
Fabrication Guide

PRISM®
(*Solid Surface*)

ILLUSION
(*Solid Surface™*)

InPro Corporation has created this fabrication guide to assist fabricators and installers in the proper procedures for storing, handling, tooling, seaming, sanding, and polishing InPro's Prism Solid Surface and Illusion Solid Surface products.

All recommendations and information set forth in this fabrication guide must be verified by the user. InPro Corporation does not assume any legal responsibility. Questions on any of the methods or procedures should be addressed to InPro Corporation's Technical Services Department. Just call the Installation Hotline: 866.EZINPRO. For Sales, call 800.222.5556.

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IPC.764/REV.3



INPRO CORPORATION®
Interior and Exterior Architectural Products

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Questions?

Contact our Installation Hotline 866.EZINPRO
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Interior and Exterior Architectural Products

1.1 Ordering Information

PRICES

Prices are list. Prices are subject to change without notice.

ORDERING PROCEDURE

All orders must be placed by mail or fax using InPro Decorative Surfaces order forms, which are available at no charge. Verbal orders will not be accepted. At times we may request a wood template with exact dimensions to ensure the accuracy of your custom order. Paper templates are not acceptable.

ORDER CHANGES AND CANCELLATIONS

Items that have already been manufactured are charged at full value. Items being cancelled or changed that are already scheduled and set up for production are subject to the following charges:

Vanity tops and single flat products: \$141 list

Shower and tub surrounds: \$297 list

PACKAGING

Most products are individually packaged to provide maximum protection from factory to final destination (exception can be flat stock). Most vanity tops and sinks are packaged in specially designed corrugated cartons. Shower wall packages, tub surrounds, flatwork pieces and some vanity tops are packaged in wood crates. For additional protection, we palletize and band or stretch-wrap all orders. NOTE: Consolidated truckload shipments are not palletized.

DELIVERY & FREIGHT CLAIMS

As soon as you receive your InPro products, it is your responsibility to count all boxes and inspect for visible damage or shortages before signing the UPS Registry or Bill of Lading. Report all product damage or shortages within 10 days of receiving shipment and include a photo of this damage. Damage should be noted on the Bill of Lading. This also applies to instances of concealed freight damage. Product verified as broken upon delivery should be reported immediately. Concealed damage claims are only valid in shipment from InPro to the InPro ship to address. Any damage found after that point, InPro is not liable. Call InPro Decorative Surfaces Sales Support Specialists at 1-800-222-5556 with questions and claims.

IMPORTANT: Our products, like others in this industry, are subject to damage during shipping. As soon as the recipient has accepted the products in good condition, InPro Corporation responsibility ceases. Freight carriers will not honor a claim for concealed damage if the waybill is authorized clear. *It is important to inspect the contents of each carton immediately as it comes off the carrier.* If this is not possible, then inspect the carton carefully for dents, abrasions, signs of impact or markings. If the carton appears damaged, sign the waybill with the following notation: **Cartons have exterior markings, possible concealed damage. Inspect contents soon.** You must file a claim with the carrier within 15 days of your receipt of product if damage within the cartons is found.

NOTE: For full Delivery, Freight & Return Policy, see paperwork that arrives with every shipment.

RETURN MERCHANDISE

Due to the fact that most items are made to order, most items are non-returnable and non-refundable. Any merchandise that is returned to the factory must have written authorization in the form of a Return Authorization issued by InPro Corporation. A request for a return authorization must be accompanied by a digital photo. Your request to return product must be made with 90 days of receiving the product. Call the InPro Decorative Surfaces Sales Support Specialists at 1-800-222-5556 for a Return Authorization Number. Information will be faxed to you for you to complete, which may include: a Request to Return Material form, labels, bill of lading and call tags as applicable.

RUSH ORDERS

Add 15% or \$25 (whichever is greater) to order total when requesting a rush order.



Questions?

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1.2 Colors and Sizes

COLOR	PRICE CLASS	STANDARD SURFACE FINISH	HARD SEAMING ADHESIVE	SOFT SEAMING SILICONE
P9001 Antique White	A	220 grit	DSP9138SC	DSTS CLEAR
P9002 White Sand	A	220 grit	DSP9117SC	DSTS CLEAR
P9003 Monterey	A	220 grit	DSP9134SC	DSTS CLEAR
P9004 Eggshell	A	220 grit	DSP9102SC	DSTS CLEAR
P9005 Taupe	A	220 grit	DSP9117SC	DSTS CLEAR
P9006 Haze	A	220 grit	DSP9134SC	DSTS CLEAR
P9007 Light Beige	A	220 grit	DSP9134SC	DSTS CLEAR
P9008 Dover White	A	220 grit	DSP9104SC	DSTS CLEAR
P9009 Sea Salt	A	220 grit	DSP9108SC	DSTS CLEAR
P9010 Silver	A	220 grit	DSP9110SC	DSTS CLEAR
P9011 Bright White	A	220 grit	DSP9106SC	DSTS CLEAR
P9012 Sill White	A	220 grit	DSP9106SC	DSTS CLEAR
P9013 Lunar	B	220 grit	DSP9106SC	DSGFX130
P9014 Candlelight	B	220 grit	DSP9131SC	DSGFX501
P9015 Festival	B	220 grit	DSP9104SC	DSGFX402
P9016 Sandbar	B	220 grit	DSP9128SC	DSGFX301
P9017 Fieldstone	C	220 grit	DSP9144SC	DSGFX406
P9018 Autumn	B	220 grit	DSP9103SC	DSGFX301
P9019 Dolomite	B	220 grit	DSP9103SC	DSGFX040
P9020 Coral Drift	C	220 grit	DSP9103SC	DSGFX040
P9021 Chipotle	B	220 grit	DSP2170SC	DSGFX307
P9022 Mountain Mist	B	220 grit	DSP9121SC	DSGFX310
P9023 Gunmetal	B	220 grit	DSP9118SC	DSGFXC1131
P9024 Bedrock	B	220 grit	DSP9113SC	DSGFXC1131
P9025 Galaxy	B	220 grit	DSP9114SC	DSGFX121
P9026 Rouge	B	220 grit	DSP9125SC	DSTS CLEAR
P9027 Mulberry	B	220 grit	DSP9151SC	DSGFXC1110
P9028 Raisin	B	220 grit	DSP9151SC	DSGFX502
P9029 Java	C	220 grit	DSP9136SC	DSGFX471
P9030 Tumbleweed	C	220 grit	DSP9142SC	DSGFX040
P9031 Trail	C	220 grit	DSP9103SC	DSGFX070
P9032 Spa	C	220 grit	DSP9100SC	DSGFXC1114
P9033 Pesto	B	220 grit	DSP9142SC	DSGFXC1111
P9034 Raindrop	B	220 grit	DSP9108SC	DSGFXC1114
P9035 Peacock	B	220 grit	DSP9111SC	DSGFXC1112
P9036 Spruce	B	220 grit	DSP9112SC	DSGFXC1112
P9037 Breeze	B	220 grit	DSP9110SC	DSTS CLEAR
P9038 Cosmic	B	220 grit	DSP9145SC	DSGFXC1122
P9039 Admiral	B	220 grit	DSP9114SC	DSGFXC1147

* Color chart continues on next page *

1.2



Questions?

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INPRO CORPORATION
Interior and Exterior Architectural Products

1.3 Colors and Sizes

PRISM COLOR	PRICE CLASS	STANDARD SURFACE FINISH	HARD SEAMING ADHESIVE	SOFT SEAMING SILICONE
P9040 Twilight	B	220 grit	DSP9145SC	DSGFXC1147
P9041 Angora	B	220 grit	DSP9105SC	DSTS CLEAR
P9042 Fossil	C	220 grit	DSP9100SC	DSGFX406
P9043 Risotto	C	220 grit	DSP9134SC	DSGFX402
P9044 Haystack	C	220 grit	DSP9103SC	DSGFX060
P9045 Curry	B	220 grit	DSP9103SC	DSGFX312
P9046 Macadamia	C	220 grit	DSP9103SC	DSGFX312
P9047 Gingerbread	B	220 grit	DSP9107SC	DSGFXC1119
P9048 Salt Crystal	B	220 grit	DSP9108SC	DSGFXC1114
P9049 Pine	C	220 grit	DSP9113SC	DSGFXC1111
P9050 Tea Leaf	B	220 grit	DSP9133SC	DSGFXC1113
P9051 Denim	B	220 grit	DSP9130SC	DSGFXC1122
P9052 Riptide	C	220 grit	DSP9100SC	DSTS CLEAR
P9053 Pebbles	C	220 grit	DSP9103SC	DSTS CLEAR
P9054 Gravel	C	220 grit	DSP9100SC	DSGFX502
P9055 Glacier	C	220 grit	DSP9105SC	DSGFX130
P9056 Milkyway	C	220 grit	DSP9122SC	DSGFX501
P9057 Creole	C	220 grit	DSP9103SC	DSGFX307
P9058 Parchment	C	220 grit	DSP9128SC	DSGFX060
P9059 Mahogany	C	220 grit	DSP9136SC	DSGFX502
P9060 Papyrus	C	220 grit	DSP9103SC	DSGFX070
P9061 Brickle	C	220 grit	DSP9144SC	DSGFX219
P9062 Gold Rush	C	220 grit	DSP9151SC	DSGFX471
P9063 Harvest	C	220 grit	DSP9103SC	DSGFX504
P9064 Snake Skin	C	220 grit	DSP9107SC	DSGFXC1140
P9065 Everest	C	220 grit	DSP9121SC	DSGFXC1131
P9066 Portabella	C	220 grit	DSP9107SC	DSGFX040
P9067 Moonwalk	C	220 grit	DSP9129SC	DSGFX501
P9068 Wasabi	B	220 grit	DSP9112SC	DSGFXC1111
P9069 Nougat	B	220 grit	DSP9104SC	DSGFX312
P9070 Meteorite	C	220 grit	DSP9113SC	DSTS CLEAR
I8001 Yellowstone	D	140 grit	DSP9133SC	DSTS CLEAR
I8002 Wet Sand	D	140 grit	DSP9133SC	DSTS CLEAR
I8003 Pebblestone	D	140 grit	DSP9103SC	DSTS CLEAR
I8004 Pillar	D	140 grit	DSP9104SC	DSTS CLEAR
I8005 Oyster	D	140 grit	DSP9128SC	DSTS CLEAR
I8006 Cypress	E	140 grit	DSP9125SC	DSTS CLEAR
I8007 Pottery	D	140 grit	DSP9103SC	DSTS CLEAR
I8008 Amazon	D	140 grit	DSP9113SC	DSTS CLEAR
I8009 Riverbed	E	140 grit	DSP9121SC	DSTS CLEAR
I8010 Cliff	E	140 grit	DSP9133SC	DSTS CLEAR

1.3



Questions?

