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## 1. DuPont™ Corian® Illumination Series

The DuPont™ Corian® Illumination Series allows you to see DuPont™ Corian® in a whole new light. While some colours of DuPont™ Corian® sheet have always been translucent, the DuPont™ Corian® Illumination Series allows up to three times as much light to pass through the sheet, while still maintaining the DuPont™ Corian® properties you have come to count on. The Illumination Series are thermoformable, repairable, seamable ... and comes only from DuPont

### FABRICATION / INSTALLATION CONSIDERATIONS FOR BACKLIT DUPONT™ CORIAN® ILLUMINATION SERIES APPLICATIONS

#### *Overview*

The DuPont™ Corian® Illumination Series can be fabricated in the same manner as DuPont™ Corian®. When there is no backlighting few changes in fabrication are required. When a light source is placed behind the sheet there are some additional considerations. This document will help you understand how to fabricate for best appearance.

This document discusses the basics of changes to fabrication techniques required by the higher translucency of these materials. Refer to the DuPont™ Corian® Fabrication Manual for details on fabrication techniques referenced in this document. The increased translucency and use of backlighting allows the use of this material in new and unique applications requiring advanced fabrication and lighting techniques beyond the scope of this bulletin. It is important to work with your customer, test samples to help demonstrate the design, and ensure your customer is satisfied with the final product.

The new Translucent White (TW) DuPont™ Corian® Joint Adhesive has been specially formulated to work with the DuPont™ Corian® Illumination Series. This adhesive is more translucent and will better match the appearance of the sheet when backlit. However, results will vary depending on fabrication/installation conditions.

*It is important for backlit applications that all inspection and quality checks are done both with room lighting and with backlighting. Some fabrication defects will not be visible until the sample is backlit.*

#### *Seaming*

Seam quality is critical for appearance. Seams may be more visible when backlit than with typical room lighting. A higher quality mirror-cut tight seam will minimize the visibility of the seam. Make sure no interior voids are present in the adhesive as they will be visible when the seam is backlit. Place the seams where they are less likely to be noticed. This could include corners or locations where the light source or supports create a shadow.

If a tight seam is not achieved the seam may be visible. The visible adhesive may change appearance depending on the lighting, appearing darker than the sheet if not backlit, and lighter than the sheet if backlit. **Do not use excessive pressure.** Enough adhesive needs to stay in the joint to create a strong seam.

*If the application involves backlighting, excess adhesive on the back side must be removed or it will create a shadow due to the increased thickness. The sheets needs to be sanded and properly finished both side.*

When removing the adhesive on the back side the finish should be blended in with the surrounding finish as extreme differences in finish may be perceived as lighter or darker areas. After seaming it is important to examine the seam with the type of backlighting to be used in the final installation. Lighting type, intensity, angle, etc all may affect seam visibility. Examine the quality of the seam and ensure that adhesive removal did not create a visible change in appearance.

### ***Backlighting***

Backlighting can be a key part of designs using the DuPont™ Corian® Illumination Series. Lighting technology, particularly LED lighting, is changing rapidly and each technology has its own design considerations. The preferred type of lighting will depend on the desired effect.

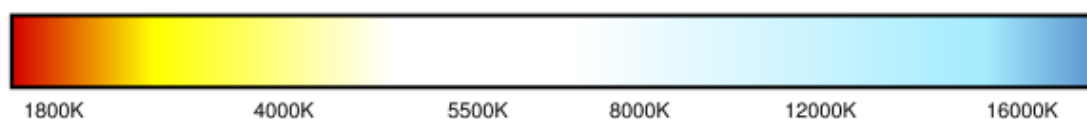
***CAUTION: While this product has a good rating for flammability, the DuPont™ Corian® Illumination Series aesthetics are not intended to be used in applications lit with or near flames.***

***NOTICE:*** *An important consideration in the overall design is the amount of heat generated from the light source. If DuPont™ Corian® sheet is heated from one side, thermal expansion may cause warp. In an enclosed lighting application, the design needs to accommodate the amount of heat generated by the light source and ensure that the enclosure does not overheat.*

***NOTICE:*** *DuPont™ Corian® Illumination Series colours are not recommended for situations where product is exposed to direct sunlight.*

*The type of backlight used can have a serious impact on the final result of the design piece. Each type of light has his own specificity and white light is not just white light, the range of can go from very warm to cool. Herewith you find some basic information to guide you when selecting the type of light, for more details please consult a lighting specialist.*

*To categorize different light source the colour temperature of the thermal radiation from an ideal black body radiator is defined as equal to its surface temperature in Kelvin is used. The colour temperature give an indication of the appearance of light the below figure shows the relation between the temperature in Kelvin and the light appearance.*



*Fig.1: Colour temperatures*

Herewith you find some pictures showcasing the effects that can be noticed when using different kind of light colours as light source for backlighting the Illumination series.

Each picture shows the colours in 6mm (left part) and 12mm (right part) backlit with 4 fluorescent lamps with different colour temperatures: 2700K, 3000K, 4000K and 6500 K.

Standard white LED light source have a colour temperatures in the range of 6500K.



**2700 K: Incandescent White**

**3000 K: Warm White**

**4000 K: Cool White**

**6500 K: Cool Day light**

Fig 2: Backlighting test set-up

NOTE: The following pictures are just indicative to give an idea of the possible effects due to the colour temperature. The colours on the pictures might be different of the real application.

