart® Decorative Edges are the affordable design option you just can't afford to overlook.

The Bevel Edge FE-Flat Edge and SE-Snap Edge

- Creates a sleek, seamless look with strong, crisp and classic lines, evoking the polished image of cut and chamfered stone.

The Crescent Edge FE-Flat Edge and SE-Snap Edge)

- A soft curve that mimics the "bullnose" granite edge. This versatile edge blends into most any kitchen or bath design. The perfect finishing touch to your "I can't believe this isn't real granite" countertops.

GUARANTEED 10 YEARS

Unlike some other decorative edge products, laminate-clad Wilsonart® Decorative Edges are made with medium density fiberboard (MDF), to which decorative laminate is bonded. Because of this assembly technique, it's practically impossible for the face edge of the molding to delaminate. In fact, we have so much confidence in the performance of Wilsonart® Decorative Edges we back them with a 10-year warranty against face edge delamination. See your distributor of Wilsonart® products for complete details.

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 is the responsibility of the facility owner and the shop employees.

CAUTION: Always follow product, equipment and/or tool manufacturer's recommendations and instructions carefully.

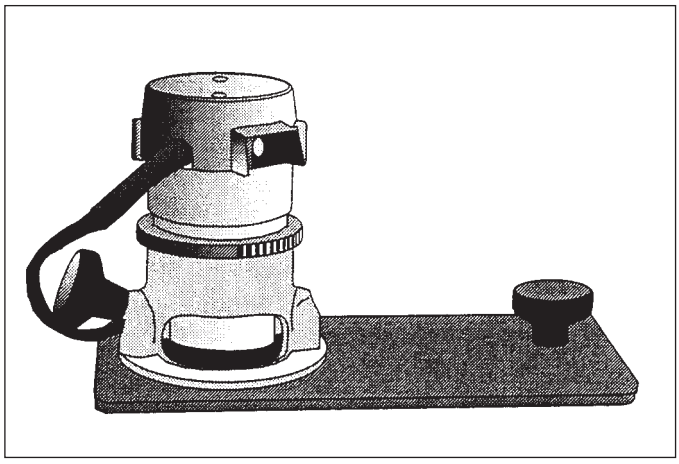
- Read directions carefully before fabricating/installing Wilsonart® Decorative Edges.
- Read and follow instruction manual before operating the different tools.
- Keep all guards in place and in working order.
- Insure all tools are properly grounded. Never remove the third prong.
- Keep work area clean, 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. 3A & 3B)
- 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.

FIG 4A

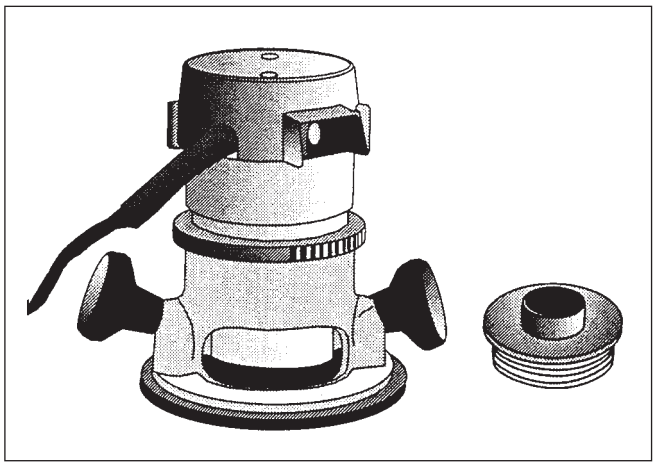
FIG 4B

STORAGE

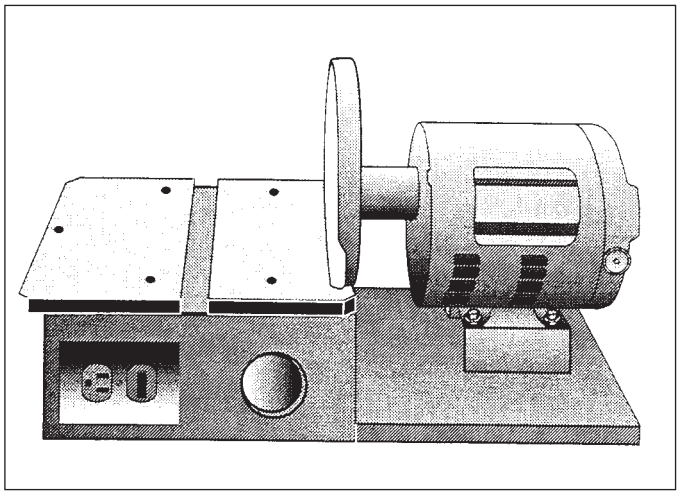
Keep Wilsonart® Decorative Edges in original packaging until ready to fabricate. It is best to store the product in this packaging to eliminate warping and possible damage.



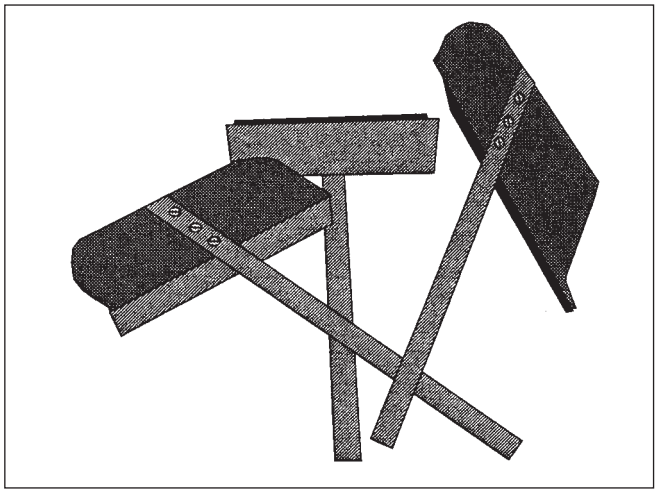
Router with ¼” Dado cutter



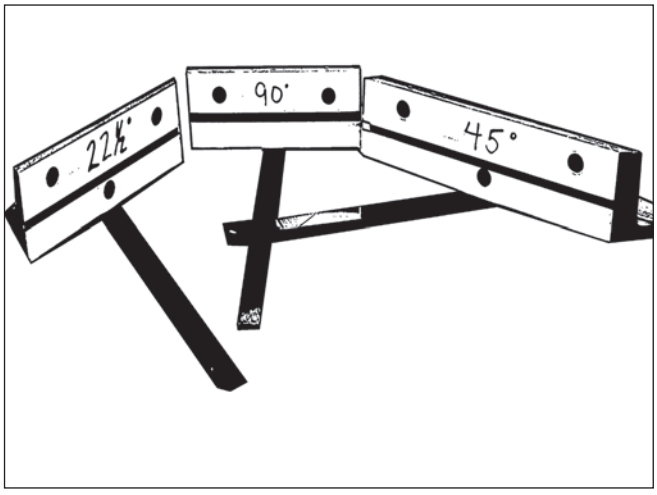
Clipped Corner Router and
Template Guide