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INPRO CORPORATION
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1.4 Colors and Sizes

Prism Sheet Goods in all 70 standard colors are available in the following thicknesses and sizes:

Prism Standard Sheet Sizes:

Sheet Thickness (Inches)	Size: Width x Length (Inches)
1/4	30 x 96
1/4	30 x 120
1/4	30 x 144
1/4	36 x 96
1/4	36 x 120
1/4	36 x 144
1/4	48 x 96
1/4	48 x 120
1/4	48 x 144
1/2	30 x 96
1/2	30 x 120
1/2	30 x 144
1/2	36 x 96
1/2	36 x 120
1/2	36 x 144
1/2	48 x 96
1/2	48 x 120
1/2	48 x 144



Questions?

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1.5 Colors & Sizes

Illusion Sheet Goods in all 10 standard colors are available in the following thicknesses and sizes:
Exception: See Note 2) below.

Illusion Standard Sheet Sizes:

Sheet Dimensions	Sheet Thickness		
	1/4"	1/2"	2cm
Width X Length			
27" X 120"			X
27" X 144"			X
30" X 120"	X	X	X
30" X 144"	X	X	X
36" X 120"	X	X	X
36" X 144"	X	X	X
48" X 96"		X	X
48" X 120"		X	
48" X 144"		X	
60" X 120"		X	

Notes:

- 1). "X" indicates that sheets are available in the noted sheet dimension and thickness.
- 2). I8006 Cypress, I8009 Riverbed, and I8010 Cliff sheets are only available in 1/2" and 2cm thickness.
- 3). Additional panel sizes are available for tub and shower walls. Panel sizes include both 72" and 96" heights by 36", 48", and 60" widths. A 60"x60" panel is also available.
- 4.) Additional 2cmx27" wide vanity blanks are available in lengths ranging from 39" to 81".



Questions?

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1.6 Performance Properties of Prism

PROPERTY	TEST	RESULT
Tensile Strength	ASTM D 638	4,500 psi
Tensile Modulus	ASTM D 638	1.7 x 10 ⁶ psi
Elongation	ASTM D 638	.45% min.
Flexural Strength	ASTM D 790	7,000 psi
Flexural Modulus	ASTM D 790	1.5 x 10 ⁶ psi
Specific Gravity	ASTM D 792	1.7
Weight per Square Foot		¼" – 2.2 lbs. ½" – 4.4 lbs.
Hardness, Rockwell M	ASTM D 785	90
Hardness, Barcol Impressor	ASTM D 2583	58
Thermal Expansion	ASTM D 696	2.3 x 10 ⁵ in./in./deg. F
Izod Impact, Notched	ASTM D 256A	.69 ft.lb./in.
Impact Resistance, Sheets	NEMA LD-3-3.3 1/2lb. ball	¼" – 36" drop, No fracture ½" – 144" drop, No fracture
Water Absorption, 24hrs.	ASTM D 570	¼" – .038% ½" – .025%
Boiling Water Resistance	NEMA LD-3-3.5	No change
High Temperature Resistance	NEMA LD-3-3.6	No change
Fungus and Bacteria Resistance	ASTM G 21 and G 22	No support of growth
Color Stability	NEMA LD-3-3.10	No change
Gloss Level, 60° Gardner	ANSI Z124	3-30 (matte to semi-gloss)
Wear and Cleanability	ANSI Z124.3, Z124.6	Pass
Stain Resistance, Sheets	ANSI Z124.3, Z124.6	Pass
Flammability – Surface Burning Characteristics	ASTM E 84, UL723, NFPA 255 Flame Spread(FS) Smoke Density(SD)	¼" – FS = 10 SD = 75, Class A or I ½" – FS = 5 SD = 20, Class A or I
Note: Prism Solid Surface products meet or exceed ANSI Z124.3 and ANSI Z124.6 standards for plastic sinks and lavatories, as well as, ANSI/ICPA SS-1 (Performance Standard for Solid Surface Materials). 1.6		



Questions?

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1.7 Performance Properties of Illusion

Table 1 – Flammability and Food Compliance Rating

Property Tested	Standard	Testing Results
Flame-Spread Index	ASTM E 84-01	Class I
Smoke Developed Index	ASTM E 84-01	Class A
Food Compliance Rating	NSF/ANSI 51	Food Prep

Table 2- Summary of ISSFA Testing for Performance Properties

Consistency of Color (Same Sheet) ISSFA SST 2-1.00	Pass	Pass
Clean Ability Stain Rating ISSFA SST 3.1-00	26 (15/11) Pass	16 (10/6) Pass
Visual Defects ISSFA SST 5.1-00	Pass	Pass
Light Resistance ISSFA SST 7.1-00	No Effect- Pass	No Effect- Pass
Boiling Water Resistance ISSFA SST 8.1-00 (Referencing NEMA LD3-3.5)	No Effect- Pass	No Effect- Pass
High Temperature Resistance ISSFA SST 9.1-00 (Referencing NEMA LD3-3.6)	No Effect- Pass	No Effect- Pass

Table 3 – Summary for Engineering Properties

Radiant Heat Resistance NEMA LD3-3.10	600+ seconds Pass	600+ seconds Pass
Linear Thermal Expansion (ASTM E 228-95)	4.62 x 10-5 mm/mm C (2.57 x 10-5 in./in. F) Pass	5.01 x 10-5 mm/mm C (2.79 x 10-5 in./in. F) Pass
Flexural Strength (PSI) ASTM D-790-99	50.6 Mpa (7333 PSI) Pass	41.90 Mpa (6077 PSI) Pass
Flexural Modulus (MPSI) (ASTM D-790-99)	8895 Mpa (1.29 MPSI) Pass	7791 Mpa (1.13 MPSI) Pass
Barcol Hardness (ASTM D 2583-95)	62 Pass	61 Pass
Flatness of Sheets ISSFA SST 4.1-00	Length-<0.25 mm (<0.010 in.) Negative Warp Width-<0.25 mm (0.010 in. Positive Warp-Pass	Length-<0.25 mm (<0.010 in.) Negative Warp Width-<0.25 mm (0.010 in. Positive Warp-Pass
Impact Resistance ISSFA SS-T 6.1-00	Pass at 1525 mm (60 in.) Thickness= 0.46450	Pass at 1525 mm (60 in.) Thickness= 0.47800 in.



2.1 Precautions

Health and Safety Information

For Sheet And Shaped Products:

Prism solid surfacing material is non toxic. Sawing, routing and sanding produces dust that is considered nuisance dust.

First Aid Procedures

Inhalation:

Nuisance Dust—If respiratory irritation occurs get fresh air. If symptoms persist, consult a physician. Contact physician if irritation persists.

Skin or Eye:

Nuisance Dust—If skin or eye irritation occurs, wash skin and flush eyes with water for at least 15 minutes. If symptoms persist, consult a physician.

Exposure Control Methods

Use dust collection devices in works areas and on all fabrication equipment. Wear protective masks, eyewear and gloves when sanding and machining Prism Sheet.

Disposal Procedures

Collect dust and scrap from fabrication and dispose of the dust and scrap in accordance with local, state and federal regulations.



Questions?

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2.2 Precautions

Repair Kit, Unsaturated Polyester Resin

Acute Exposure:

INHALATION: Harmful if inhaled. Effects from exposure may include headaches, fatigue, nausea, sensation of drunkenness, central nervous system depression and pulmonary edema. Inhalation of vapor or aerosol may cause irritation to the respiratory tract (nose, throat, and lungs). May cause respiratory sensitization in susceptible individuals.

SKIN: Harmful if absorbed through skin. Contact causes skin irritation. Prolonged or repeated skin contact can result in defatting and drying of the skin. Contact may cause skin sensitization, an allergic reaction which becomes evident on re-exposure to this material.

EYES: Harmful to eyes. Direct contact with this material causes eye irritation. Symptoms may include stinging, tearing, redness and swelling.

INGESTION: Harmful if swallowed. Single dose oral toxicity is low. Swallowing small amounts during normal handling is not likely to cause harmful effects; swallowing large amounts may be harmful. Effects from exposure through ingestion may include gastrointestinal disturbances, pain and discomfort. Effects of exposure by ingestion may also include those indicated by the inhalation route. Styrene is harmful or fatal if liquid is aspirated into the lungs. Ingestion is not an anticipated route of exposure for this material in industrial use.

Chronic Exposure: Overexposure to this material (or its components) has been suggested as a cause of the following effects in humans and may aggravate pre-existing disorders of these organs; central nervous system effects, effects on hearing and respiratory tract damage. Prolonged or repeated exposure may cause liver and kidney damage.

Carcinogenicity: This material contains styrene which is listed by the International Agency for Research (IARC) on Cancer as a group 2B cancer causing agent (possibly carcinogenic to humans).

FIRST AID MEASURES

Eye Contact: Immediately flush eyes with large quantities of clean water for at least 15 minutes. Get immediate medical attention.