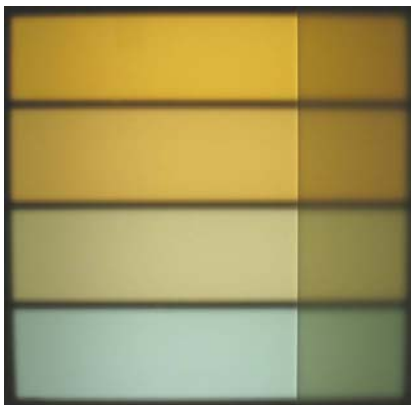


Fig. 3: Glacier Ice (6mm and 12mm)

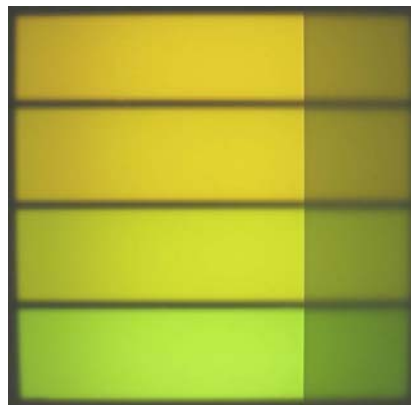


Fig. 4: Lime Ice (6mm and 12mm)

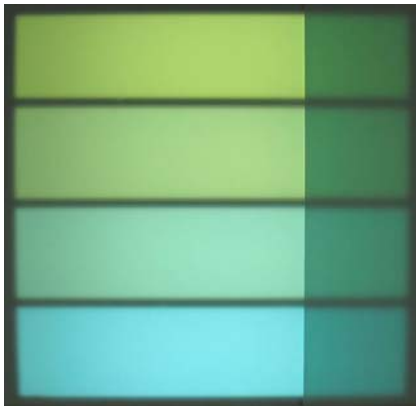


Fig. 5: Mint Ice (6mm and 12mm)

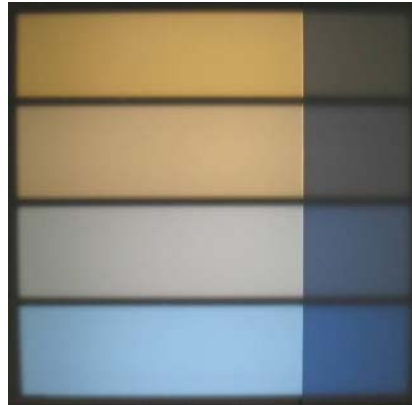


Fig. 6: Blueberry Ice (6mm and 12mm)

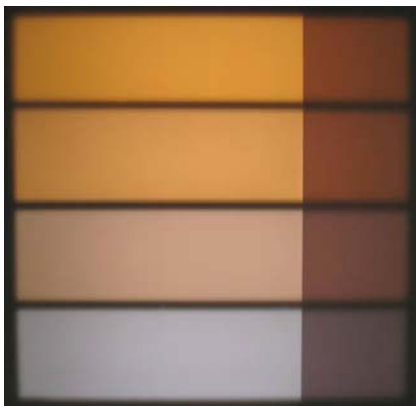


Fig. 7: Strawberry Ice (6mm and 12mm)

### **Placements of the light source**

The distance between the light source and the DuPont™ Corian® panel depends on different parameters like: the type of light source, required effect, thickness of the panel.

As a rule of thumb a distance of +/- 15 cm between the light source and the DuPont™ Corian® panel can be used.

### **Thermoforming**

The DuPont™ Corian® Illumination Series can be formed using similar conditions and methods used for other DuPont™ Corian® colours except lower temperatures and heating times are recommended. While forming is the same, defects are more readily seen with backlighting and will appear differently when backlit.

Slight colour shifts may occur during the thermoforming heating process. Due to the increased translucency in these colours the colour change may be more noticeable. The change is a function of both the time and temperature of heating. To minimize colour shift use the minimum time and temperature necessary to achieve the desired shape. ***The maximum time and temperature recommended is 12 minutes at 160°C when using platen heaters.*** If the formed sheet needs to be seamed with unformed sheet and colour match is an issue, the flat sheet should be heated under the same conditions.

Any transfer of mould texture from the thermoforming mould to the sheet is more visible when backlit, particularly when the show side of the part is the side in contact with the mould. This can be eliminated by making the mould with a higher quality finish or by sanding the part after moulding.

*It is important for backlit applications that all inspection and quality checks are done both with room lighting and with backlighting representative of the lighting used in the final installation. Some fabrication defects will not be visible until the sample is backlit.*

### ***Finishing***

The front surface finishing requirements do not change. If the application will have backlighting the back side may require some finishing. The appearance when backlit is relatively insensitive to backside sanding quality, scratches, etc., but the sanding level should be uniform. Damage to the back surface may show through as a shadow. Take care not to create extremely different finishes when finishing seams as the different finishes may show up as light or dark spots when viewed with backlighting. Always check with backlighting to ensure the area around the seam matches the rest of the sheet.

## 2. DuPont™ Corian® Stone Collection Colours



4 new colours of the 2008 offering (Clam Shell, Sonora, Lava Rock and Aztec Gold) belong to the Stone colour family. This new family consists of exciting new patterns that will allow you to offer completely new aesthetics to your customers.

These colours present random veins, colour shades and particles. Due to this random effect, it is unlikely to have a continuous flow of the pattern when 2 sheets or 2 pieces from the same sheet are seamed together. The change of the pattern and colour shades will show up at the seam area.

We advise you to inform your customers about this fact during the sales process. 100x100mm samples are too small to fully represent the random pattern of these colours. A full size display, which clearly shows the pattern, is the recommended way to demonstrate to the end consumer the actual look of Stone colours.

This technical bulletin contains several design ideas and recommendations on new layout and assembly techniques to obtain the best results. Nevertheless, it is the responsibility of the Fabricator to blend the patterning into the assembly in order to meet end consumer expectations.

### **Countertop Seams**

Because the Stone Collection has random directional patterns, countertop seams may require more than a typical butt seam (90° seam) to be acceptable to the consumer. You may find that some colours may have acceptable results with a 90° seam; other might require a mitre seam (45° seam).

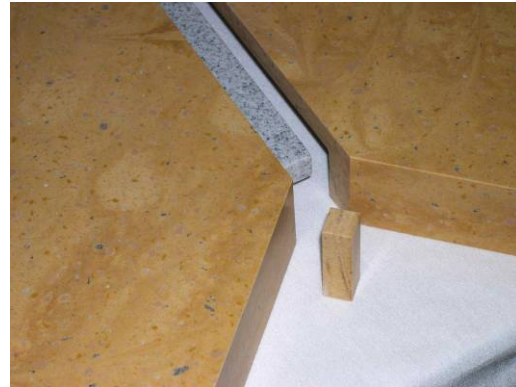


*Examples of standard 90° seams*



When using a mitre seam, use the insert block method to get the proper inside corner radius. Please remember that reinforcement is also needed, as described in the Fabrication Manual. Be sure that the joint between the reinforcement strip and the corner block is completely filled with adhesive.

