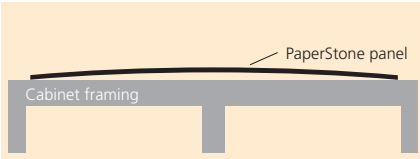




Fabricate & Install

Step-by-step instructions for fabricating and installing your PaperStone® project

Any "crown" should face up like this



Not down like this

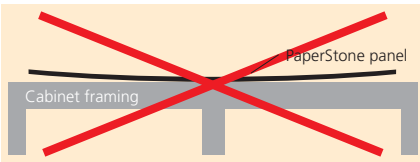


Fig. I

When the countertop is attached to the framing, the crown will straighten and become level with the cabinet frame. Any crowning of the material will not exceed 1/8" over 30".



2B



2C



2D



2E



2F



2G



2A

1. Tools needed for fabricating and installing [2A]

- Circular saw (with carbide-tipped blade)
- Router (with solid carbide-tipped bits)
- Jigsaw (with extra blades)
- Hole saw (size 1 3/8")
- Cordless drill with an assortment of drill bits
- Measuring tape
- Level
- Caulk gun
- Hot glue gun with glue
- Adhesives (refer to PaperStone® Recommended Adhesives by Application for specific adhesive choices)
- Orbital sander with an assortment of sandpaper grits (80 to 240) and maroon non-woven pads, such as Scotch-Brite™ 7447
- Towels (blue paper shop towels work well and/or cloth)
- Masking tape
- Adhesive blocks (scrap PaperStone® blocks work well)
- Sawhorses, fabrication tables
- Straight edge and radius guides
- PaperStone® Finish or other finish of choice appropriate for wood surfaces (refer to PaperStone® Finish Guide)

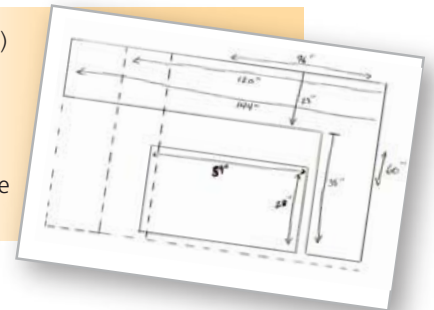


Fig. II

2. Preparing the PaperStone® panel

- Look at both sides of the panel to determine if there is a preferred side for the top
- If seams will be necessary, determine where they will be
- Sometimes there is a natural "crown" in the material. This is not a problem. Make sure it faces UP and that the ends come in contact with the cabinet framing [Fig. I]

3. Transfer template to PaperStone® panel

- Locate the best position on the panel to make optimum use of the material [Fig. II]
- Place template on panel [2B] or [2C]
- Trace template onto panel and mark any internal cut-outs [2D]

4. Mark sink/stove cut-outs and faucet holes on PaperStone® panel

- Carefully position sink/stove templates on panel and draw outline [2E] and [2G]
- Check number of faucet holes and diameter of each; typically most faucet holes are 1 3/8" in diameter
 - mark properly in relation to sink template [2F] and [2G]

5. Recheck all measurements for accuracy before cutting.

Before using any power tools, refer to the manufacturer's safety recommendations. Always wear eye protection.

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6. Cutting

- **CUTTING TIP:** masking tape on the saw base plate will help prevent scratching [2H]
- Make a rough-cut of the countertop with a circular saw (try to stay 1/8" outside of the traced line) [2I]
- A jig-saw can be used for tight spaces and curves, make sure cut stays perpendicular to the panel surface [2J]
- Make a clean-up cut precisely to the traced line with a router (utilize guides to ensure clean, straight cuts and smooth curves) [2K]
- For outside radius corners an orbital sander or router (with guide) works well [2L]
- For inside radius corners a router with radius guide is required to make a smooth, uniform radius cut
- Using a hole-saw, drill out the desired faucet holes

7. Pre-mount countertops

- Lay countertops on cabinet bases and check for proper fit and alignment
- Ensure all cutouts are in correct position, all overhangs are consistent and tops are resting level on cabinet bases [2M]

8. Edge Detailing

- Ensure that the desired edge finish is not extremely rough (if so, perform a preliminary sanding of the edge with 80 to 180 grit sandpaper depending on severity of roughness) [2N]
- Using a profile bit with a guide bearing, route the desired edge detail into the panel's edge (if desired edge detail requires the removal of a considerable amount of material, utilize 'step-cuts' to maintain a better edge and prevent burning) [2N]