10” Disk Sander

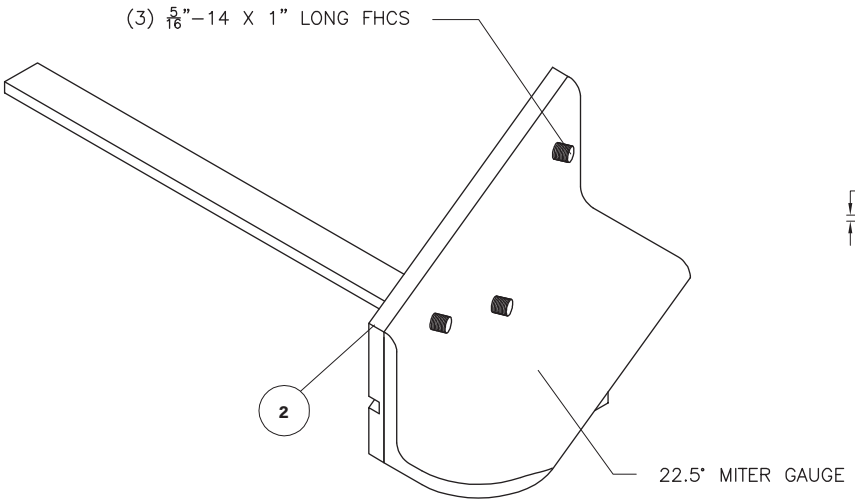


90°, 45°, 22-½° Miter Gauges

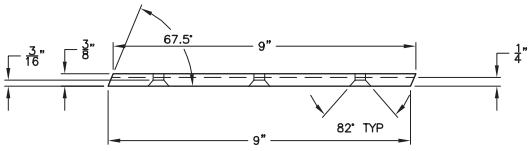


90°, 45°, 22-½° Attachment Plates

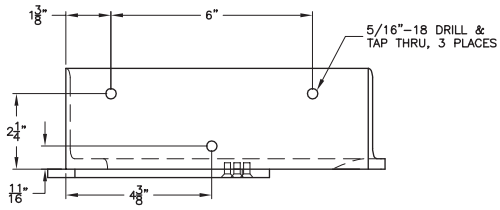
These are the guilines for building your own plate attachment for use with Crescent SE MOUNTING styles.



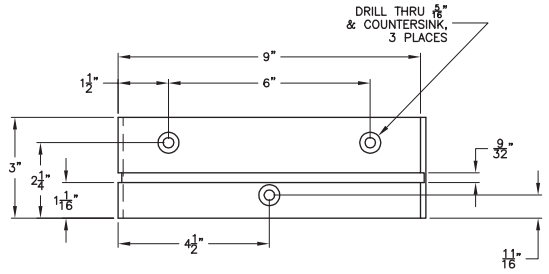
22.5° MITER GAUGE
ASSEMBLY VIEW
NTS



2 22.5° COMPACT GUIDE
TOP VIEW
MATERIAL: 3/8" COMPACT LAMINATE

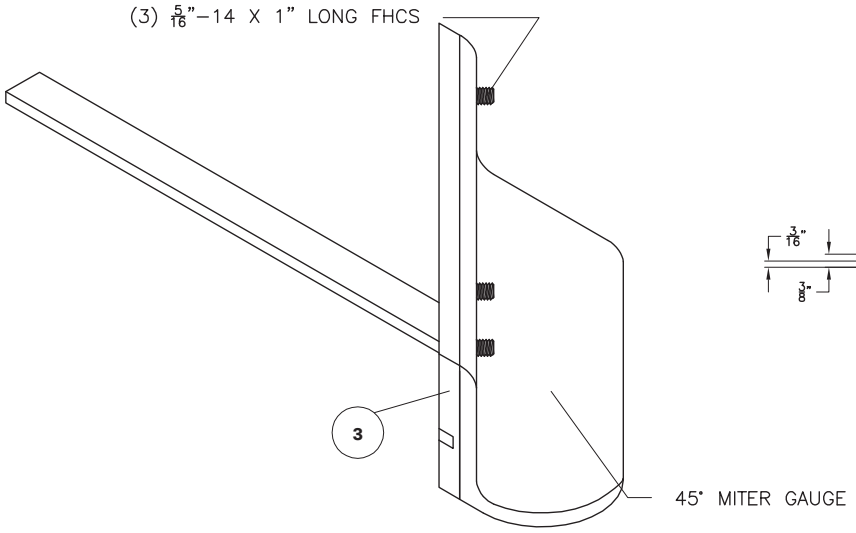


22.5° HOLE LOCATION
FRONT VIEW

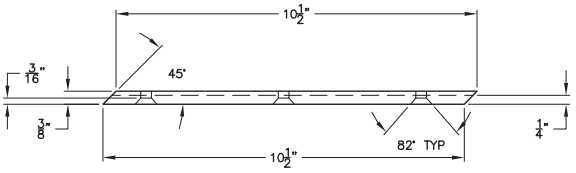


2 22.5° COMPACT GUIDE
FRONT VIEW
MATERIAL: 3/8" COMPACT LAMINATE

These are the guilines for building your own plate attachment for use with Crescent SE MOUNTING styles.



45° MITER GAUGE
ASSEMBLY VIEW
NTS



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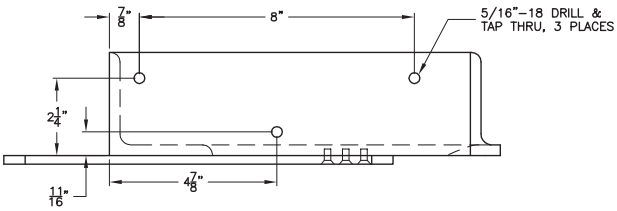
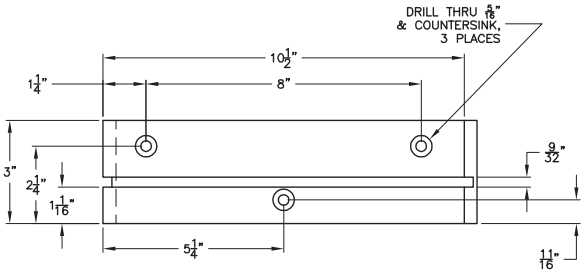
45° COMPACT GUIDE
TOP VIEW
MATERIAL: 3/8" COMPACT LAMINATE