*Examples of mitre seam*





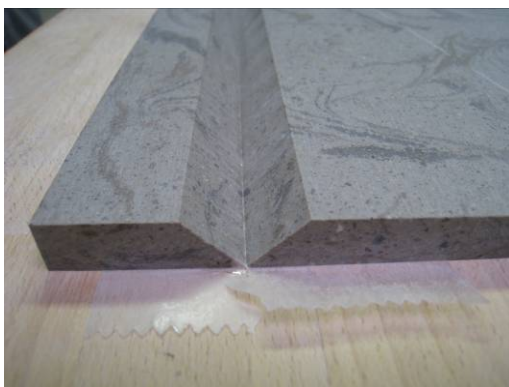
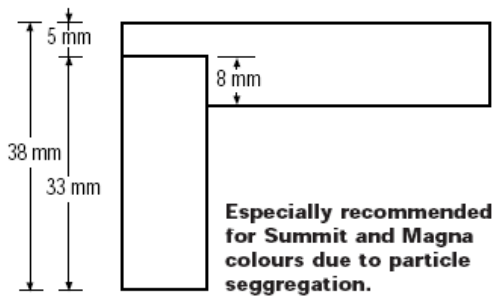
**Edge details**

Stone Collection has a mix of random particles and veins which runs throughout the sheet. A standard drop or stacked edge may or may not have the expected aesthetic results.



**Recommendation:**

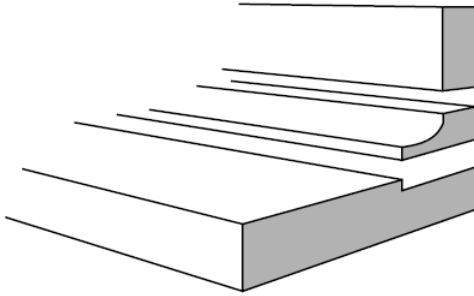
Rebated and V-grooved edges are recommended in order to allow the flow and continuity of the veins.



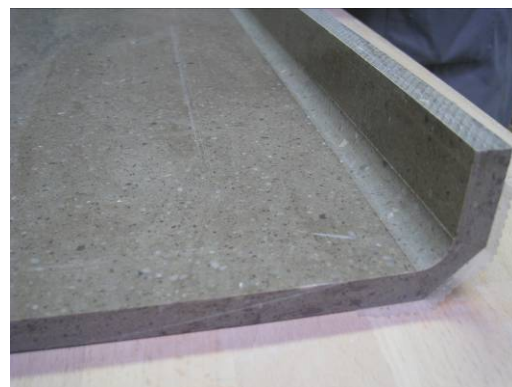
***Backsplashes***

For **butt backsplashes**, follow the standard procedures described in the DuPont™ Corian® Fabrication Manual. Pay attention to the direction of the veins and patterns when cutting the strips, and fit them on the countertop following the original direction. This will help you to have a natural flow of the pattern. V-grooving is also a good alternative.

**Coved backsplashes** on the Stone colour family, because of its random effects, tend to make the pieces more visible, not resulting in a monolithic look.



Results obtained with V-grooved backsplashes are the same.





### *Thermoforming*

**Stone** colours show a similar performance to the Magna series when thermoforming: in order to avoid whitening and micro-cracks due to the size of the particles, radii will have to be bigger than normal. For more details, please refer to the Corian® Fabrication Manual, chapter 17.

By thermoforming at lower temperatures than usual there will be less whitening and also less particles popping-up or separating. Best results are achieved at a temperature of **140° C**.

### *Finishing and sanding*

All typical finishing methods are suitable to use on DuPont™ Corian® **Stone** colours. For more information, please refer to the DuPont™ Corian® Fabrication Manual, chapter 19.

### 3. DuPont™ Corian® Lustra Colours

This bulletin summarizes specific characteristics/properties of the Lustra Collection of colours from DuPont™ Corian® that must be taken into account when specifying and designing a DuPont™ Corian® application to ensure the correct use of the product and ensure customer's satisfaction. It also describes specific fabrication and installation techniques that must be met to ensure the "10 Year DuPont™ Corian® Limited Installed Warranty" coverage within the DuPont™ Corian® Quality Network.

#### *Availability*

- Dimensions: 12 x 760 x 3658 mm
- Colour family: Lustra: Anthracite, Blackberry Ice
- Sensitive colours: The DuPont™ Corian® Lustra colours belong to the group of the 'Sensitive colours'. Saturated and dark colours will show dust, scratches and other wear and tear more visibly than lighter and less saturated ones.  
Therefore, we recommend that these colours should not be used in applications where the surface is exposed to heavy use and contact (e.g. kitchen worktops).
- Colours & Adhesives: please contact your Internal Sales Representative or your DuPont™ Corian® supplier



ANTHRACITE \*



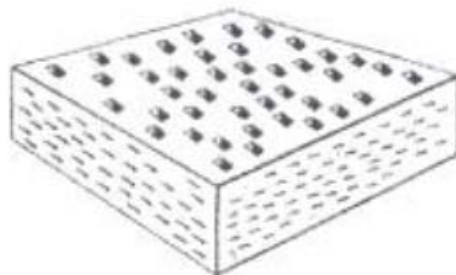
BLACKBERRY ICE \*

**Note:** Blackberry Ice will be obsolete in 2010.

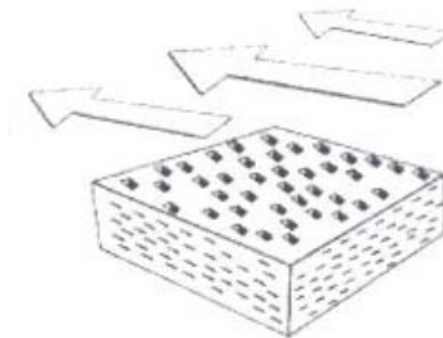
#### *Specific Characteristics*

The secret of the DuPont™ Corian® Lustra aesthetic is millions of mirror-like, micro-thin flakes that are oriented within translucent acrylic polymer.