Skin Contact: Wash skin with soap and water. Remove contaminated clothing. Get medical attention if irritation develops or persists. Wash contaminated clothing before reuse.

Ingestion: DO NOT INDUCE VOMITING. **ASPIRATION HAZARD:** this material may enter the lungs during vomiting. Immediately give the victim one or two glasses of water or milk to drink. Never give anything by mouth to an unconscious person. GET IMMEDIATE MEDICAL ATTENTION.

Inhalation: Remove victim to fresh air. Keep warm and quiet. If not breathing, give artificial respiration. If breathing is difficult, give oxygen by trained personnel. GET IMMEDIATE MEDICAL ATTENTION.



2.3 Precautions

Solid Surface Adhesive

WARNING: Flammable.

Eye, Skin and respiratory tract irritant.

Harmful if inhaled or absorbed through the skin.

Chronic overexposure may cause liver and kidney effects.

PRECAUTIONS:

Keep away from heat sparks or open flames.

Avoid breathing vapor.

Use with adequate ventilation or use proper respiratory equipment.

Wear suitable protective clothing.

Wash thoroughly after handling.

Do not take internally.

Keep container closed when not in use.

FIRST AID

Eyes: Flush with water for 15 minutes. Get immediate medical attention.

Skin: Remove contaminated clothing and excess contaminant; wash skin with soap and water.

Inhalation: Remove to fresh air.

Ingestion: Get immediate medical assistance.

Storage: Store in a cool dry place at a temperature between 50°F and 70°F. Do not freeze.

Keep out of reach of children



Questions?

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2.4 Precautions

Solid Surface Adhesive (continued)

250 ml cartridges fit hand-held manual and pneumatic dispensing guns. Static nozzles provide mixing while dispensing. High-Strength, Durable Bonds. Ideal for All Surfacing Materials. Mixed as Dispensed. Fast, Room-Temperature Cure

Uncured Adhesive Activator

Viscosity cps x 1000 20 – 35 18–28

Color Clear Translucent white

Weight lbs/gal 9.1 9.4

Mix Ratio by Volume 10 1

Flash Point 51°F (10°C)

Mixed Viscosity cps x 1000 18 – 35

Open/Working Time minutes 8 – 12 @ 72°F (22°C)

Assembly/Fixture Time minutes 15–20 @ 72°F (22°C)

Functional Cure minutes 50–60 @ 72°F (22°C)

Cured* Acrylic Polyester

Tensile Strength (ASTM M-638) psi 3,850 3,400

Flexural Strength psi 5,800 5,950

Tensile Elongation % 6.9

Impact Strength (NEMA LD3) ft - lbs 4.6

Water Absorption (ASTM D-570) % 0.26

Water Resistance (ICPA SS-1) cycles 250

Hardness (Barcol) 34/42

*Based on independent laboratory testing.

Adhesive is 100% reactive and contain no solvents.



Questions?

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2.5 Storage and Handling

Handling Prism and Illusion Solid Surface Sheets

Moving Single Sheets

Protect the surface from possible scratching. When lifting Prism Sheet, wear leather gloves and safety shoes. Lift only one sheet at a time. Use two people to lift solid surface sheets. Lift the sheet at the ends, holding it upright in a vertical position. Follow safe lifting practices when lifting heavy objects. Take extra care when transporting sheet material with cutouts. Crating or support rails may be required to prevent breakage.

Moving Several Sheets

Move larger quantities of sheet with a forklift, centering sheet on the forks.

Storing sheet

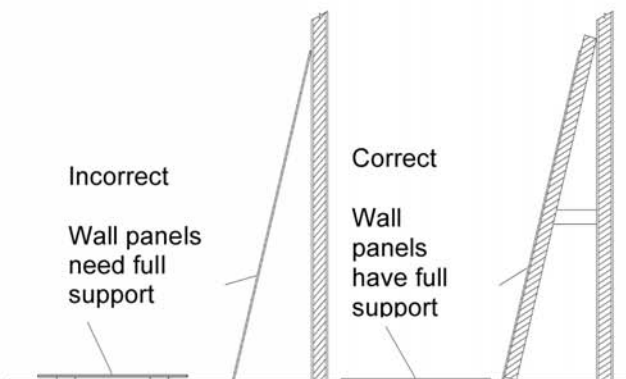
Store sheets on shipping skids on well-supported horizontal racks. Temporarily store sheets vertically in work areas, supporting the sheet from behind to prevent warping. Do not store sheets outside. Store sheets in interior, environmentally controlled areas with temperatures between 60°F and 80°F. Avoid moisture when storing solid surface material.

Storing Bowls

To store bowls lay them on a flat surface on the rim of the bowl.

Transporting fabricated sheet

Transport large fabricated pieces on edge. Support or brace the sheet to prevent damage and pad the edges to prevent chipping. Do not let material sit in extreme temperatures or direct sunlight. Allow material to acclimate to the installation area temperature before installing.



Material Handling Cart



Questions?

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2.6 Storage and Handling

Prism Sheet Goods are typically shipped on pallets and should be unloaded using a forklift with a minimum of 6' forks. See chart below for pallet and weight specifications for all sheet thicknesses and sizes.

Sheet Size (in)	Weight/Sheet (lbs)	Empty Pallet Weight (lbs)	10 Sheets + Pallet Weight (lbs)
¼ x 30 x 96	44	78	518
¼ x 30 x 120	55	99	649
¼ x 30 x 144	66	114	774
¼ x 36 x 96	52.80	91	619
¼ x 36 x 120	66	116	776
¼ x 36 x 144	79.20	137	929
¼ x 48 x 96	70.40	105	809
¼ x 48 x 120	88	138	1,018
¼ x 48 x 144	105.60	175	1,231
½ x 30 x 96	88	78	958
½ x 30 x 120	110	99	1,199
½ x 30 x 144	132	114	1,434
½ x 36 x 96	105.60	91	1,147
½ x 36 x 120	132	116	1,436
½ x 36 x 144	158.40	137	1,721
½ x 48 x 96	140.80	105	1,513
½ x 48 x 120	176	138	1,898
½ x 48 x 144	211.20	175	2,287

NOTE: All pallets are 6" high and 2" longer in width and length than the sheet size.



Questions?

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2.7 Prism MSDS



Material Safety Data Sheet

May be used to comply with OSHA's Hazard Communication Standard, 29 CFR 1910.1200.
Standard must be consulted for specific requirements.

U.S. Department of Labor

Occupational Safety and Health Administration
(Non-Mandatory Form)
Form Approved OMB No. 1218-0072

IDENTITY	
Prism Solid Surface	

Section I

Manufacturer's Name	Telephone Number for Information
InPro Corporation S80 W18766 Apollo Drive PO Box 406 Muskego, WI 53150	800.222.5556

Section II - Hazard Ingredients/Identity Information

Hazardous Components (Specific Chemical Identity; Common Name(s))	OSHA PEL	ACGIH TLV	Other Limits Recommended	%(optional)
Totally polymerized mixture of polyester resin, hydrated alumina ($\text{Al}_2\text{O}_3 \cdot 3\text{H}_2\text{O}$), may contain up to 2% titanium dioxide (TiO_2); Cast Polymer; Solid Surface Material				
OSHA PEL - N/A;	ACGIH TLV - N/A;	Other Limits - N/A		

Section III - Physical/Chemical Characteristics

Boiling Point	N/A	Specific Gravity ($\text{H}_2\text{O} = 1$)	N/A
Vapor Pressure (mm Hg.)	N/A	Melting Point	N/A
Vapor Density (AIR = 1)	N/A	Evaporation Rate (Butyl Acetate = 1)	N/A
Solubility in Water - Insoluble			

Section IV - Fire and Explosion Hazard Data

Flash Point (Method Used) - N/A	Flammable Limits - N/A	LEL - N/A	UEL - N/A
Extinguishing Media - Water			
Special Fire Fighting Procedures - None			
Unusual Fire and Explosion Hazards - None			

(Reproduce locally)
N/A = Not applicable

OSHA 174, Sept. 1985

2.7



Questions?

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2.8 Prism MSDS

Section V - Reactivity Data

Stability	Unstable		Conditions to Avoid - None
	Stable	X	
Incompatibility (<i>Materials to Avoid</i>) - None			
Hazardous Decomposition or Byproducts - N/A			
Hazardous Polymerization	May Occur		Conditions to Avoid - None
	Will Not Occur	X	

Section VI - Health Hazard Data

Route(s) of Entry:	Inhalation - X	Skin - N/A	Ingestion - N/A
Health Hazards (<i>Acute and Chronic</i>) - Non-Hazardous			
Carcinogenicity:	NTP - N/A	IARC Monographs - N/A	OSHA Regulated - N/A
Signs and Symptoms of Exposure -	Not applicable		
Medical Conditions Generally Aggravated by Exposure -	Not applicable		
Emergency and First Aid Procedures -	Not applicable		

Section VII - Precautions for Safe Handling and Use

Steps to Be Taken in Case Material is Released or Spilled - Use normal good housekeeping procedures
Waste Disposal Method - Landfill as normal (non-hazardous) waste
Precautions to Be taken in Handling and Storing - None
Other Precautions - None

Section VIII - Control Measures

Respiratory Protection - Use dust mask for nuisance dust (29CFR1910.134)		
Ventilation	Local Exhaust - X	Special
	Mechanical (General)	Other
Protective Gloves - Not required	Eye Protection - Use safety glasses or goggles when sawing, drilling, routing, etc	
Other Protective Clothing or Equipment - None		
Work/Hygienic Practices - Normal good housekeeping procedures		

U.S.G.P.O.: 1986 - 491 - 529/45775

7/25/02



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2.9 Illusion MSDS



MATERIAL SAFETY DATA SHEET

SECTION I-CHEMICAL PRODUCT AND COMPANY INFORMATION

DISTRIBUTOR: InPro Corporation
S80 W18766 Apollo Dr.
Muskego, WI 53150

CHEMICAL FAMILY: filled cured unsaturated polyester

SECTION II- HAZARDOUS COMPONENTS

COMPONENT	CAS #	%	PEL/STEL
Styrene Monomer	100-425	<1.0	50PPM
Cured Unsaturated polyester resin	N/A	35-38	N/A
Alumina Trihydrate	21645-51-2	62-65	N/A

