

Laminate countertops have a fresh, updated look with today's new designs and textures. This look can be enhanced by including a curved radius with one of Wilsonart's Decorative Edge profiles. This added touch can affordably transform surfaces into sculpted architectural details. Following are guidelines recommended by the Wilsonart Technical Services team for achieving the best results.



Overview of this Bulletin:

- Fabrication guidelines for creating a radiused edge using Wilsonart Decorative Edge Crescent and Cascade edge profiles.
- **FABTIPS** in red are energy-saving suggestions from our fabrication team.

Getting Started

Only FE (Flat Edge) Crescent and Cascade Decorative Edge profiles are recommended for creating laminate countertops with a radius. The radius must not be tighter than a 48" radius. (Please see diagram and/or link for assistance in identifying radius dimensions.)

After cutting the countertop and flush trimming the laminate, apply build down material with Wilsonart Wood Glue. After the build down is applied, ensure all sides receiving Wilsonart Decorative Edges are cleaned and squared with either a straight cut-planer or a straight edge and router. (**FABTIPS:** 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.)

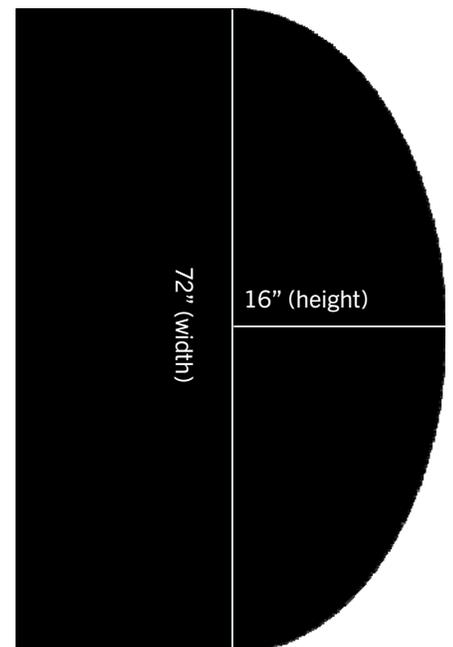
When fabricating a radius, we suggest attaching a router to a long straight edge that will allow the appropriate arc/radius on the pre-measured and marked top. Other options include using a CNC, point to point, or any other specialty radius tooling to create the arc/radius. (**FABTIPS:** If tooling is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

Formula: $(\text{width} \times \text{width}) \div (8 \times \text{height}) + (\text{height} \div 2) = \text{radius}$

Example: $(72 \times 72) \div (8 \times 16) + (16 \div 2) = \text{radius}$
 $5184 \div 128 + 8 = 48.5 \text{ radius}$

<http://www.mathopenref.com/arcradius.html>



Fit the Molding

Start by rough cutting all the Decorative Edge pieces. Rough cut and dry fit the Decorative Edges to the desired length and smooth the cut using a disc sander. **(FABTIPS: Trim a minimum 1" from both ends of the Decorative Edge molding).**

Divide the angle finder dimension by two to get your miter angle. **(FABTIPS: 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.)**

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. **(FABTIPS: 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 molding.

Glue the Molding

Using Wilsonart Type II adhesive, apply two 1/8" beads to the top and bottom areas of the flat backside of the Decorative Edge. **(FABTIPS: Do not use contact adhesive.)**

Smooth the adhesive with scrap laminate material and apply molding to the prepared substrate. Use fiber-reinforced tape applied every two to three inches down the length of the molding and around the corners vertically to secure miter corners. **(FABTIPS: Use a laminate faced wood block and 3" pinch clamp to maintain correct height of molding to the laminate countertop edge—see photo at left).**



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 molding to the countertop. Apply tape around the corner to pull miters tight.

Wipe off any glue squeeze out with a damp cloth.

Clean-up and Final Finish

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 molding. **(FABTIPS: A scrap piece of molding can be rubbed over the seams to smooth any sharp edges. A matching dry erase marker or SeamFil® can also be used to touch up seam areas.)**

This is an addendum to the Decorative Edge Fabrication Manual BR1515 (Rev. 9-30-2011). More detailed installation instructions are available on the Wilsonart website: www.wilsonart.com. The Decorative Edge fabrication video can be viewed here: http://www.youtube.com/watch?v=h_v9yIBEGuk&feature=share&list=UU2kGD-a6FN9sTftSWzP6UIQ.