As a result, when viewed from different angles there is a perceived colour change even under a consistent light source. And when viewed from the edge of the sheet, the flakes tend to 'disappear'. This creates exciting new possibilities for tone-on-tone effects.



While these features can add a wonderful look to an installation, they can present some areas to consider when fabricating this material. Realising the full potential of DuPont™ Corian® Lustra requires some special considerations in design and assembly. However, no special fabrication methods are needed for sink or lavatory mounting, thermoforming, or finishing.



**Note:** Illustrations shown here are not completely representative of proper fabrication procedure. *All inside corners must be radiused – ref. DuPont™ Corian® Fabrication Manual.*

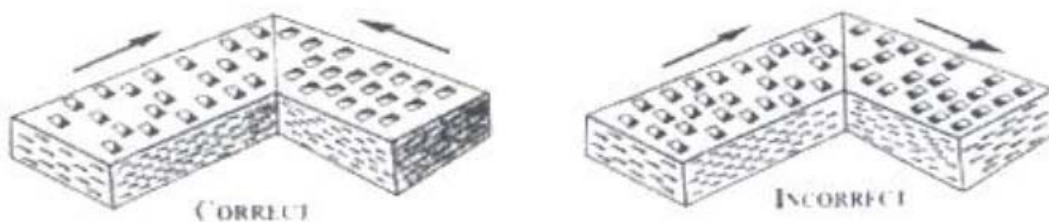
### Worktop Seams

Light reflection varies as DuPont™ Corian® Lustra is viewed from different angles, which can appear as colour difference when sheets are joined. This is especially evident when making seams in “L” or “U” shaped tops. This is a natural feature of the aesthetic and is more evident in some Lustra colours than others. It should not be considered a defect, but should be explained to consumers before fabrication begins.

#### a. Diagonally Seamed Inside Corners

Diagonal seams in corners of “L” or “U” shaped tops will give the best look for DuPont™ Corian® Lustra. They give a subtle, neatly tailored change in the directionality of the light reflection, so the pieces blend very nicely.

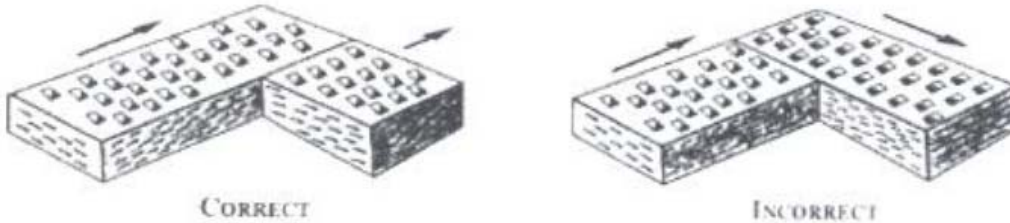
**Important Note:** Cuts should be made so that the printing on the underside of the sheets runs in opposite directions at the corner.



b. Butt-Seamed Inside Corners

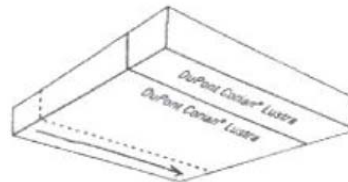
If the return leg of the “L” or “U” is less than 760 mm, a typical butt-seam can be used at corners.

**Important Note:** To minimise the difference in colour appearance, the printing on the underside of the pieces must run parallel and in the same direction.



c. Butt-Seams on Island or Peninsulas

**Important Note:** When making an island or peninsula wider than 762 mm, the printing on the underside of the sheets must run parallel and in the same direction.



**Helpful Hints:**

Put an arrow showing the direction of the printing on the bottom of any strips that do not have printing on them.

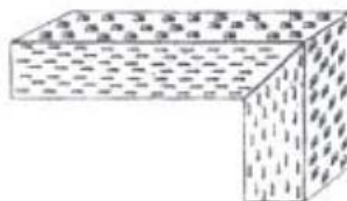
**Edge Treatment**

The flakes tend to ‘disappear’ when viewed from the edge of a sheet of DuPont™ Corian® Lustra. This is accentuated by making a thick edge in which the pieces are layered.

The following techniques are recommended for fabricating edges with Lustra:

a. V-Grooved edges

V-grooved edges look best because the flakes can be easily seen over the entire edge surface.



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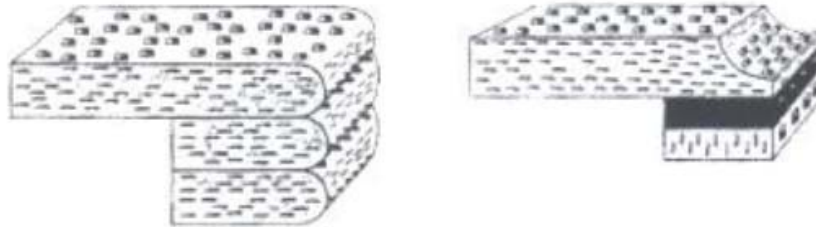


**Helpful Hints:**

Smaller router profiles are recommended for V-grooved edges. Larger router profiles take away too much material, causing flakes to 'disappear'.

**b. Stack (layered) Edges**

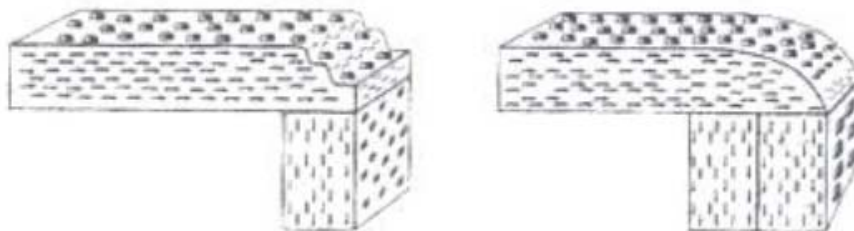
Stack edges have a different look in DuPont™ Corian® Lustra because the flakes tend to 'disappear' when viewed from the edge of the deck.