SECTION III

PHYSICAL PROPERTIES	ILLUSION SURFACE
Appearance and Odor:	Marble like solid, no odor
Boiling Point:	N/A
Specific Gravity:	1.75
Solubility in Water	Not Soluble

SECTION IV

FIRE AND EXPLOSION DATA:	ILLUSION SURFACE
Flash Point:	N/A
Flammable Limits:	N/A
FIRE EXTINGUISHING MEDIA:	Water spray, CO2 or dry chemical
SPECIAL FIRE FIGHTING PROCEDURES:	Evacuate area, Wear full protective equipment including self breathing apparatus.
UNUSUAL FIRE AND EXPLOSION HAZARDS:	None
HAZARD CLASSIFICATION:	Not Flammable

2.9



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2.10 Illusion MSDS

SECTION V – REACTIVITY DATA

Stability:	Stable
Conditions to avoid:	None known
Polymerization:	Will not occur
Condition to avoid:	None known

HAZARDOUS DECOMPOSITION PRODUCTS:

Thermal decomposition or combustion may produce carbon monoxide, carbon dioxide, smoke, oxides of nitrogen or styrene. For related health hazards see Section VI.

SECTION VI- HEALTH HAZARD INFORMATION:

EFFECTS OF OVEREXPOSURE:	Material are not toxic but during fabrication process such as sawing or routing can cause the emission of dust or very low concentrations of styrene vapor.
SKIN:	Contact with dust may cause irritation.
EYES:	Contact with dust may cause severe eye irritation.
INHALATION:	Contact with dust may cause irritation of the respiratory tract. High concentration of styrene vapor may result in headache, nausea, insensibility, and other central nervous system disorders.
INGESTION:	Not expected to cause health hazards.

FIRST AID:

SKIN:	Wash skin thoroughly with soap and water for 15 minutes and get medical attention if symptoms persist.
EYES:	Immediately flush with water for 15 minutes. Get medical attention if symptoms persist.
INHALATION:	Remove patient to fresh air. If symptoms persist contact physician.
INGESTION:	None
PRIMARY ROUTE OF ENTRY:	Inhalation, skin contact and eye contact.
CHRONIC HEALTH HAZARDS:	The International Agency for Research on Cancer (IARC) has classified styrene as a possible human carcinogen (class 2B). The IARC 2B classification is not based on significant new evidence but on a revised IARC classification scheme and data on styrene oxide.

2.10

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Interior and Exterior Architectural Products

2.11 Illusion MSDS

SECTION VII- EXPOSURE CONTROL METHODS

RESPIRATORY PROTECTION:

Ensure adequate ventilation to maintain exposure levels below limits stated in Section II. If levels exceed these limits use NIOSH approved organic vapor cartridge respirator with full face. The effectiveness of air purifying respirator is limited. For emergency and other conditions when short-term limits may be exceeded use approved positive pressure self-contained breathing apparatus.

VENTILATION: Use only with adequate ventilation

PROTECTIVE GLOVES: Leather or cotton

WORK/HYGIENE PRACTICES: Wear safety shoes. Have immediate access to soap, water, and eye irrigation.

EYE PROTECTION: Safety glasses

SECTION VIII- SPILL OR LEAK PROCEDURE

STEPS TO BE TAKEN IN CASE MATERIAL IS RELEASED OR SPILLED:

Evacuate area. Ventilate area to remove fumes. Avoid skin contact. Collect spills with absorbent materials. Avoid exposure of personnel to toxic concentration of vapor and guard against accidental fire and explosion.

WASTE DISPOSAL:

Material in unused form is hazardous under RCRA and should be disposed accordingly. Solidified and/or scrap finished product is non-hazardous under RCRA. Check local regulations for details on disposal. For further information, contact your state or local solid waste agency or US EPS's RCRA hotline (800) 424-9346 or (202) 382-3000.

SECTION IX- DISCLAIMER

The information and statements in the MSDS sheet were obtained from sources, which we believe are reliable. However, the information is provided without any representation or warranty, expressed or implied, regarding its accuracy or completeness. User should undertake sufficient verification and testing to determine the suitability for a particular purpose of any information or products referred to herein.



Questions?

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3.1 Tooling

Fabrication Tools

Cutting tools

Horizontal table saw and vertical panel saw – best for cutting width and length.

Portable circular saw – Suitable for rough cutting on site.

Carbide tipped blades are recommended. Use blades with triple chip grind.

Jig-saw – Suitable for rough cutting radii and curves. Use metal cutting blades

Machining Tools

Plunge router – for cutting sinks and faucets holes

Coving router – for cutting coved backsplash

Router bits - carbide router bits are recommended



Coving Router



Coving Router

Sanding and Polishing

Belt sander – for rough sanding large horizontal surfaces. Do not use for leveling.

Pad/orbital sander – for sanding all horizontal surfaces

Orbital polisher – used to finish surface

Profile sander – used to sand and finish cutouts and radii.



Dynabrade Sander



Fein Random Orbit Sander

3.1



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3.2 Tooling



Scotch-Brite Polishing Pad, #7448, Gray, Ultra Fine



GEM 11" Orbital Polisher



Adhesive Dispenser



Hot Glue Gun and Glue Sticks

Sandpaper Grading System Comparison Chart

Micron	CAMI	(FEPA) P-Grade
116 Micron	120	P120
100 Micron	150	P150
80 Micron	180	P180
60 Micron	220	P220
40 Micron	320	P400
30 Micron	400	P800
15 Micron	600	P1200

To order tools and solid surface fabrication accessories contact Pinske Edge at 1-800-T-PINSKE

3.2



Questions?

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3.3 Seaming

Seaming Sheets

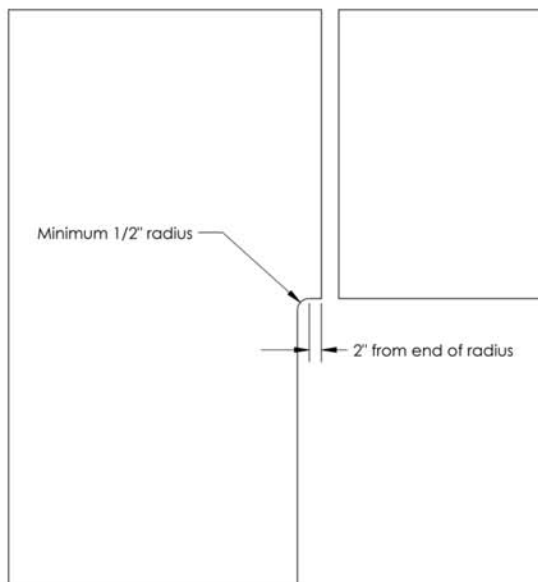
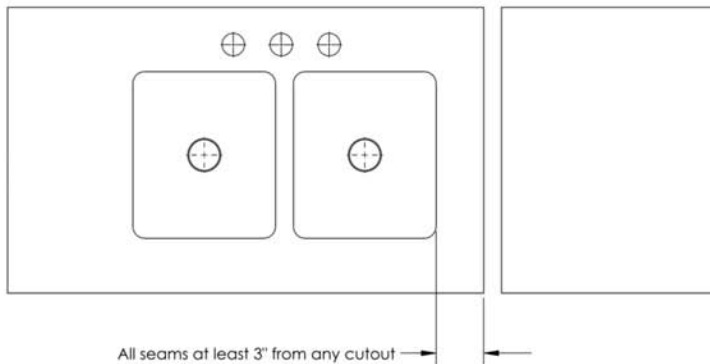
Note: Offset seams 2" from inside corners. Never have seams at corners. Do not have seams over dishwashers or other cutouts. Keep seams 3" away from cutouts Drop-edge inside corners require a 1" radius.

Seam placement guidelines

- Keep all seams 3" away from any cutout
- No seams through any cook top
- No seams in an overhang on an island or peninsula
- No seams through sinks cutouts

Cutting Guidelines

- Inside comers must have a minimum of a 1/2" radius including cutouts
- Square corners are not allowed

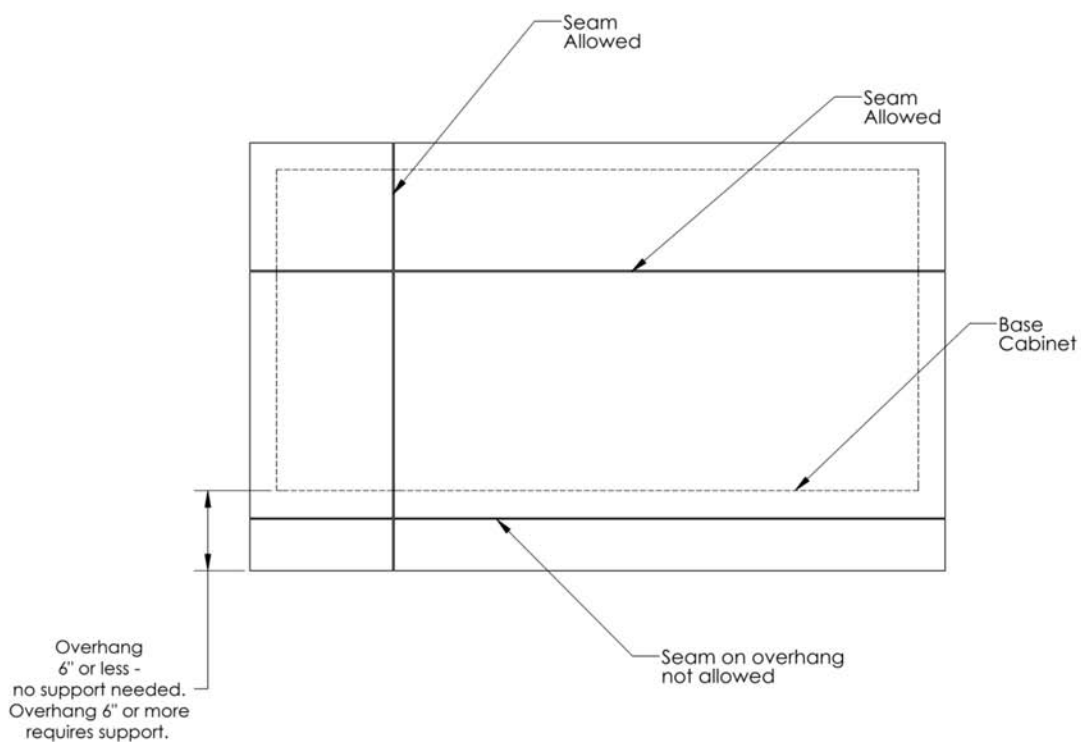


3.3



Questions?

