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Durasein
Built-Up Edges



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Fabrication and Installation

Built-Up Edges

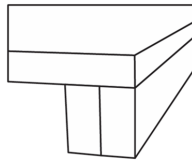
BULLETIN NO.
Built-Up Edges_0525

TECH INFO
Built-Up Edges

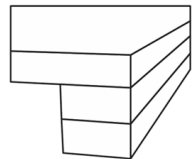
Introduction

Although many styles of edges can be accomplished with Durasein® Solid Surface, we will address in this section the four predominant styles of 1 ½" (36 mm) built-up edges:

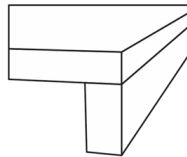
The Vertical Stacked Edge



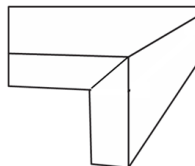
The Horizontal Stacked Edge



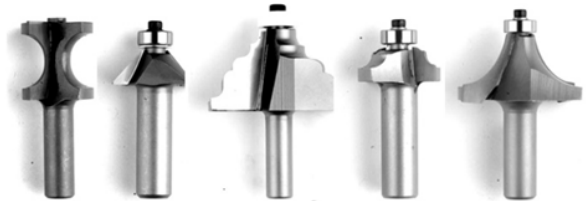
The Single Vertical Drop Edge



V-Groove Edge

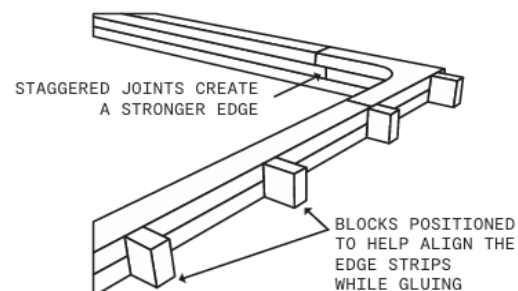


Edges are generally created by attaching strips of material to the countertop deck using solid surface seam adhesive. Many profile bits are available to create decorative edges.



A wide variety of router bits are available to create the desired aesthetic for the countertop edge. For hand routing, size your router appropriately for the type of bit being used. Smaller diameter profiles require less horsepower than larger profiles. Also, for larger profiles, use a plunge router and cut the profile in steps. This will create less chatter in your final cut.

When using either the vertical or the horizontal style, it is recommended that the seams in the strips be staggered wherever possible. This will create stronger joints in the build-up strips.





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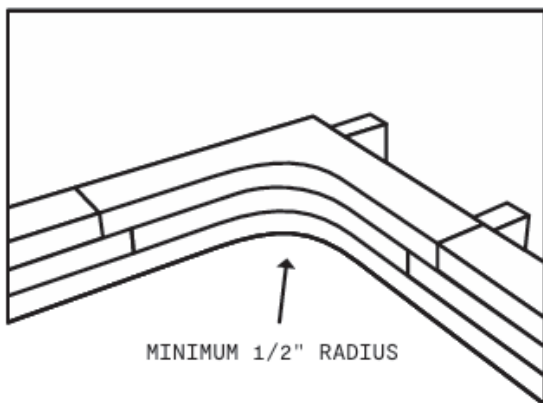
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Generally, strips are clamped in place with the aid of wood or plastic blocks to assure alignment. Spring clamps are the most common method and provide appropriate pressure for a good adhesive joint. The strips and sheet material are cleaned with denatured alcohol and clean white cloths. Seam adhesive is applied and the strips put in place. Assure adequate coverage and clamp the strips in place. When the adhesive has cured, remove the positioning blocks and trim the face of the edge.

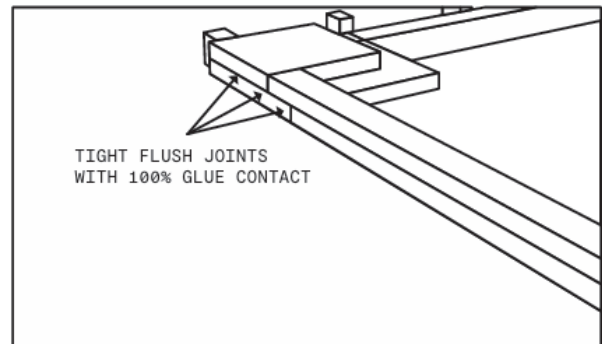
Inside Corner Blocks

Durasein® Solid Surface requires a minimum 1/2" (12.7 mm) radius on countertop inside corners. In addition to other drawings in this section, the following diagrams show some suggested details of the corner build-up. In most cases, the drawings are shown from the underside of the sheet.



Corner Block Pieces

There are usually two square pieces that make up the corner block. The inside corner blocks should be at least 3"- 4" (76-102 mm) square prior to fabrication. If your edges are layered as a vertical or horizontal stacked edge, ensure the joints are staggered in order to increase strength and integrity of this area. Varying the size of the two square corner pieces will help accomplish this.





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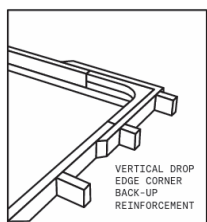
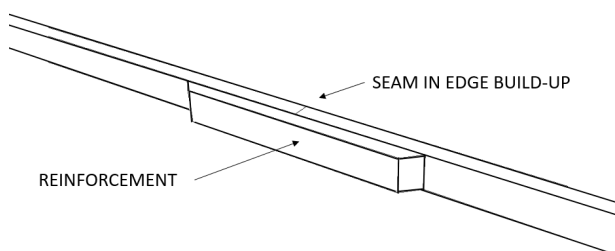
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For single vertical drop edges, reinforce the inside corner with a backing strip that extends at least one inch (25 mm) beyond where the inside block and front edge strip meet. Additionally, reinforce any butt seams in the vertical edge strip with 4" (102 mm) long backer reinforcement with beveled ends.



Be sure all corner blocks and edge build-up have been sanded to remove any potential stress risers. This includes the back face of the build-up pieces and the exposed outside corners of the build-up

Be sure that all joints in the edge build-up are flush at the rear of the build-up. Even small offsets can be areas where stress cracks can start

Tips for Built Up Edges

- Be sure that all joints in the edge build-up are flush at the rear of the build-up. Even small offsets can create areas where stress cracks can start.
- Be sure seams are 100% filled with seam adhesive. Voids in joints can be severe stress risers. A crack can start in the joint and migrate up into the deck.
- Support corner areas properly. Be sure the cabinetry and support pieces can prevent flexing of the countertop at the corner.
- Be sure that both sides of the countertop at an inside corner are level and flat.
- Use flexible adhesives to adhere the countertop to supports and cabinetry.
- Be sure to leave room for expansion and contraction between the support components and the countertop.

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