**Important Note:** Larger-profile router bits expose more flakes and can enhance the look of a layered edge. Adding an alternate colour strip as a "sandwich" breaks up the edge and draws attention away from the 'disappearing' flakes.

**c. Stand-Up Edges**

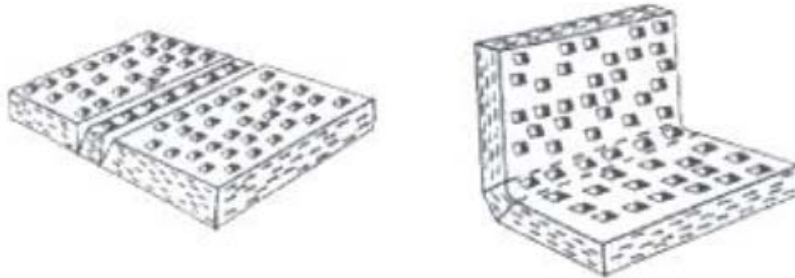
Stand-Up edges (made by standing up the edge strip) with large or very detailed edge profiles will create a large area without reflecting flakes.

**Backsplashes**

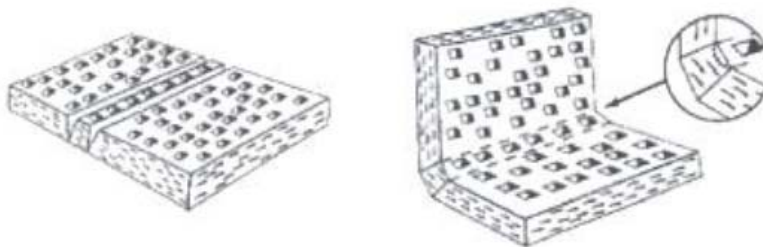
A conventional loose backsplash works well with DuPont™ Corian® Lustra colours. Clear silicone gives the best look. However, feel free to use the colour of silicone you think looks best with the project.

a. V-Grooved Backsplashes

The best-looking backsplash for DuPont™ Corian® Lustra is made by V-grooving, because the flakes can be easily seen over the entire edge surface.

b. Simulated V-Grooved Backsplashes

If a V-grooved machine is not available, this look can be simulated by making the pieces by hand, using a  $22\frac{1}{2}^\circ$  router bit or a table saw set to  $22\frac{1}{2}^\circ$ . Lay up the pieces, tape and glue together with joint adhesive. After the adhesive sets, the cove is cut with the coving router.

c. Conventionally Coved Backsplashes

Conventional coved backsplash methods will work well for DuPont™ Corian® Lustra, but only if the following special procedures are strictly followed. Follow this assembly method whether using a shaper, router table coving router to make the cove radius.

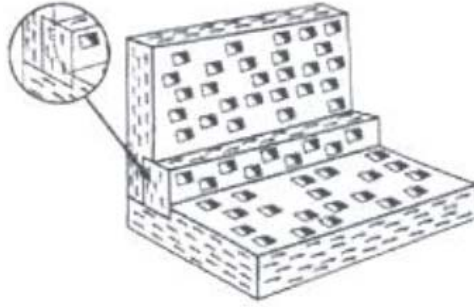
- o Cut the backsplash piece so that it will go down into the rebate on the back of the worktop.
- o Cut the rebate 3 mm x 12 mm in the bottom of the face of the backsplash piece.
- o Cut a strip 12 mm x 12 mm x the length of the backsplash. Glue into the rebate on the backsplash piece with joint adhesive.

**Important Note:** The top surface of this strip must be facing in the same direction as the backsplash piece.



- o After the adhesive sets, trim excess from the bottom of the splash piece. Glue splash assembly into worktop as usual.

**Important Note:** Mitre all inside and outside corners.

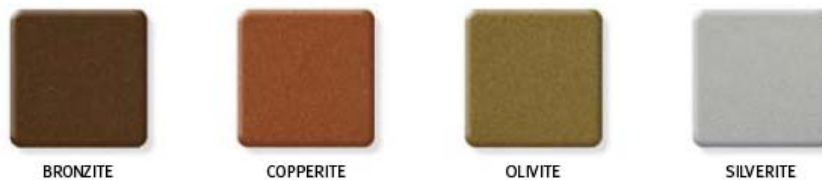


## 4. DuPont™ Corian® Metallix Colours

This bulletin summarizes the procedures for fabricating DuPont™ Corian® Metallix colours, including techniques to create unique aesthetics utilizing the directional nature of the product. All typical fabrication and installation requirements, seam reinforcement, for example, must be followed.

### Availability

- Dimensions: 12 x 760 x 3658 mm
- Colour family: Metallix: Bronzite, Copperite, Olivite, and Silverite.
- Sensitive colours: The DuPont™ Corian® Metallix colours belong to the group of the 'Sensitive colours'. Saturated and dark colours will show dust, scratches and other wear and tear more visibly than lighter and less saturated ones.  
Therefore, we recommend that these colours should not be used in applications where the surface is exposed to heavy use and contact (e.g. kitchen worktops).
- Colours & Adhesives: Please contact your Internal Sales Representative or your DuPont™ Corian® supplier



### Overview

The DuPont™ Corian® colours containing metallic flakes offer three types of aesthetics with metallic reflectivity. There are four solid colours: Bronzite, Copperite, Olivite, and Silverite.

The metallic pigments in the solid colours reflect light in a directional manner. Depending on the design goals, the objective may be to either maximize or minimize the directional effect relative to a reference point. For best visual results, you will need to consider directionality of the sheet, lighting type and locations, from where observers will view the sheet, the impact on 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 and visual activity of your installations. Be sure to show samples to your customer to ensure that the design will meet their expectations.