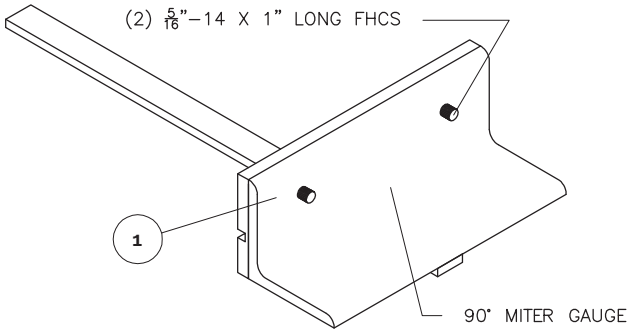
45° HOLE LOCATION
FRONT VIEW



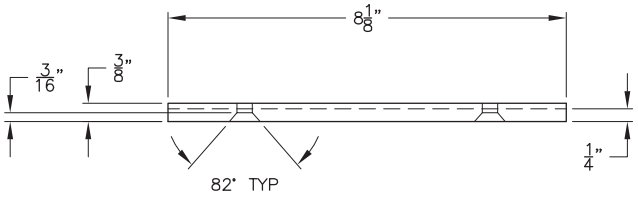
3

45° COMPACT GUIDE
FRONT VIEW
MATERIAL: 3/8" COMPACT LAMINATE

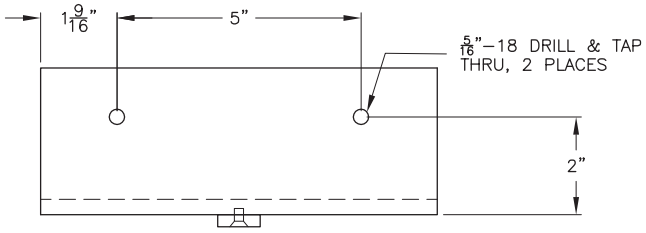
These are the guilines for building your own plate attachment for use with Crescent SE MOUNTING styles.



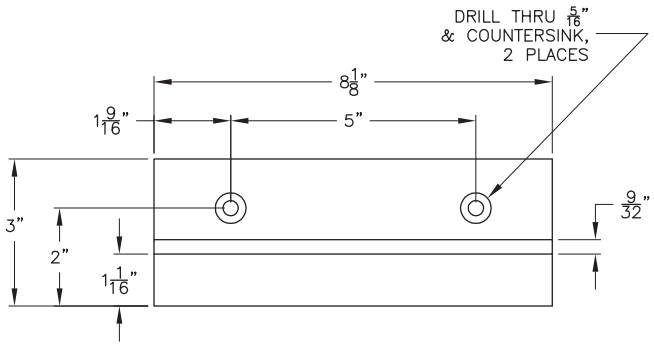
90° MITER GAUGE
ASSEMBLY VIEW



1 90° COMPACT GUIDE
TOP VIEW
MATERIAL: 3/8" COMPACT LAMINATE



90° HOLE LOCATION
FRONT VIEW



1 90° COMPACT GUIDE
FRONT VIEW
MATERIAL: 3/8" COMPACT LAMINATE

Cut the substrate to the desired size, (top should be ⅛" larger) place the substrate face side up on a flat work surface and thoroughly brush the substrate surface clean.

Place a 90° miter gauge on the front of the countertop. Place straight edge against miter gauge and align along the edge of the countertop. Hold the miter gauge firm against counter, check the straight edge to see if it is flush with the countertop edge. If the straight edge is flush with your countertop, the countertop is square. If not, back the straight edge up approximately ⅛" keeping it square against the miter gauge. (FIG. 9A) Clamp the straight edge into place.

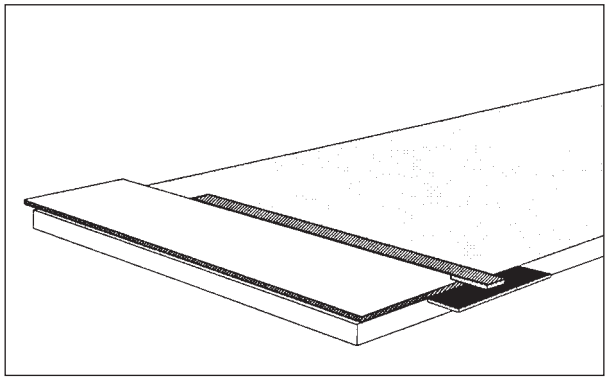


FIG 9A

Clamp straight edge to the edge that is to receive the decorative edge. Working left to right, trim off approximately 1⁄16" from the countertop. Use a router with 2 flute cutter and template guide. Do the same for all edges to receive a decorative edge. (FIG. 9B)

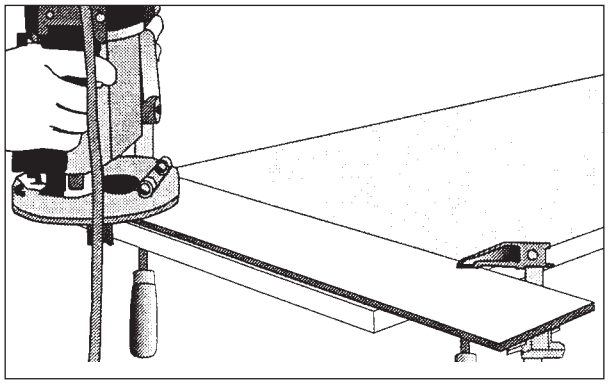


FIG 9B

FAB TIP: Exercise care to assure a chip-free machined edge surface.

When using SE-style edges, use the ¼" Dado Cutter to machine the dado into the substrate. Always rout in a left to right direction, using a smooth consistent motion. (FIG. 9C)

FAB TIP: When using FE-style edges, it is recommended to attach build-up support strips to the countertop prior to dry-fitting. Build-up strips must be flush with edge of countertop.