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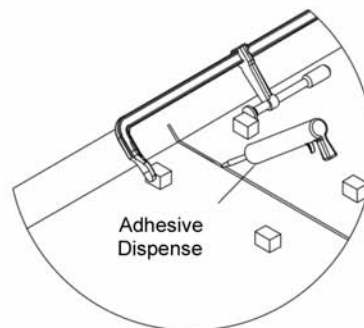
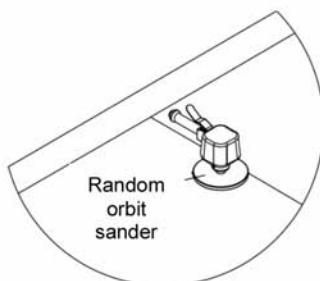
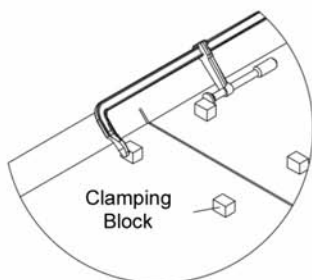
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3.5 Seaming

1. Router edges with a bit using the mirror cut method. Dry fit the seam. Lightly sand the two surface to be joined. Wipe with de-natured alcohol before gluing.
 - a. Mirror cutting is a method that produces a finished edge on two pieces of sheet in a single pass. Clamp the two pieces of sheet 1/4" apart. Sheets must be on the same plane or coplanar. Clamp a straight edge on one side, so the router will cut both edges with a single pass.
 - b. Seaming Illusion Material:
A new seaming technique has been introduced to the Solid Surface market by Kevin Andreas of Andreas Custom Design. This new serpentine edge template called the Andreas Wiggle is recommended for seaming the Illusion products. In addition to providing more surface area when seaming, the unique wavy shape weaves the seam in and out of the constantly changing color pattern of the material making the seam virtually undetectable. Standard seam blocking and edge abrading procedures should be followed in accordance with the Prism/Illusion Fabrication Manual.

Contact information:
Andreas Custom Design
80 Black Meadow Rd.
Chester, NY 10918
(800) 774-6744
andreascustomdesign.com

2. Place clear tape beneath the joint before applying the adhesive. Allow 1/8" gap between sheets. Sheets must be on the same plane or coplanar.
3. Apply 2" x 2" x 1/2" blocks of scrap prism material on either side of the seam with hot melt glue.
4. Apply the solid surface adhesive to the joint going up the length of the seam and back down the length of the seam.



3.5

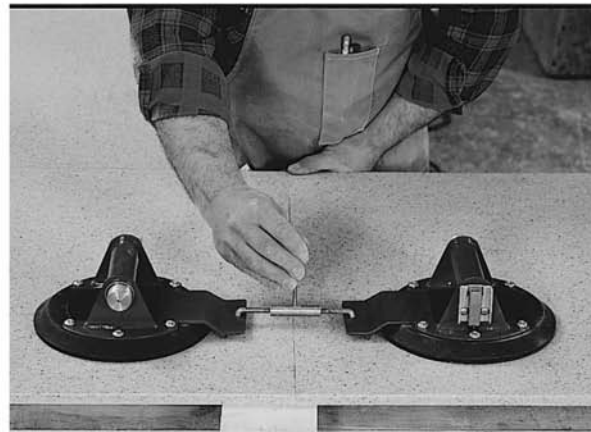
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3.6 Seaming

5. Attach clamps on the blocks of material; draw the seam together making sure not to over tighten the seam. Over tightening, the seam will squeeze too much adhesive out and cause a dry seam.
6. After the adhesive cures, remove the clamps and pry off the blocks. Remove excess dried adhesive with a router and planing bit. Do not use a chisel to remove excess adhesive; only use a router or sander.
7. Remove the remaining adhesive, with an orbital sander starting 100 micron (P-grade, P120 grit) sandpaper.
8. Continue sanding using 60 micron (P-grade, P220 grit), followed by a maroon or gray Scotch-brite pad until a matte or semi-gloss finish is achieved.
9. Reinforce each seam, from the back, with a 6" wide seam block. Bevel both edges of the seam block.



Pinsky Power Grips



Questions?

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3.7 Seaming



Surfacing Adhesive



Adhesive Dispenser



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3.8 Support

Support

All tops need to be supported every 12"

Normal countertop can be supported with wood strips.

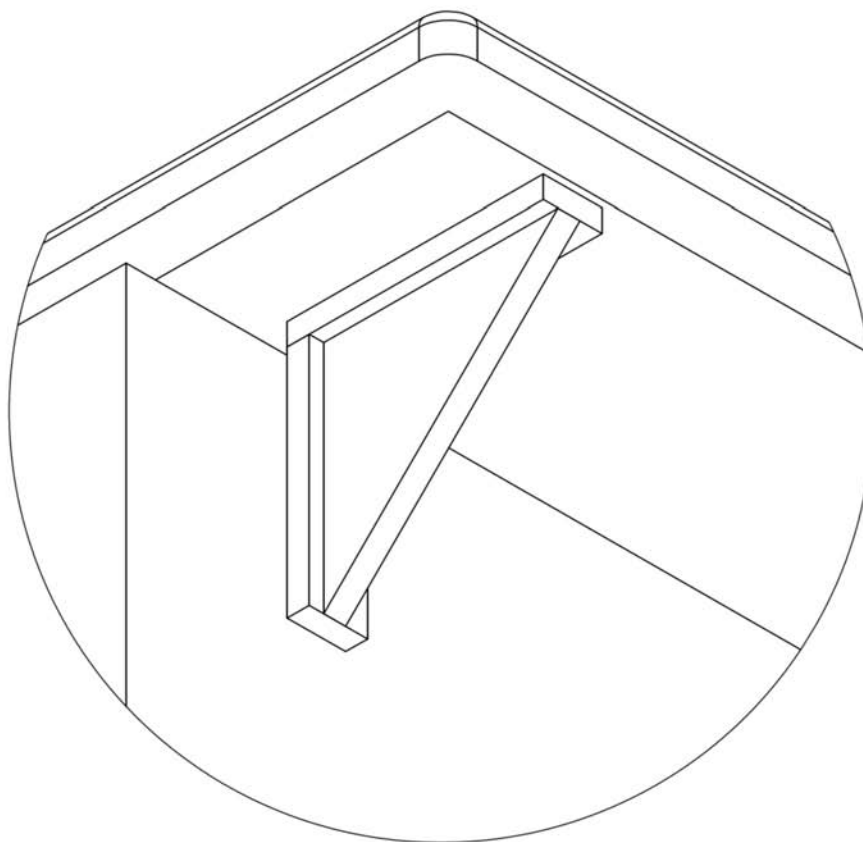
Overhangs of 7" to 15" need to be supported with plywood or support brackets.

Plywood Support

For full plywood under mount, screw the support to the Cabinet from the top. Silicone the top to the plywood.

Support Brackets

Install brackets every 24". Front of brackets must mount within 5" of the edge of the counter. Attach brackets to the cabinet with back plate. Attach countertop to the bracket supports with silicone sealant..



3.9 Edge Treatment

Edge Buildups

Create buildup edges by cutting $\frac{1}{2}$ " material 2" deep by the length of the edge.

Hot melt blocks of mdf along the line where the back edge of the buildup strips will align.

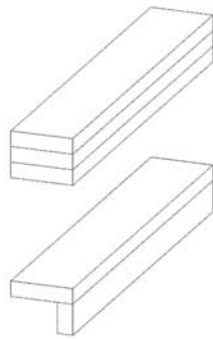
Apply solid surface adhesive to the front and back edge and middle of the spot where the buildup edges will be glued.

Glue the second buildup strip in a similar manner.

Clamp the edge buildup with spring clamps every 2-3 inches.

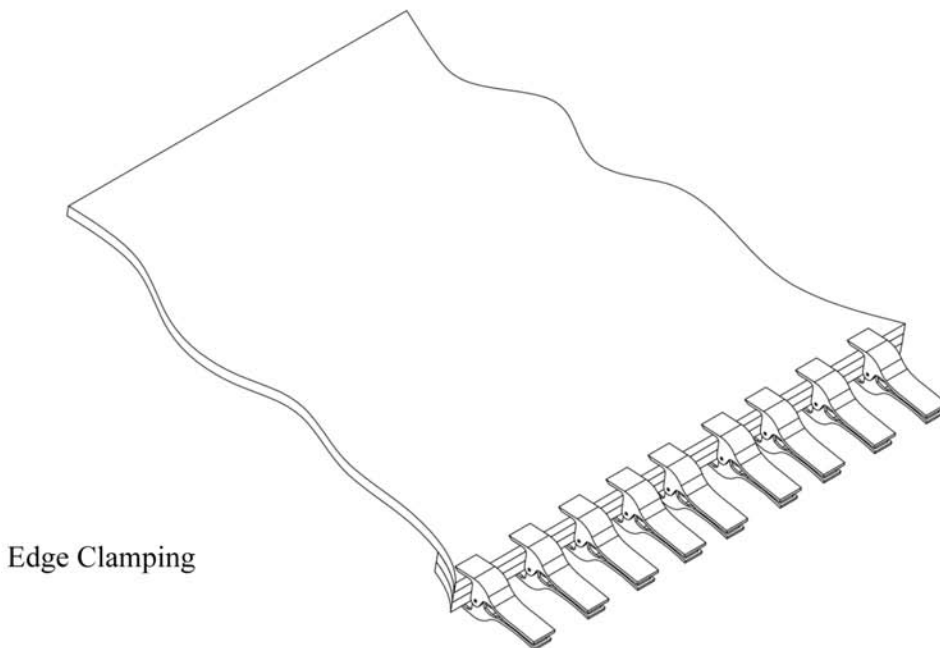
Once cured, route the front edge of the edge of the buildup square with the top. Edge inlays are achieved by gluing material of a different color between the top and bottom build-up pieces.