This discussion focuses on the unique characteristics of these colours. For complete details of assembly procedures, refer to the DuPont™ Corian® Fabrication Manual.

**Key Design Points**

This product is directional, both on the top surface and on the edges. It is best used when the directionality is highlighted. Creating uniform appearances is possible, but requires special attention to sheet orientation and not all standard fabrication techniques are applicable.

The orientation of the metallic flake changes through the thickness of the sheet. This results in reflectivity variance that may change with the orientation of the sheet. This is most visible when multiple sheets are stacked with a square edge. It is not as visible on curved surfaces. If a uniform edge profile is required, a v-grooved edge is recommended.

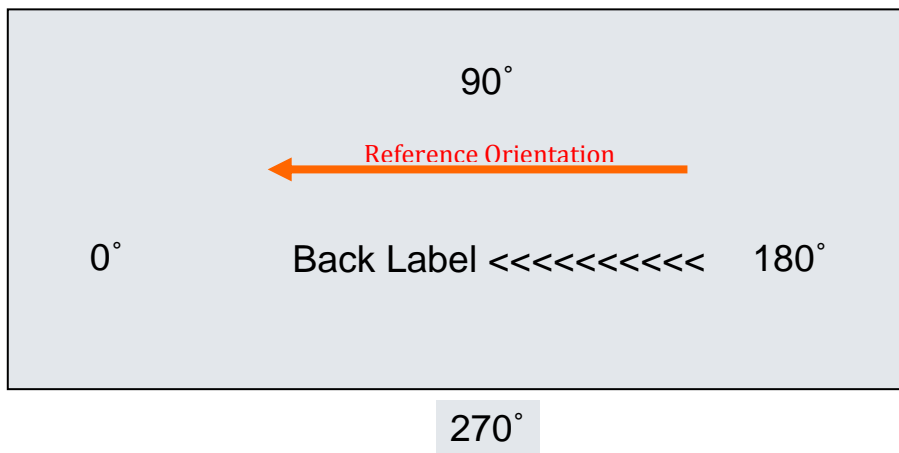
The directional nature of the sheet must be accounted for during design and fabrication. This directionality persists through the thickness and is most apparent along the length of the sheet. If two sections are joined with different orientations so that they look different on the top surface, the edge profiles will also look different.

**Important**

Using the orientation of the product back side labelling as a reference direction, marking all cut pieces with a directional arrow will help later with properly orienting the pieces during assembly. It may be difficult to visually determine orientation of the cut pieces until they are seamed together and the sample is finished.

All reference to orientation in this bulletin will be relative to the backside label on the sheet. There are directional arrows in the label that point towards the beginning of the text. When the sheet is oriented so the text is upright, 0° will be left with the arrows pointing towards it, 90° will be up, 180° will be right and 270° will be down. This terminology will also be used to describe viewing angles. For an uncut sheet, to view the 0° appearance is to stand at the 180° position and look towards the 0°. This is similar to how you would read a compass, looking across the compass to look north.

Pick one piece, generally the largest one and use that as your reference orientation. All other pieces can be oriented relative to that piece. Picking 0° as the reference, the red arrow indicates the reference orientation.



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It is important to remember that the visual effects are with respect to the original sheet orientation, not to the seams where sheets are brought together. The difference will be delineated at the seams, but the angles where the effects are most visible are dependent on the original sheet orientations, lighting, and the position of the observer.

Lighting plays a strong part in the visibility of patterns. Directional lighting can maximize visual effects when oriented in a way that maximizes directional reflections. Uniform area lighting may decrease the impact of the patterns.

The position of the observer is important. If the design will be primarily viewed from certain positions, it is important to design so that position will see the desired effect.

### ***Designing for Directional Effects***

The directional nature of the sheet lends itself to some unique design possibilities and is the best application for the solid Metallix colours.

Decorative patterns can be created by assembling a surface from pieces with varying orientations. The varying orientations of the metallic flakes interact differently with light. As the observer moves relative to the surface, different aspects of the design appear and disappear, creating a dynamic surface.

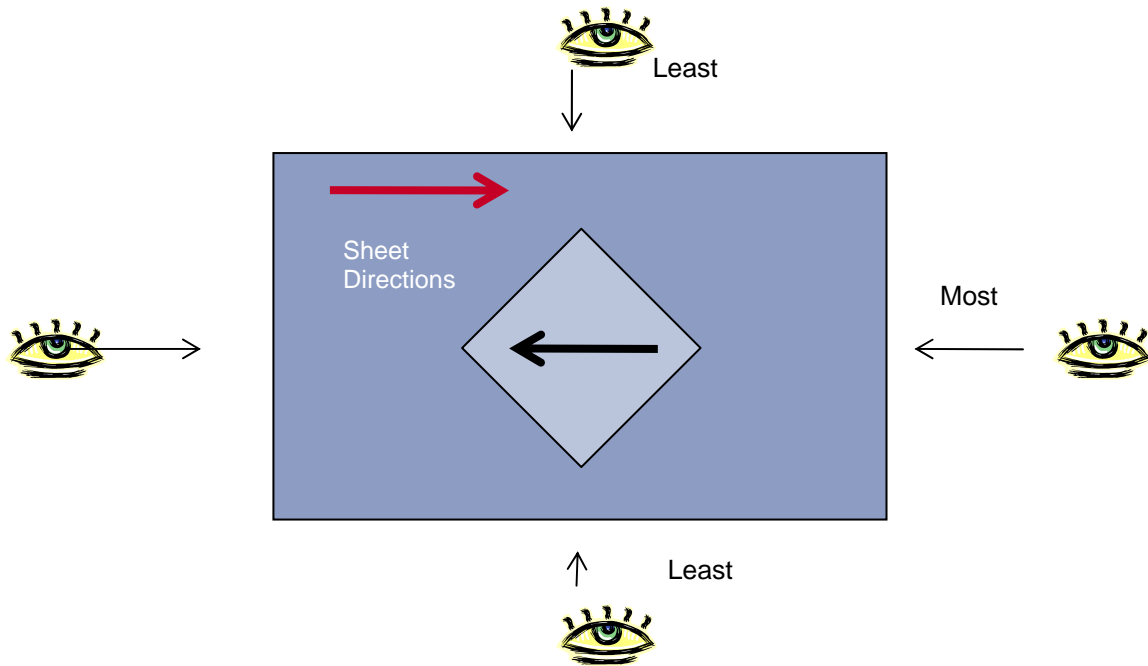
One source of inspiration for creating unique aesthetics is applications where wood grain is used as a design element. An example is a parquet appearance. This may be fabricated by assembling strips with alternating angles, then cutting that into squares that are assembled with alternating orientations.