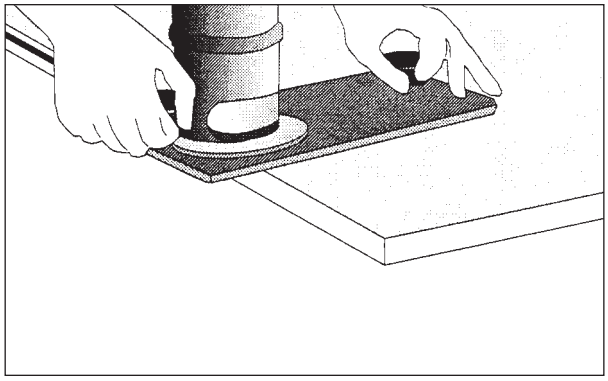


FIG 9C

Measure the substrate edge and rough cut the edges (working in a right to left direction). Leave at least three quarters of an inch (¾") of excess on both ends of the edge piece. (FIG. 9D)

Using a disc sander to miter the edges of Bevel SE or FE style edges, start with the edge's laminate side to miter gauge with the bevel side up, sand the edge to a miter. Alternate the edge - bevel up/bevel down - for each miter. Always keep the laminate side to the miter gauge. (FIG. 10A on next page)

FAB TIP: Inside corners will cause you to change the direction of the miter gauge on the disk sander.

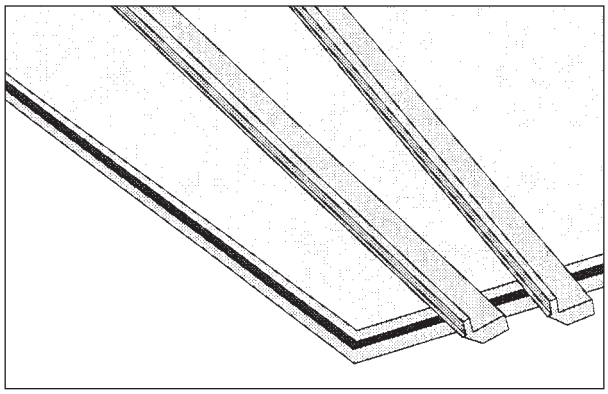


FIG 9D

When sanding the mitered edge for Crescent SE style edges, use the modified miter gages with plate attachments (FIG. 10B). Insert the ¼" wood tongue of the SE edge into the dado slot in the plate attachment. Alternate the tongue up and down in the dado slot for each miter. Always keep the wood side to the miter gauge and plate (FIG.10C).

FAB TIP: Inside corners will cause you to change the direction of the miter gauge on the disk sander.

When using a disc sander to miter edges on the Bevel FE and Crescent FE style, use standard or modified miter gauges. Keep wood side of the edge to the miter gauge for Crescent style edges. The miter gauge should be on the left side of the sander to create inside corners and on the right side to create outside corners when using Crescent edges.

Working right to left, dry fit each piece. Use a rubber mallet to dry fit SE style edges into the dado groove around the top of countertop. FE style edges, use filament tape.

Use a sharp pencil to mark the miter position of your pieces. Repeat this step for each additional piece. (FIG. 10D)

Sand your miter to the precise length you have marked, and brush all the edge pieces clean. Always use a disc sander, not a miter saw, to finish all miters.

CAUTION: After dry fitting and scribing the edges, carefully remove them and prepare the edges for adhesion to the countertop.

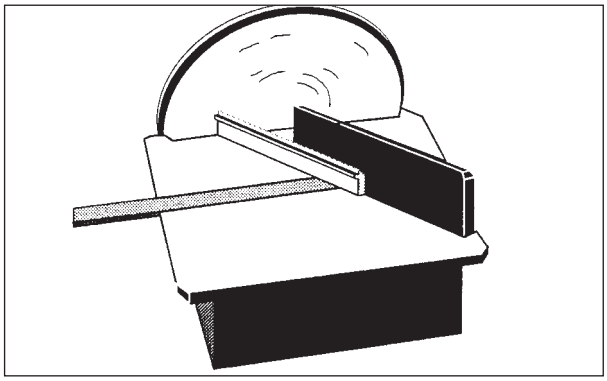


FIG 10A

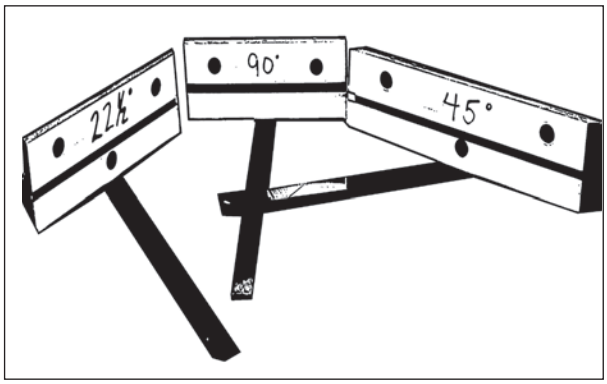


FIG 10B

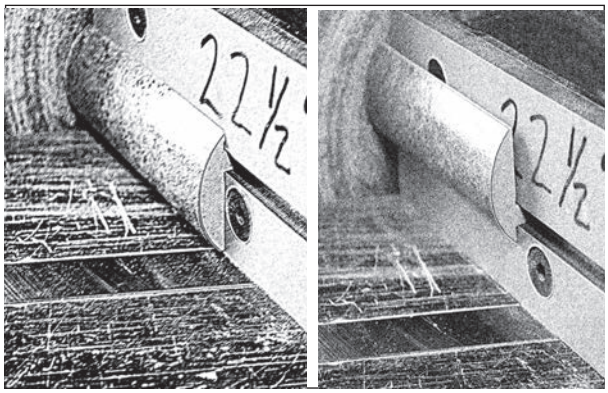


FIG 10C

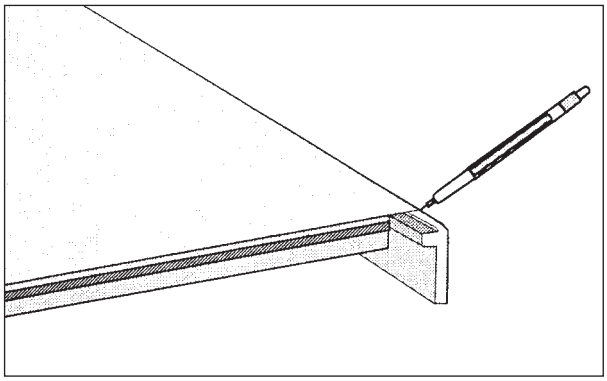


FIG 10D

Apply a bead of Wilsonart® Type II Adhesive to the top and bottom inside corner of the SE-style edge tongue. (FIG. 11A & 11B)

Smooth out the bead of Wilsonart® Type II Adhesive on the top of the tongue with the tip of your finger. (FIG.11C)

When adhering FE-style edges, apply a sufficient (¼") bead of Wilsonart® Type II Adhesive and spread adhesive to the entire wood area of the FE edge. One hundred percent (100%) squeeze-out is required on top of the molding (a 1⁄16" or less).

FAB TIP: Small beads of adhesive squeeze-out is recommended on top of the molding. (a 1⁄16" or less)

CAUTION: Use care not to slide your finger over the laminate edge of the product. It is sharp and will cut your skin.

