SEAMS
Seams and joints made with the Formica® Solid Surfacing Seaming Adhesive are generally machinable and handleable after one or three hours, respectively. Properly made, seams will reach strengths of about 70% of the strength of the sheet. Since these adhesives do not reach maximum strength for several days, newly bonded seams and joints require proper handling during fabrication, transportation and installation. The following fabrication and handling techniques may be helpful.

SANDING
The heat generated by intense sanding, especially belt sanding, can cause uneven thermal expansion which can stress a new seam. Periodically feel the area being sanded for hot spots. If it becomes hot to the touch, stop sanding for a few seconds and let the heat dissipate. Replacing worn sandpaper will help reduce heat buildup.

ASSEMBLY AND CARRYING
Most shop operations require flipping or turning a newly seamed assembly. To do this, carefully rotate the assembly to a vertical position, pause, reposition your hands then continue rotating it on its edge and carefully lower it back onto the work surface as shown. Large or shaped tops (e.g. “U” or “L” shapes) may require two or more people and/or the use of straight lumber, etc., securely clamped along the long edge or edges to avoid flexing during this operation. (See Figure 1)

Typically, edge strips are applied when a top is upside down.

Edge strips should be butted to each other and the joints staggered. Corner blocks should be used at all inside corners, as illustrated in the Formica® Solid Surfacing Fabrication Guide (Form No. 10-003). (See Figure 2)

For additional seam strength, a 3” to 4” wide double-chambered reinforcement strip of Formica Solid Surfacing is required. Bond strip to the underside of each seam with the Formica® Solid Surfacing Seaming Adhesive. Use sufficient adhesive for full coverage of strips. (See Figure 3)

For long, straight tops, use as few Formica Solid Surfacing strips on the bottom drop edge course as possible. Avoid making the bottom drop edge join in the center of long tops. If the top sags, the tensile forces on the vertical joint could cause a crack which could continue into the Formica Solid Surfacing top. (See Figure 4)

If the assembly is to be moved, carefully rotate it to a vertical position and carry it on edge. When lowering the transported top to another work surface, position it on its edge again and carefully rotate to lower it into a flat position as shown in Figure 1.
TRANSPORTATION
Formica® Solid Surfacing should be transported lying flat on a clean, well-supported, padded surface. Large fabricated tops should be transported on edge, braced to prevent movement and well-padded to prevent damage. Secure lumber strips to the underside of the top to help prevent flexing during shipment. (See Figure 5) Special care should be taken when transporting countertops with cutouts.

Note: Low temperatures (at or near freezing) require extra care during transportation and handling.

INSTALLATION
Transport and carry the top on edge. When positioning onto the cabinetwork, place the back edge onto the cabinets and lower the front edge, keeping it as straight as possible, and slide into place. Again, as during fabrication, large or shaped tops may require additional personnel and/or mechanical support.

TECHNICAL SERVICES
Technical assistance may be obtained through your local Formica Solid Surfacing distributor or from Formica Corporation trained representatives in sales offices throughout the country. To assist these representatives, Formica Corporation maintains a sales technical services staff in Cincinnati, Ohio. For technical assistance, contact your distributor or sales representative; write the company directly at Formica Corporation Technical Services Department, 10155 Reading Road, Cincinnati, OH 45241; call 1-800-FORMICA™; fax (513) 786-3195 or visit our website at www.formica.com.

In Canada, call 1-800-363-1405. In Mexico, call (525) 530-3135.

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GreenGuard Environmental Institute
Formica® Solid Surfacing is GreenGuard Indoor Air Quality Certified under the GreenGuard Standard for Low-Emitting Products.

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