### ***Sheet Reflectivity***

The sheet is most reflective looking towards 0° from the 180° position. The view of the 90° and 270° positions is slightly less reflective. The least reflective viewing angle is looking at 180° from the 0° position. This is true for both the top and any edge profiles. These statements assume uniform lighting. Directional lighting may change the visible appearance.

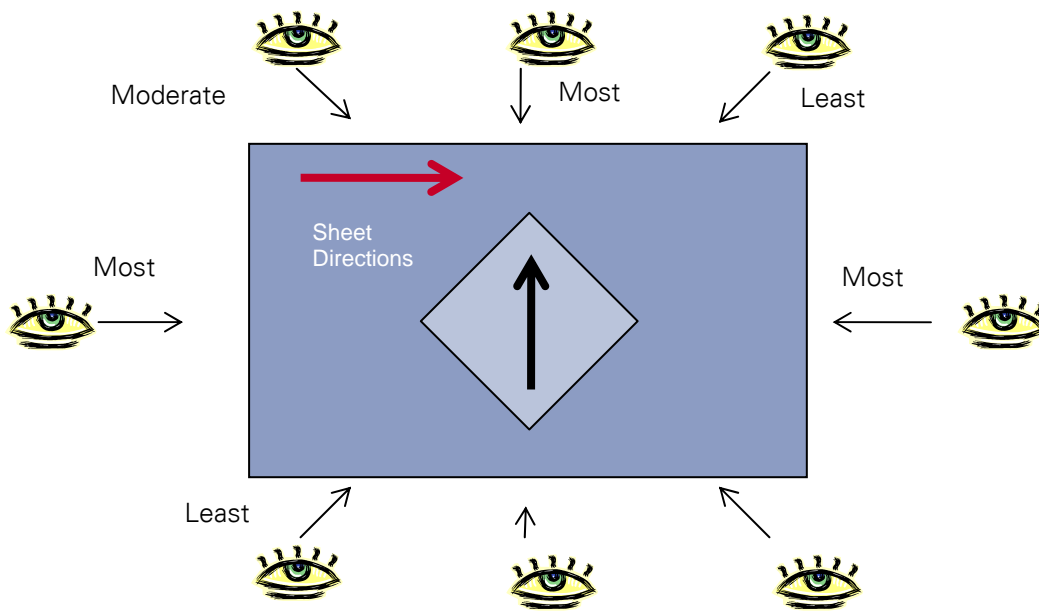
### ***To Generate "Disappearing" Aesthetics***

Patterns are most likely to "disappear" if all components are oriented to either 0° or 180°. These patterns will be most visible looking down the 0° or 180° axes. They will be least visible from the 90° and 270° axes.



**To Generate Aesthetics Visible from Many Angles**

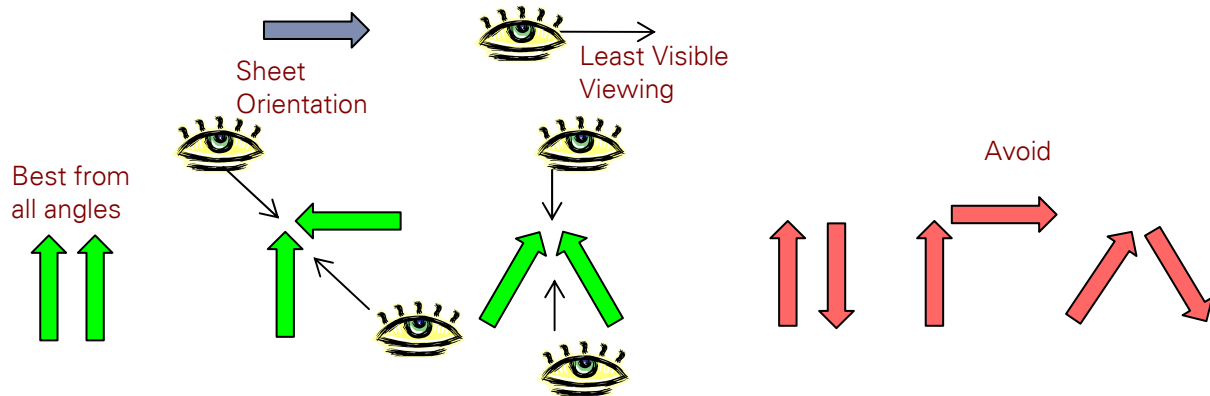
Patterns will be visible from more angles if sections are oriented 90° from each other. They will be most visible looking along one of the original axes of the sheet. The patterns will be least visible looking from a point half way between the original axes when the sheets are oriented so that the label arrows are both pointing away or towards the observer. When the sheets are oriented so that one label arrow is pointing towards the viewer and one away, the pattern will be moderately visible.



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**Designing to Minimize Directional Effects**

Trying to present a “uniform” appearance is more difficult than designing to take advantage of directional effects. Best practice is that all pieces have the same orientation. Where this is unpractical, then the transition should look as natural as possible, often achieved with a mitered seam. When designing to minimize directional effects the arrows on the labels should be pointing so that they meet at some point. The directional effect will be least visible from a point midway between the two arrows, so the most likely position that people will view the design must be considered.