Drop edge buildups are not recommended.



Built-up Edge - Recommended

Drop Edge - Not recommended



Edge Clamping

3.9

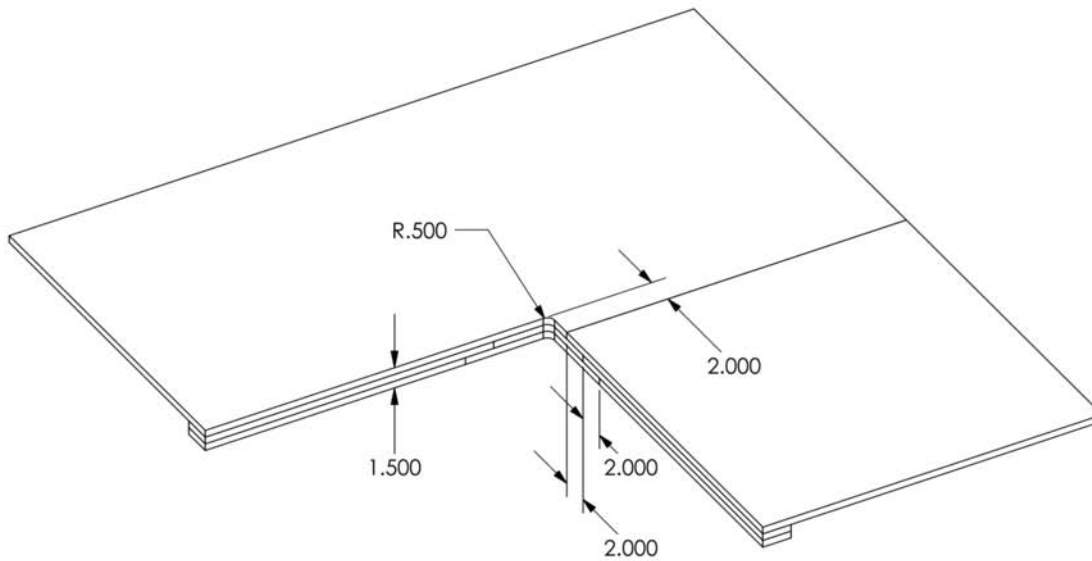


Questions?

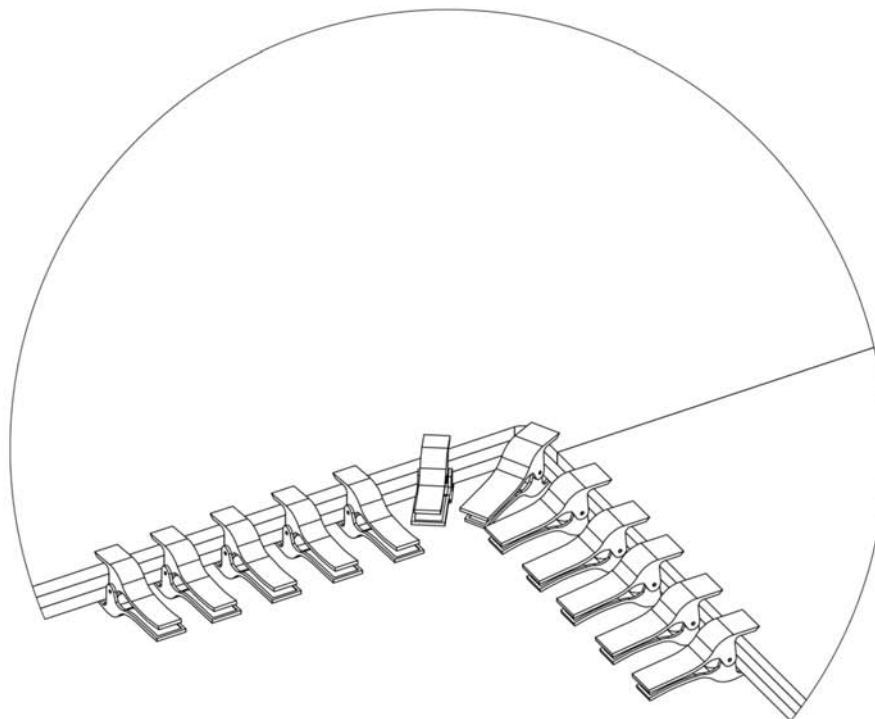
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3.10 Edge Treatment



Inside Corner Build-up, Showing Material Overlap



3.10

Edge Clamping, Inside Corner



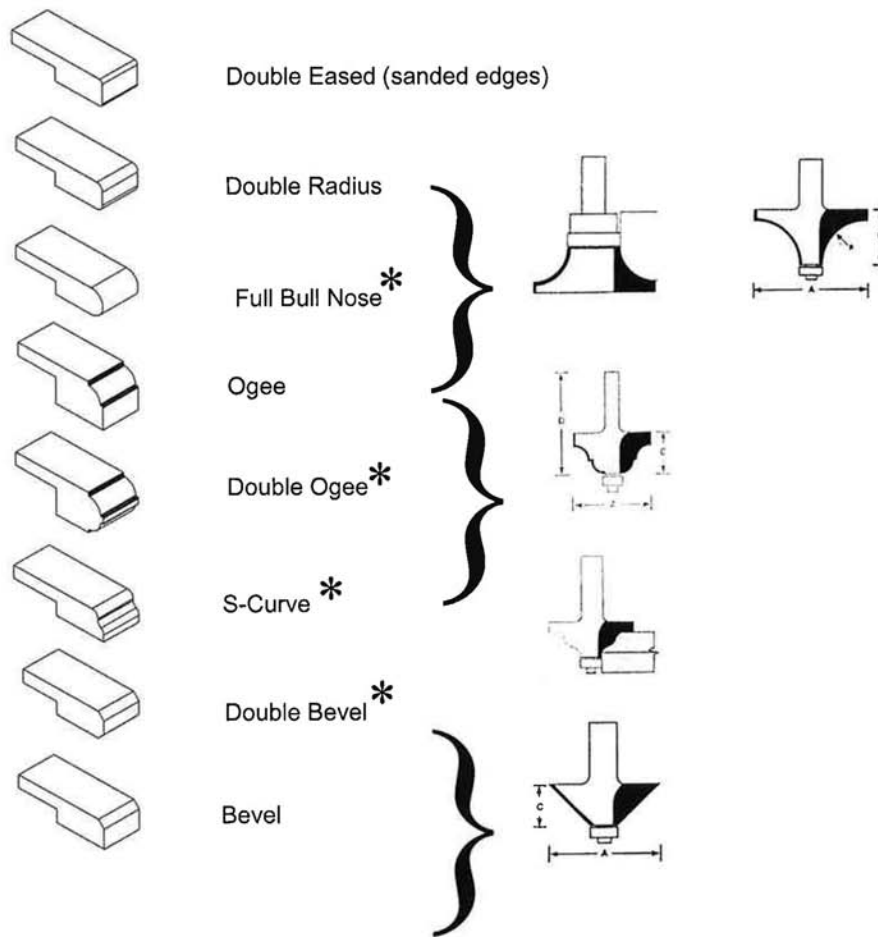
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3.11 Edge Treatment

1. Cut strips of solid surface material as needed to build up the edge for various types of edge treatment.
2. Adhere and clamp solid surface pieces to countertop edge. Remove clamps after the adhesive cures.
3. Finish edge with the appropriate router bit.
4. Do not use a chisel to remove excess adhesive; only use a router or sander.



3.11

Questions?

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3.12 Backsplash

Backsplash (Coved Splash)

1. Adhere a ½" x 7/8" x "length of counter top" piece of prism material to the bottom of the backsplash piece. Allow this to cure.
2. Machine an 1/8" x 7/8" wide groove into the backside of the countertop. Adhere the back splash and ½" x 7/8" assembly to the counter top by gluing it into the groove.
3. Clamp the backsplash square to the top.
4. After curing, remove clamps and route in the cove using a coving router.
5. Sand the cove smooth with the surface.



Coving Router



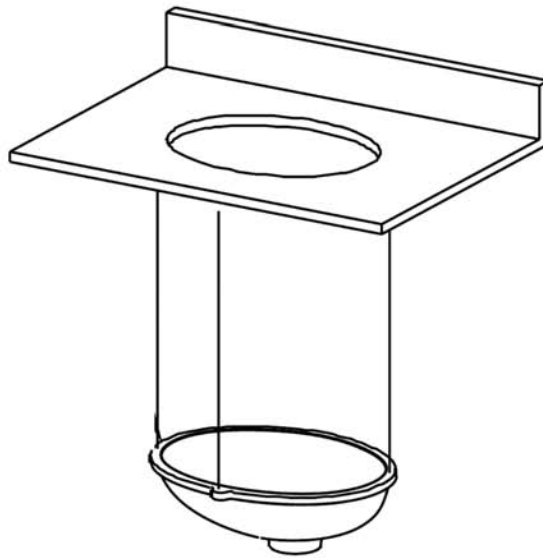
Questions?