9. Seaming (if required)

Biscuit seaming option A

- Dry-fit seam pieces
- Perform a 'mirror cut'
- Mark necessary biscuit locations
- Cut biscuit grooves
- Hot glue four 'hold-down' blocks about 8" from seam on both sides
- Apply two-part epoxy to biscuits and to both seam edges
- Using two bar clamps, gently tighten seam together
- After adhesive is slightly set-up, peel off the excess from the top surface
- Remove first clamp and clean surface with acetone and replace clamp
- Repeat previous step for remaining clamp
- With clamps in place, allow adhesive to cure following manufacturer's directions

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9. Seaming

Mechanical fastener seaming option B

- Dry-fit seam pieces upside-down
- Using a 'plunge' router, set the maximum depth to ½ of the overall thickness of the panel. Route "T" shaped grooves every four inches [20]
- Repeat previous step on second seam piece so that pieces are mirror images
- Apply adhesive to both seam pieces
- Gently tighten seam pieces together with clamps [2P]
- Insert mechanical fasteners into their respective grooves [2Q]
- Ensure that the pieces are lined up correctly, then tighten fasteners
- After adhesive is slightly set-up, peel off the excess from the top surface
- Remove first clamp and clean surface with acetone and replace clamp
- Repeat previous step for remaining clamp
- With clamps in place, allow adhesive to cure following manufacturer's directions

10. Install undermount sink (self-rimming sinks will be installed after the top installation is complete)

- Turn countertops upside down
- Locate and mark center point of both the sink and the cutout
- Place sink upside down on the underside of the countertop and match up the two center marks, mark positions for pre-drilled mounting holes
- Remove sink
- Pre-drill holes in underside of countertop at specific mounting screw locations (use tape or a drill stop on your carbide-tipped bit to prevent drill-through)
- Apply a bead of silicone adhesive to the underside edge of the sink cutout
- Place sink back on the countertop and match up the two center marks
- Lightly insert screws into each pre-drilled mounting hole
- Turn countertop right side up
- Lightly tap the sink until it is in exact desired location (consistent reveal)
- Tighten all mounting screws
- Wipe away excess adhesive

11. Surface preparation

Scotch-Brite™ option A

- This option will maintain PaperStone's natural micro-textured surface [2R]
- Sand all exposed edges with a maroon non-woven pad to achieve an even surface treatment

Sanding option B

- This option will produce a smoother PaperStone® surface [2S]
- Sand all exposed edges with 220/240 grit sandpaper
- **NOTE:** Depending on condition of top surface, sand with coarsest required grit to remove rub marks/scratches then work up to 220/240 grit sandpaper
- Finish with a maroon non-woven pad

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12. Attach countertops

- Place countertops on cabinets
- Locate necessary anchor screw locations
- Pre-drill holes in underside of countertop at specific anchor screw locations (use tape or a drill stop on your carbide-tipped bit to prevent drill-through) [2T]
- Pre-drill holes in cabinet frame/supports at specific anchor screw locations (use larger bit here)
- Working with one section at a time, lift the countertop off the cabinet base [2U] and apply a thin bead of silicone adhesive to the cabinet base [2V]. Carefully lower the countertop back onto cabinet base, repeat this step as necessary to apply adhesive to other areas of the cabinet base (if possible, remove the entire countertop and apply a bead of adhesive on the top edge of all cabinet bases for added strength)
- Insert mounting screws into each anchor location (correct screw diameter and length)
- Wipe away excess adhesive

13. Backsplashes (optional)

- Pre-mount backsplashes (check to ensure there are no gaps between countertop and backsplash or wall and backsplash) (scribing of the wall side of the backsplash is possible, but it can be a challenge)
- Remove backsplashes
- Mark correct length and cut to size (45°/butt cut)
- Apply a thin bead of silicone adhesive to underside and back of backsplash (hot glue if not using a fast-setting epoxy)
- Mount backsplash on top
- Clean any excess adhesive
- Allow adhesive to cure according to manufacturer's instructions

14. Finishing the countertops

- Clean all exposed surfaces with a soft wet cloth
- Allow time for surface to dry
- If backsplash is installed, use masking tape to assure clean, crisp caulk lines, then apply a bead of caulk to the seam where the backsplash meets the countertop, where the backsplash meets the wall and around the sink
- After caulk has been applied, remove masking tape guides
- When caulk is totally cured, apply wood finish of choice (i.e. Osmo® Top Oil, EcoProCote™ Acri-Soy™, PaperStone® Finish, etc. Refer to *PaperStone® Finish Guide*.)
- Buff aggressively with clean, dry cloths
- Allow to dry for at least 8 hours prior to use, or follow manufacturer's instructions