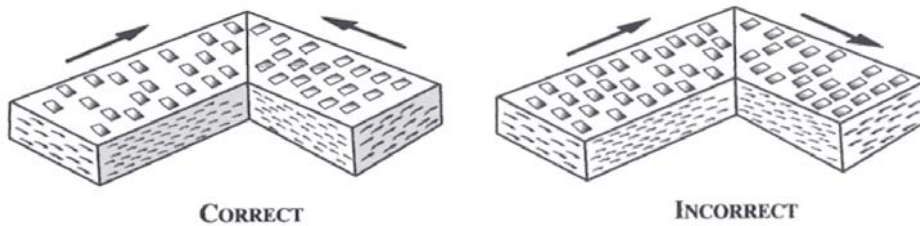
**Seams**

Light reflection varies as the Metallix colours are viewed from different angles. This can appear as a colour difference when sheets are joined. Common examples of where sheets may come together at 90° angles are “L” or “U” shaped tops. This is a natural feature of the aesthetic and will be more evident in some colours and finishes than others. It is best to have samples to show the customer so it is understood what the final piece will look like.

**Diagonally Seamed Corners**

When two sheets need to be joined at an angle a diagonal seam will provide the best appearance. A diagonal seam will provide a subtle, neatly tailored change in directionality. This seam will be least noticeable looking down the diagonal and directly above. The seam is most visible looking down the length of the sheets at low angles.

**Important Note:** The sheet orientations should be as below on the left, with the arrows in the backside label both pointing either towards the corner.



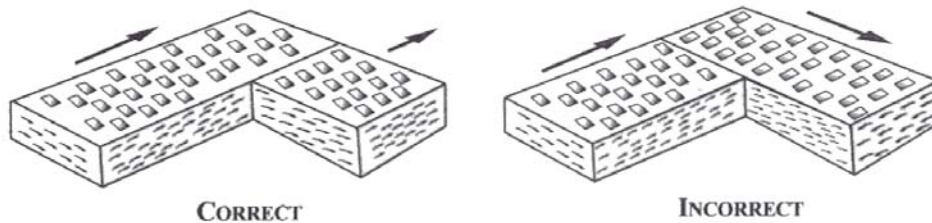
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### Offset-Seamed Corners

If one side of an "L" is less than 760 mm then a typical offset seam can be used at the corner. Additional 760 mm sections could be added, maintaining the common orientation.

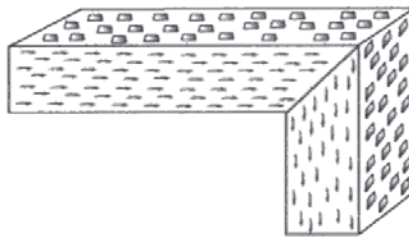
**Important Note:** The sheet orientations should be as below on the left, with the arrows in the backside label both pointing in the same direction.



### Edge or Corner Details

This section addresses options for corners or edges. The Metallix colours have reflective metal flakes that are generally oriented in the plane of the sheet. Thus the edge of the sheet shows the edges of the metallic flakes. As the edges reflect less light compared to the surface of the flake, the edges of the sheet will have a darker, less reflective appearance. The orientation of the flakes changes through the thickness so the edge appearance has some variation in reflectivity. The reflectivity also varies with orientation.

If a drop edge is used, the surface reflectivity of the vertical edge contrasts with the edge view of the top sheet. Therefore a more suitable aesthetic is obtained using a v-groove edge. A V-groove edge will give the most uniform appearance when a tight radius is used.

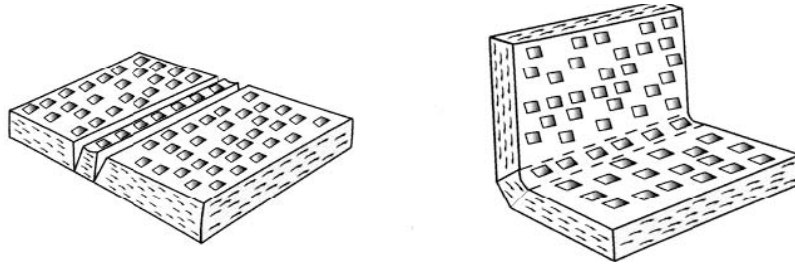


A stacked edge does have a difference from the top and varying reflectivity on the edge. This is most apparent for a flat edge. If profiles are used, the change in reflectivity from the curvature hides some of the variation and the surface will look more uniform. Different profiles (bull nose, ogee, etc) will give different effects. A strip of a contrasting colour will also hide the varying reflectivity.

Drop edges or a butt seam on a vertical corner are not recommended unless the visual contrast is desired. In all cases, having samples to show customers so they understand the visual details will help avoid surprises when the job is installed.

### **Coves**

For solid Metallix colours reflectivity varies with the orientation of the metallic flakes to the viewer. Creating the cove reveals the interior of the sheet, and the metal flakes will not be aligned with the surface cut of the cove. Depending on the angle of observation the cove may match, but will tend to look darker than the horizontal or vertical surfaces surrounding it at other angles. Coves are not recommended. If a cove is required, the v-groove technique provides the best cove. Make sure the customer sees a sample and approves the appearance.



### **Thermoforming**

DuPont™ Corian® with metallic flake can be thermoformed using typical settings. It is important to account for directionality during the design of the part and during fabrication. To track orientation it is best to put arrows on each piece indicating the orientation relative to the backside label.

### **Finishing**

All typical finishing methods are suitable to use on DuPont™ Corian® with metallic flakes. Darker colours may have a better appearance with a semi-gloss finish. The metallic flakes and directionality effects will be more apparent at higher glosses. The consumer should be made aware of the proper care and maintenance instructions for the provided gloss level. 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. Buffing pads may turn dark from metal oxide removed during polishing.

### **Summary**

The directional nature of metallic flakes in these DuPont™ Corian® colours allows for some creative designs that change with viewing angle. When directionality is not desired many typical fabrications can be used, but an awareness of the impact of sheet orientation fabrication methods is required to minimize the effect of directionality. In addition, all requirements as set forth in the DuPont™ Corian® Tech Bulletin, CTDC – 117, "Required Fabrication and Installation Procedures for DuPont™ Corian® Products" must be followed.