Apply vertical strips of filament tape over the length of the edge every 3" - 4" to hold the edge in place until the adhesive dries. (FIG. 11D)

FAB TIP: For better adhesion, clean laminate surface with denatured alcohol. Apply the tape to the face of the molding using upward pressure.

FAB TIP: Twist end of filament tape to make removal easier.

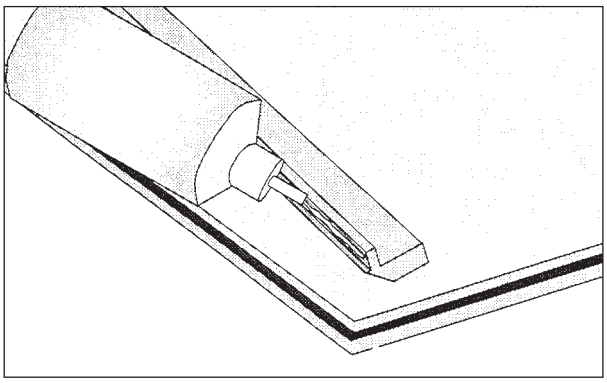


FIG 11A

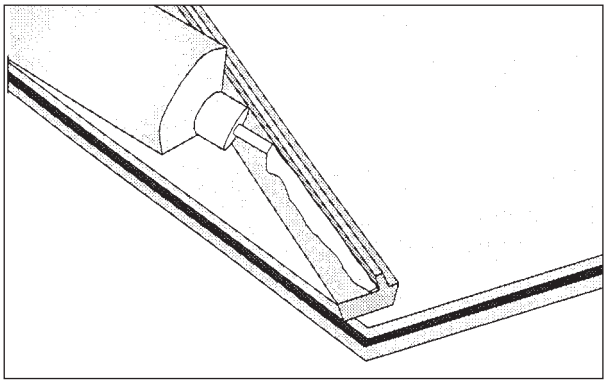


FIG 11B

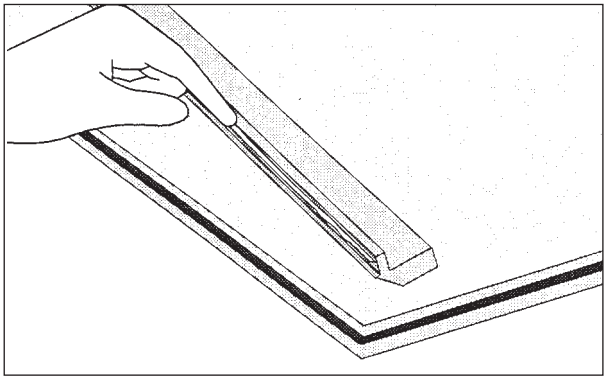


FIG 11C

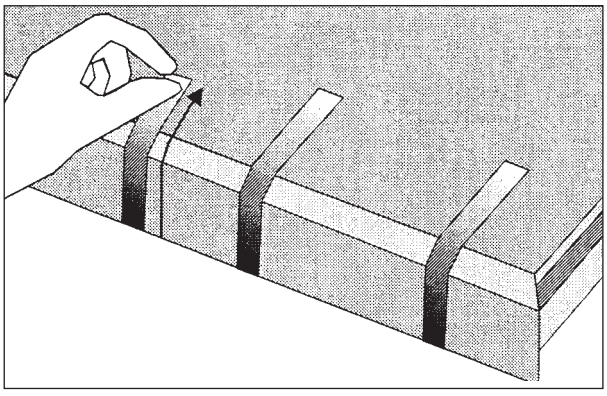


FIG 11D

Put a small amount of Wilsonart® Type II Adhesive on the trailing end of each edge piece before installing it. Then, use filament tape to hold the corners in place while the adhesive dries (approximately 30 min.) (FIG. 12A)

FAB TIP: Excessive glue squeeze-out on top of the bevel may cause separation from the countertop. When squeeze-out occurs, wipe off with a damp cloth immediately.

It is recommended to turn the top over (face down) and add build-up/build-down strips to all exterior edges of the substrate that have received SE-style edge strip. (FIG. 12B)

FAB TIP: When using FE-style edges, it is recommended to attach build-up support strips to the countertop prior to dry-fitting.

When adding the build-up/build-down strips, it is recommended that Wilsonart® Type II Adhesive and staples be used, to attach the strips.

FAB TIP: When using FE style Decorative Edges use a laminate faced wood block and 3” pinch clamp to maintain correct height of molding to the laminate countertop edge.

CAUTION: Exercise care when selecting the length of the staple to be used when attaching build-up/build-down strips. Inappropriate length staple(s) will cause damage to the top surface.

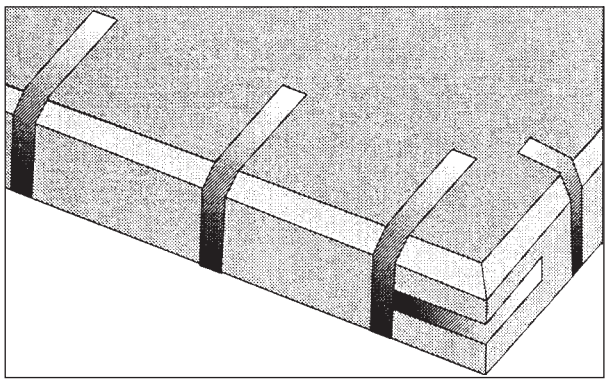


FIG 12A

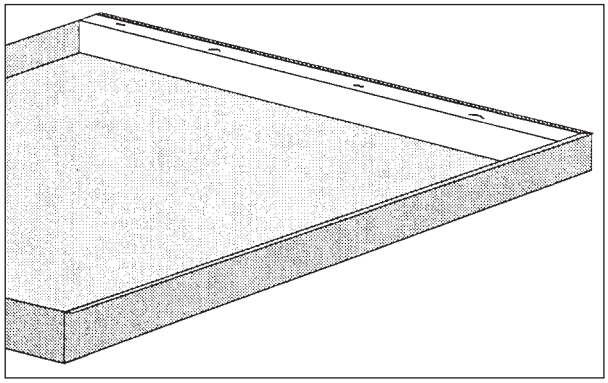


FIG 12B

CLIPPED CORNERS

Typically, the design for a custom built countertop with a Wilsonart® Decorative Edge will contain at least one 90° outside corner. Although these corners are cosmetically pleasing to the eye, a customer may request that you soften the 90° angle by "clipping" the corner(s). The following is an efficient and accurate method for clipping 90° outside corners on a pre-laminated top.