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3.13 Kitchen Sink and Lavatory Bowl

Kitchen sink and Lavatory Bowls (under mount)

1. Mark the centerlines for the sink or lavatory bowl position on the back of the countertop with an awl.
2. Position the bowl using the centerlines. Scratch the outside perimeter of the bowl into the backside of the counter with the awl.
3. Sand the area where the bowl will be attached with 60 micron (P-grade, P220 grit) sandpaper.
4. Plunge route a 2" hole in the center of the marked area to clamp hole to countertop.
5. Attach glue blocks just outside the marked area to hold the sink in place during gluing.
6. Flat sand the mating flange of the bowl; with 60 micron (P-grade, P220 grit) sandpaper. Clean the flange and the back of the countertop with de-natured alcohol.
7. Apply adhesive to the flange of the bowl.
8. Position the bowl in place on the back of the counter top. Secure the bowl in place with clamps.
9. Remove glue blocks and clamps after the adhesive has cured.
10. Finish edge with the bit required for the edge treatment needed. Over-sized bowls may require brackets.
11. Use a plunge router or hole saw to drill faucet holes. Install the faucet.
12. Install the finished top on cabinet.



3.13



Questions?

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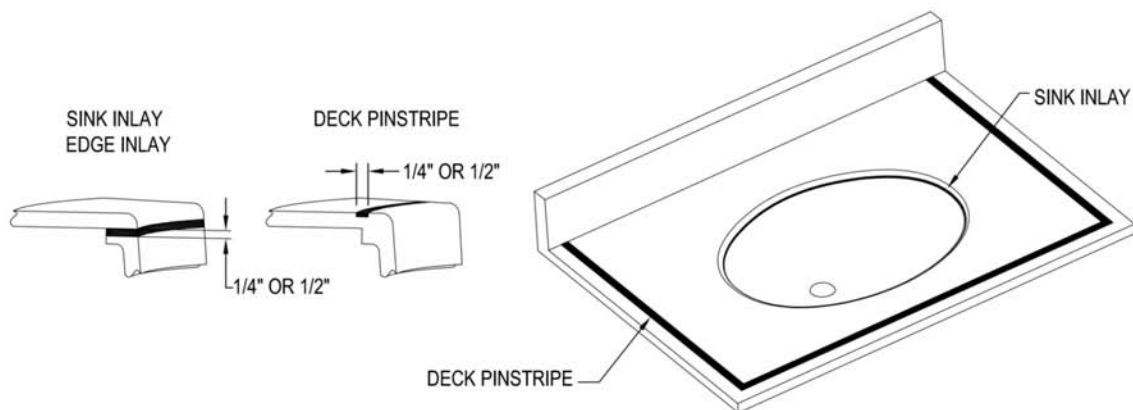
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3.14 Color Inlay

Color Inlay

Prism and Illusion Solid Surface Inlays—

Route a minimum of an 1/8" deep inlay shape or groove into the surface. Cut 1/4" solid surface material to the shape of the inlay. Glue the solid surface inlay to the bottom and sides of the routed area with solid surface adhesive. After curing, sand area with 150 grit sandpaper using a circular motion. Wet sand with 240 grit sandpaper to remove scratches. Use the proper Scotch-Brite pad to even out the finish.



3.14



Questions?

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3.15 Patching

Patching

Prism Repair Kit
Contents: Resin
Filler
Catalyst

Calibrated paper cups for measuring and mixing
Wooden mixing sticks
Sandpaper

NOTE: It is not feasible to patch Illusion Solid Surface Material.

1. When repairing a crack, drill a hole through the countertop at the end of the crack. This will stop the crack from spreading. Ream out the crack.
2. Clean damage surface and surrounding area with de-natured alcohol.
3. Create a dam around damaged area to over-fill the area with material. Do this with silicone adhesive.
4. After prepping the damaged area, mix the repair components. From the start of step 5, you will have 20 minutes until the repair material is unworkable.
5. Add $\frac{3}{4}$ ounce of resin to one of the cups.
6. Dispense 6 drops of catalyst into the resin with an eyedropper.
7. Stir steadily with a mixing stick, avoiding the creation of air bubbles.
8. After thoroughly mixing add 1 -1/4 ounce of filler. Measure the filler into a separate cup and slowly add it to the resin mixture. Stir continually.
9. After stirring and blending the components completely, overfill the damaged area with the mixture and allow it to harden completely. 24 hours is recommended; cooler temperatures require longer set-up times
10. After curing, sand area with 150 grit sandpaper using a circular motion.
11. Wet sand with 240 grit sandpaper to remove scratches.
12. Use proper Scotch-Brite® pad to even out the finish.

The above formula produces 2 ounces of material, which is enough to patch 2 cubic inches. Due to lot variations, some color difference may occur.



Patching Kit: (left to right), resin, filler, catalyst, measuring cups, stirring rods, sandpaper (150 grit and 240 grit).

3.15



Questions?

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3.16 Repairs

Seam Repairs

Common reasons for seam problems stem from failure to follow recommendations discussed throughout this guide and include heat from belt sanding, excessive clamping pressure, bad mixing of catalyst, not using a seam blocks, seams near heat source such as dishwasher or cook top, and seams placed at points of stress such as inside corners.

1. Glue the area where the seam failure is located.
2. After the glue has dried, rout a ¼" deep groove over the failure.
3. Cut a matching piece of solid surface from the original installation to the size of the groove making sure that it is taller than the surface countertop surface.
4. Rout and sand this material level and finish to match the rest of the countertop.

Other repairs including corners using a pie-shaped template.

1. Make a pie-shaped template large enough to cover the damaged area.
2. Clamp the template to the countertop and rout out the damaged area.
3. Cut a matching piece of solid surface from the original installation to the size of the pie-shaped area making sure that it is taller than the surface countertop surface. Also make sure the replacement piece extends past the edge of the countertop.
4. Dry fit the replacement piece until all gaps are tight.
5. Glue the replacement piece in place and add a support block from underneath if possible.
6. Rout and sand surface until it matches the original countertop.

Repairing Illusion Solid Surface Material.

When repairing Illusion Solid Surface Material use the Andreas Repair System.

Contact information:
Andreas Custom Design
80 Black Meadow Rd.
Chester, NY 10918
(800) 774-6744
andreascustomdesign.com



Questions?

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3.17 Sanding and Polishing

Sanding and Polishing Prism Solid Surface

Start the sanding process with 60 micron. Use a 6" (152mm) or 8" (203mm) random orbital sander to improve sanding efficiency and uniformity. The factory finish on Prism solid colors is matte, while the finish on all pattern colors is semi-gloss.

Sanding Steps

1. Move the sander in a back and forth direction.
2. Overlap each pass by 50%.
3. Sand slowly and evenly.
4. Keep micron paper clean from sanding dust. (Check paper frequently).

Matte Finish

Remove linear lines with 60 micron paper. Use a Scotch-Brite® pad, (#7447 Maroon, Very Fine) under the sanding pad to even out the finish. The easily maintained matte finish is suitable for high use areas. Inform the customer of the required maintenance for a matte finish. Homeowners can maintain the matte finish with non abrasive household cleaners.

Semi-gloss Finish

Remove linear lines with 60 micron paper and repeat the sanding process with a Scotch-Brite® pad, (#7448 Gray, Ultra Fine) under the sanding pad to even out the finish. Homeowners may maintain this finish using a white Scotch-Brite® and solid surface counter-top polish.

High Gloss Finish

After sanding with 60 micron paper, repeat the sanding process with 30 micron paper then 15 micron sandpaper. The polisher used should have 8-10 AMP and the capacity to maintain 2500 R.P.M. A high gloss finish on a dark color is not recommended for heavy use areas. Dark colors may require polishing for full impact. A high gloss finish is the most difficult finish to maintain, since the glossy finish scratches easily.

Standard Prism Finishing Steps

Matte

1. 60 micron
2. Scotch-Brite® #7447 Maroon, Very Fine

Semi-Gloss

1. 60 micron
2. Scotch-Brite® #7448 Gray, Ultra Fine

High Gloss

- | | |
|--------------|---|
| 1. 60 micron | 4. Marine paste compound with white pad |
| 2. 30 micron | 5. Gloss polish with yellow pad. |
| 3. 15 micron | |

3.17



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3.18 Sanding and Polishing

Sanding and Polishing Illusion Solid Surface

Start the sanding process with 60 micron. Use a 6" (152mm) or 8" (203mm) random orbital sander to improve sanding efficiency and uniformity.

Sanding Steps

1. Move the sander in a back and forth direction.
2. Overlap each pass by 50%.
3. Sand slowly and evenly.
4. Keep micron paper clean from sanding dust. (Check paper frequently).

Matte Finish

Remove linear lines with 60 micron paper. Follow this with 40 micron paper. Use a Scotch-Brite® pad, (#7447 Maroon, Very Fine) with water to even out the finish. The easily maintained matte finish is suitable for high use areas. Inform the customer of the required maintenance for a matte finish. Homeowners can maintain the matte finish with non abrasive household cleaners.

Semi-gloss Finish

Remove linear lines with 60 micron paper. Next sand with 40 micron paper followed by 30 micron paper. Finish the sanding process with a Scotch-Brite® pad, (#7448 Gray, Ultra Fine) with water to even out the finish. Homeowners may maintain this finish using a white Scotch-Brite® and solid surface counter-top polish.

High Gloss Finish

After sanding with 60 micron paper, repeat the sanding process with 40 micron, 30 micron, 15 micron, and then 9 micron sandpaper. The final two steps polishing steps use cerium oxide and polish. A high gloss finish on a dark color is not recommended for heavy use areas. Dark colors may require polishing for full impact. A high gloss finish is the most difficult finish to maintain, since the glossy finish scratches easily.