On a pre-laminated substrate that contains a 90° outside corner, use a Straight Cut Planer to machine both substrate edges to which the edges will be fitted.

Invert 45° miter gauge and place onto the countertop. Align the end of the gauge with the edge of countertop (FIG. 13A). Using a pencil, draw a line onto the countertop along the front edge of the miter gauge. This will establish the correct 45° at which to machine the "clipped" corner (FIG. 13B).

Align straight edge on line and clamp.

FAB TIP: The 45° miter gauge accurately positions the pencil line so that the clip corner router can be used to machine the substrate.

CAUTION! This procedure is based upon the countertop overhanging the cabinet face by 1-inch on both sides of the corner. Additionally, the clip corner router is fitted with a special 6½" diameter base plate. If you choose to use a router having a base diameter other than 6½", it is necessary to adjust the position of the traced line.

You are now ready to apply the SE or FE style edges.

Follow steps in Fabrication Techniques for the Decorative Edge of your choice.

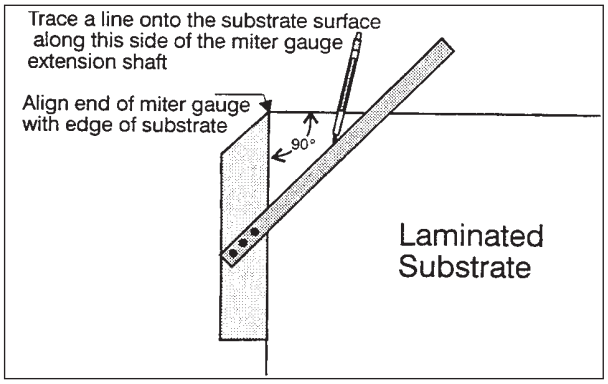


FIG 13A

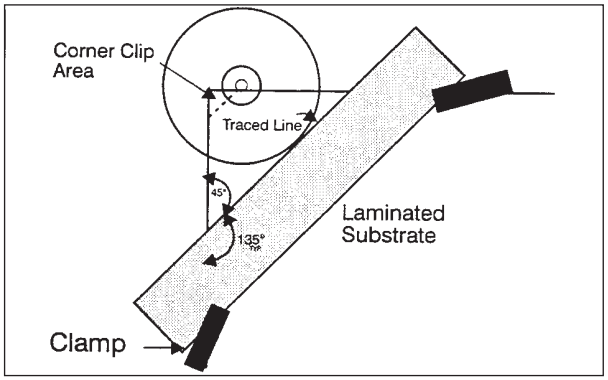


FIG 13B

BUILDING A TEMPLATE

Construct a Template (FIG. 14A) This can easily be accomplished by cutting -½" wide strips from ¾" particle board that has been laminated on both sides. After cutting the strips to the appropriate lengths, align the longest strip against the drawn line (on the laminated substrate) and secure in place with standard laminate clamps. Use 1¼" Phillips head drywall screws to complete the Template assembly.

Position the Template onto your countertop substrate and secure in place using standard laminate clamps at the locations. (FIG. 14B)

FAB TIP: Machining through ¾" countertop (with a ½" bit) can produce a poor quality cut on the edge surfaces of the substrate. It is always best to first make a rough cut and then a second finishing cut. This procedure can more easily be accomplished by attaching (with filament tape) a strip of laminate to the front side of the Template. (FIG. 14C)

Make the first (rough cut) with the laminate between the router base and the Template. (FIG. 14D) Then, flip-up the strip of laminate (using the tape as the hinge) and make the second (finishing) cut. The result will be a finish cut that is equal to one produced by the Straight Cut Planer. Complete the procedure by removing the Template from your countertop. Your "clipped" corner is now ready for the machining of the dado groove. Upon completion of that step, installation of the Decorative Edges around the clipped corner can be easily accomplished by mitering the Decorative Edge with a 22½° miter gauge.

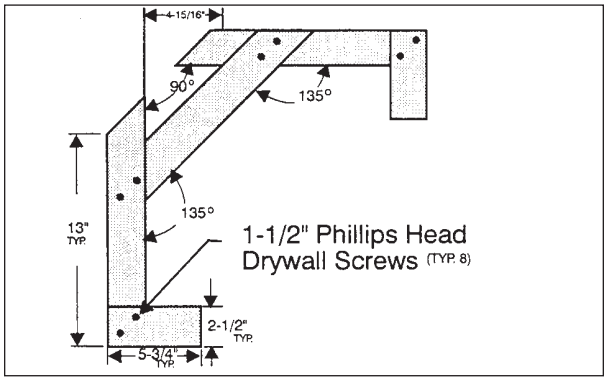


FIG 14A

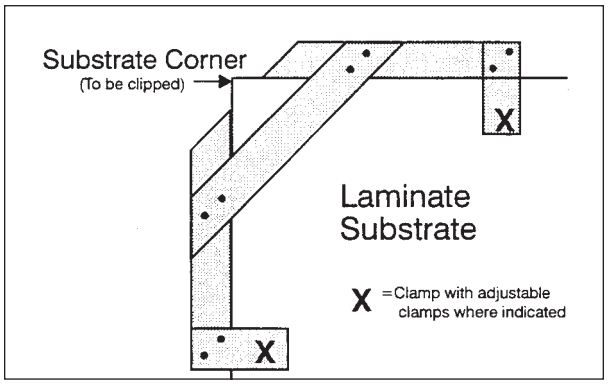


FIG 14B

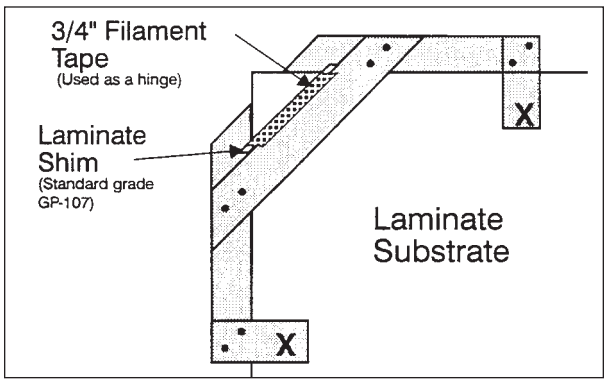


FIG 14C

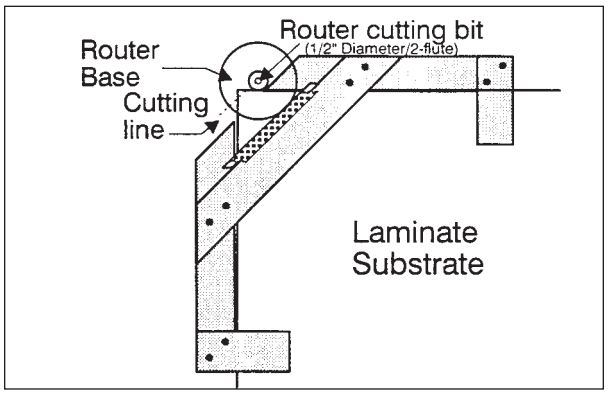


FIG 14D

Only the FE (Flat Edge) Crescent Edge profile is recommended for creating laminate countertops with a radius. The radius must not be tighter than a 48” radius. (Please see FIG 15A)

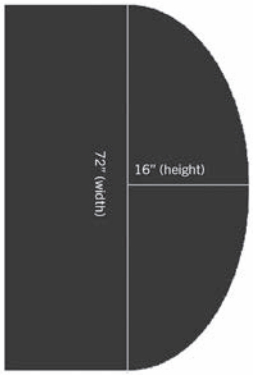


FIG 15A

After cutting the countertop and flush trimming the laminate, apply build-down material with Wilsonart® Type II Wood Glue. After the build-down is applied, ensure all sides receiving a Wilsonart® Decorative Edge are cleaned and squared with either a straight cut-planer or a straight edge and router.

Using a router with a clamped straight edge as a guide will ensure that the sides are as smooth as possible before applying the Decorative Edges. Do not use a belt sander or laminate trim router to prepare sides to receive Decorative Edges.

When fabricating a radius, we suggest attaching a router to a long straight edge that will allow the appropriate arc/radius on the pre-measured and marked top. Other options include using a CNC, point to point, or any other specialty radius tooling to create the arc/radius.

If tooling is limited, you may also use a string and pencil to make a template by transferring radius measured and developed with a center pivot point.

Minimum 48” radius for FE style Crescent

Calculating the radius:

Formula: (width x width) ÷ (8 x height) + (height ÷ 2) = radius

Example: (72 x 72) ÷ (8 x 16) + (16 ÷ 2) = radius 5184 ÷ 128 + 8 = 48.5 radius

FIT THE WILSONART® DECORATIVE EDGE

Start by rough cutting all the Decorative Edges pieces. Rough cut and dry fit the Decorative Edges to the desired length and smooth the cut using a disc sander. Trim a minimum 1” from both ends of the Wilsonart® Decorative Edge.

Divide the angle finder dimension by two to get your miter angle. An angle finder is the easiest way to identify the angle at the corners where the radius connects to the straight lines of your countertop.

FAB TIP: We recommend using an adjustable miter gauge on a disc sander to make any slight adjustments to provide you the best fit at mitered corners. Use scrap pieces from the rough cutting stage to accurately set up the adjustable miter gauge prior to using precut edge material.

Repeat these steps for all Decorative Edges.

Glue the Wilsonart® Decorative Edge

Using Wilsonart® Type II Adhesive, apply two ⅛" beads to the top and bottom areas of the flat backside of the Decorative Edges. Do not use contact adhesive.

Smooth the adhesive with scrap laminate material and apply edge to the prepared substrate. Use fiber-reinforced tape applied every two to three inches down the length of the edge and around the corners vertically to secure miter corners.

Use a laminate faced wood block and 3" pinch clamp to maintain correct height of the edge to the laminate countertop edge. See FIG 16A.

FAB TIP: Excessive glue squeeze-out on top of the bevel may cause separation from the countertop. When squeeze-out occurs, wipe off with a damp cloth immediately.

Move the block and clamp to each taping location during the taping process to secure a flush application. Twist one end of your tape to make removal easier.

Use 3-way clamps at both sides of the radius and miter intersection to secure the edge to the countertop. Apply tape around the corner to pull miters tight.
See FIG 16A.

Wipe off any excessive glue squeeze-out with a damp cloth.

Allow glue to set under pressure for 45 minutes to an hour, then remove all the tape and clamps. Remove adhesive residue by scraping with a scrap piece of laminate or edge. A scrap piece of edge can be rubbed over the seams to smooth any sharp edge. A matching dry erase marker or Wilsonart® SeamFil® can also be used to touch up seam areas.

FIG 16A

INSIDE CORNERS

The Wilsonart® Decorative Edges product line utilizes a system approach for the fabrication of custom designed tops. The system provides precision high pressure decorative edges in various styles and designs, along with unique fabrication equipment, specifically designed to work within the product tolerances. All of these are important elements that make the system work. Wilsonart has designed a simple template that takes the guess work out of inside corners.

The inside corner templates are available from Specialty Tools at specialtytools.com, in 45° and 90° angles (Speacialty Tools SNAP EDGE System, 800.669.5519). The templates can assure quality fabrication by following these simple fabrication steps.

Oversize countertop by ⅛". Position inside corner template ⅛" from edge of countertop.

FAB TIP: Make sure you are ⅛" from the edge of the counter on both sides of template. (FIG. 17A)

Clamp template into place. Using a mechanical pencil trace a line on the inside of the template. (FIG. 17A)

FAB TIP: Double check your measurements to assure accuracy.

Use a router with a straight double flute bit and template guide to rout inside corner. (FIG. 17B) Remove inside corner template and feel edge for smoothness.

FAB TIP: Porter-Cable®, Template Guide #42046 (⅝")

Take straight edge and align it with pencil mark on countertop. (FIG. 17A)

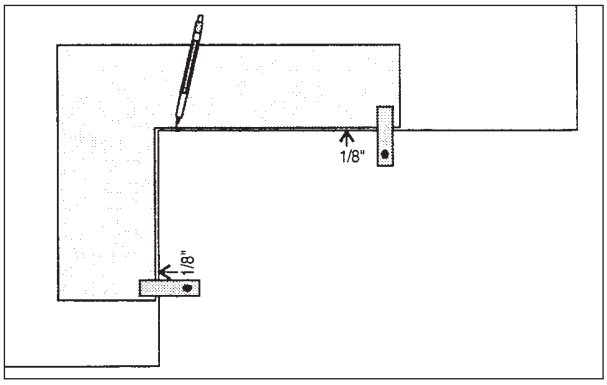


FIG 17A

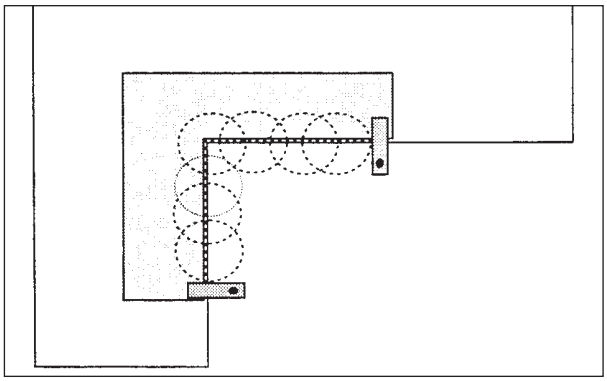


FIG 17B

FAB TIP: Make sure you are ⅛" away from edge at end of counter.

Clamp straight edge into place. (FIG. 18A) Rout edge with Router, double flute bit and template guide. (FIG. 18B)

Remove template.

If using the SE-style, you are now ready for your Dado cutter.

FAB TIP: The template guide causes a 1/16" separation between the bit and the guide. The ⅛" distance that you position your straight edge and inside corner template from the edge of the counter will allow you to trim 1/16" away from the substrate. This method will eliminate the use of the straight cut planer.

Cut and fit all edges.

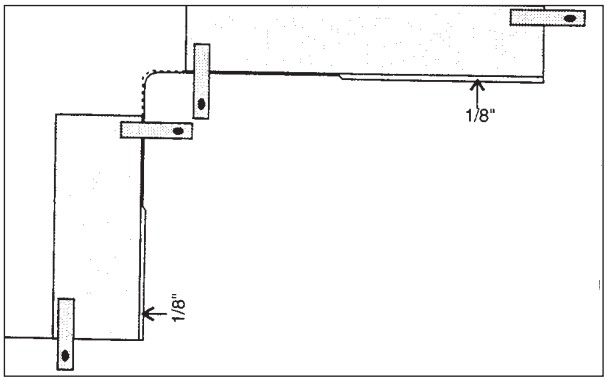


FIG 18A

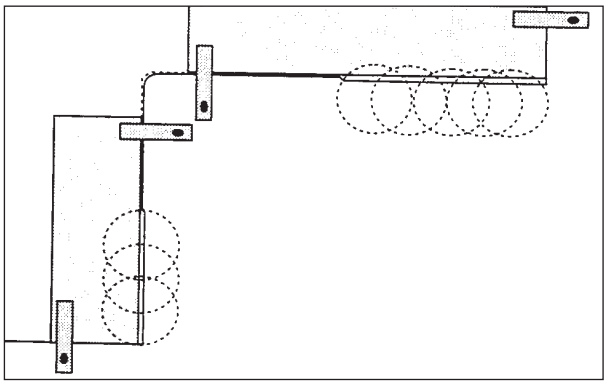


FIG 18B

The Specialty Tools SNAP-EDGE System, from Specialty Tools,at specialtytools.com, is a complete straight edge system that is designed to work with only two clamps no matter how long the run. Inside corners are no longer the time consuming hassle they have been in the past. The Specialty Tools system eliminates all of the guess-work and time consuming fabrication steps currently involved in inside corner fabrication. By placing the Specialty Tools system onto the work surface and applying one clamp at each end of the system, planing or routing can be done in one continuous step.

The system includes one of each: SNAP-EDGE 5”X94” Straight Edge, SNAP-EDGE 5”X48” Straight Edge. SNAP-EDGE 5”X31” Straight Edge and a SNAP-EDGE 90 degree inside Corner.

Other sizes available at specialtytools.com or call 800.669.5519 for prices and availability.

Follow these steps to use the Specialty Tools straight edge system with Wilsonart® Decorative Edges.

Set Specialty Tools system onto square prelaminated countertop for assembly. (Follow straight edge instructions for proper assembly)

Align system ⅛” from the edge of countertop. (FIG. 19A)

Place one clamp at each end of countertop to hold the system into place. (FIG. 19A)

Double check measurements to assure accuracy.

Place router (with two fluted cutter and template guide Porter-Cable® #42046) onto straight edge and rout the front edge of the countertop. (Always rout from left to right) (FIG. 19B)

Remove clamps and straight edge system. Porter

You are now ready for the dado cut.

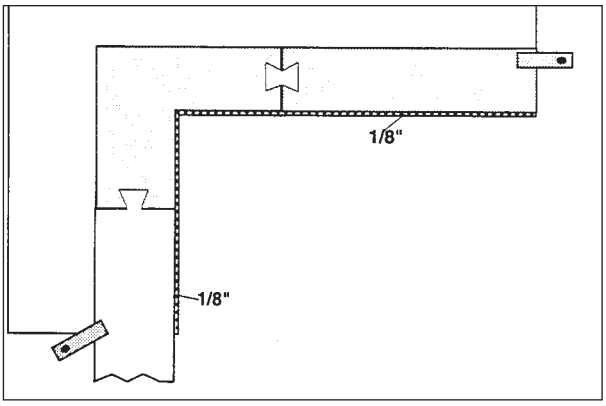


FIG 19A

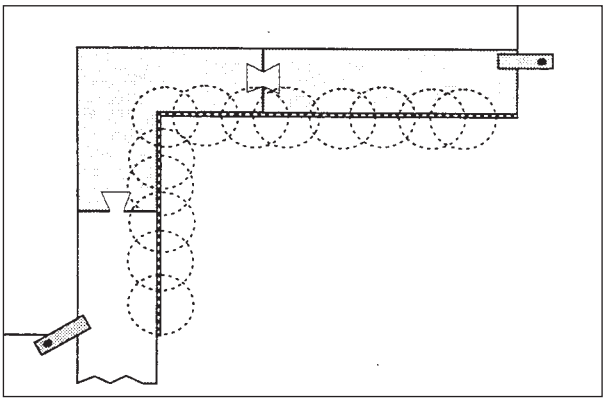
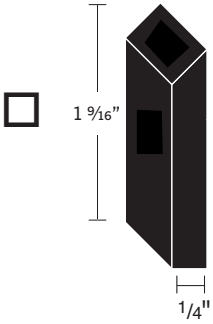
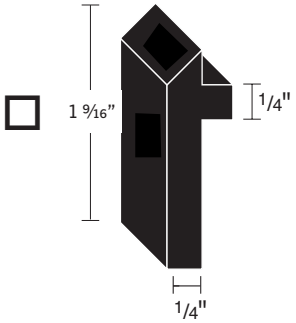


FIG 19B

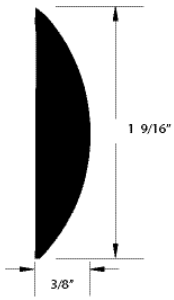
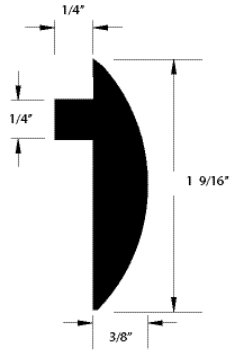


Beveled Profile (FE)



Beveled Profile (SE)

Crescent Profile (FE)



Crescent Profile (SE)