Standard Illusion Finishing Steps

Matte

- | | |
|--------------|-------------------------------------|
| 1. 60 micron | 3. Scotch-Brite® #7447 Maroon, Very |
| 2. 40 micron | Fine, Wet |

Semi-Gloss

- | | |
|--------------|------------------------------------|
| 1. 60 micron | 3. 30 micron |
| 2. 40 micron | 4. Scotch-Brite® #7448 Gray, Ultra |
| | Fine, Wet |

High Gloss

- | | |
|--------------|-----------------|
| 1. 60 micron | 4. 9 micron |
| 2. 30 micron | 5. Cerium Oxide |
| 3. 15 micron | 6. Polish |

3.18



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3.19 Thermoforming

Thermoforming

NOTE: Thermoforming Illusion Solid Surface Material is not recommended
Prism Solid Surface Material is a thermo-set resin that may be formed using the following guidelines. Follow safe work habits when working with hot materials, including the use of heat resistant gloves and goggles. To avoid tearing during bending, remove chips and scratches before heating Prism Solid Surface. Machine tight radii instead of thermoforming.

Molds

When forming Prism sheet, create molds that can clamp tightly together to hold the shape until the material cools. Male and female molds work most effectively. Clamp material for at least two hours to prevent recoil.

Recommended Temperature 275° F.

NOTE: Ovens and conditions vary. Times and temperatures are guidelines and may need to be modified.

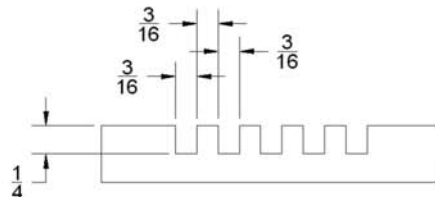
Sheet Thickness	Color	(90° or 180° bend) Min. Radius	Heat Time
1/4"	Light Colors Solid and Small Particulate	7.5"	10 min.
1/4"	Dark Colors: Solid, Small and Medium Particulate All Large Particulate Colors	10"	10 min.
1/2"	Light Colors: Solid and Small Particulate	12" *7.5"	18 min.
1/2"	Dark Colors: Solid, Small and Medium Particulate All Large Particulate Colors	16" *10"	18 min.

*Kerfing 1/2" thick Prism:

Kerfing - Machine using a 3/16" bit spaced every 3/16". Cut 1/4" deep. Use same heat temperature and times. It may be necessary to fill in the kerfing areas using soft or hard seaming techniques for added product strength.



Forming Mold



Kerfing

3.19



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4.1 Wall Cladding

Installation Instructions

Prism® and Illusion Solid Surface Wall Cladding

Prism Solid Surface Tools and Materials Required

Belt sander with #24 or 36 grit sandpaper, saber saw, router (1 3/4 HP, 22,000 rpm), random orbit sander with #100, 60, and 30 micron sandpaper, electric drill with carbide or high speed steel bits, circular/trim saw with carborundum or carbide tipped blade, tape measure, grease pencil, buffer with polishing compounds and scotchbrite pads, flat file, clamps, denatured alcohol, safety goggles, paper towels, caulking gun, dust masks, masking tape, level/straight edge, solid surface adhesive, clear silicone sealant, hot melt, epoxy and color matched silicone sealant.

1. In advance determine where hard seams, soft seams, batten strips, corner moldings and perimeter trim will occur. Soft seams must occur at inside and outside corners. Cut 1/4" solid surface material to the required size.
2. Hard seaming: Hard seaming is the joining of two or more panels with two-part adhesives to form inconspicuous seams. Make hard seams on a flat work surface. Cut edges straight and square. See figure 1. When seaming Illusion Solid Surface Panels, use a "wigggle" template to make the seam. Apply clamping blocks made from solid surface material to the surface of the wall panel with clear hot melt glue. Blocks should be 3" from each edge and every 6" over the length of the seam. Tighten clamps so the gap at the seam is 1/8". See figure 2. Apply two-part adhesive to the seam and tighten the clamps until the adhesive squeezes out. Allow adhesive to cure. Remove clamps and clamping blocks. See figure 3. Sand off excess adhesive, starting with 100 micron grit sandpaper, 60 micron grit sandpaper and followed by a Scotch-Brite® pad, (#7447 Maroon, Very Fine) for matte/solid colors or a Scotch-Brite® pad, (#7448 Gray, Ultra Fine) for semi-gloss/granite colors. Start sanding 6" on either side of the seam and conclude the sanding by going as wide as 12" on either side of the seam.

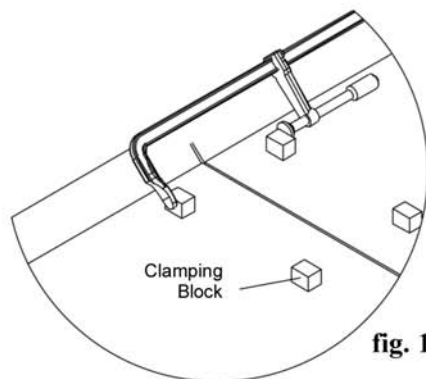


fig. 1

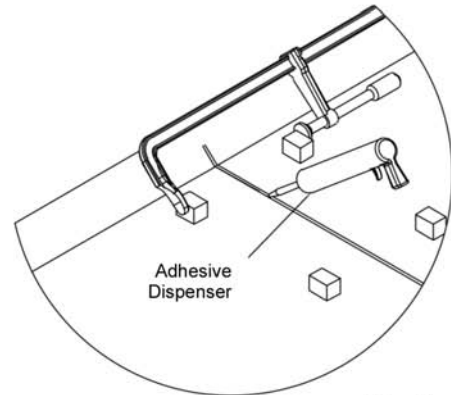


fig. 2

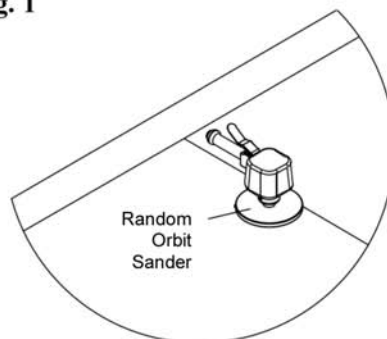


fig. 3

4.1

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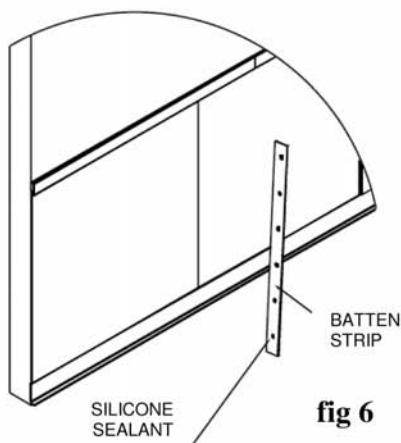
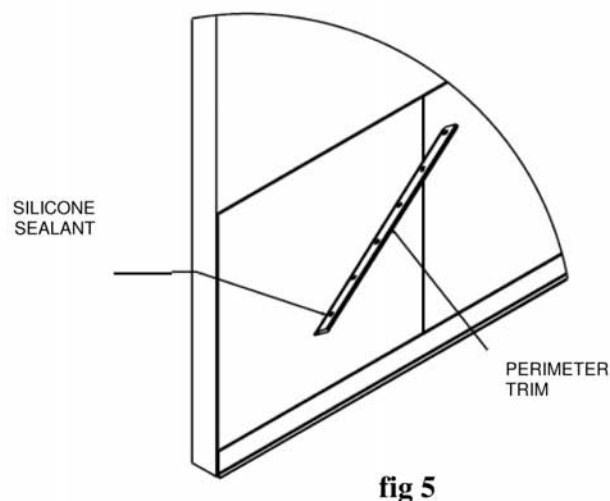
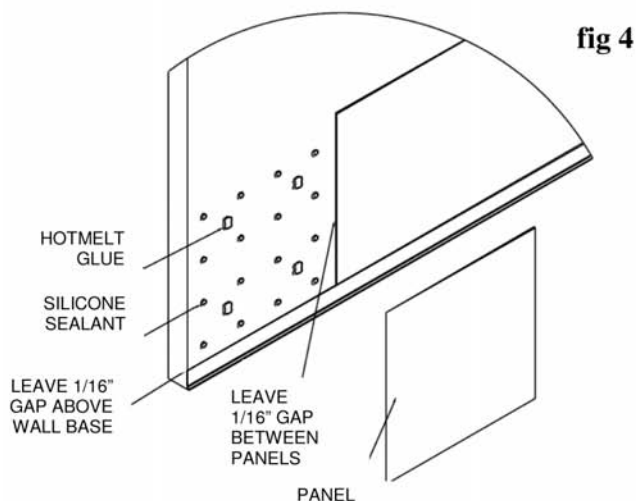
4.2 Wall Cladding

3. Apply 1"-1 1/2" diameter portions of silicone sealant on the wall spaced 4" from the edges and 8" to 10" over the rest of the field. Before applying the panel to the wall, apply hot melt adhesive on the wall every 16". This is to hold the panel in place until the silicone sealant cures. Right after applying the hot melt, position the panel on the wall and press it into place. If installing above wall base allow 1/8" gap. If you are using batten strips and corner molding leave 1/8" gaps between panels where these trim items will be used. See figure 4.

4. After all panels are adhered to the wall, fill all gaps between panels, wall base and corner conditions with clear silicone sealant. Mask off either side of the seam. Fill in the gap with clear silicone sealant, smooth it out and remove the masking tape. Clean-up any excess sealant with denatured alcohol. See figure 5.

5. Perimeter trim - Cut perimeter trim to the desired length allowing 1/8" gaps at corners and between pieces.

Adhere it to the wall with dabs of clear silicone sealant 2" from the ends and spaced every 8" over the length of the trim. Apply clear silicone on the back part of the trim that mates with the wall. Clean-up any excess sealant with denatured alcohol. See figure 6.



4.2

Questions?

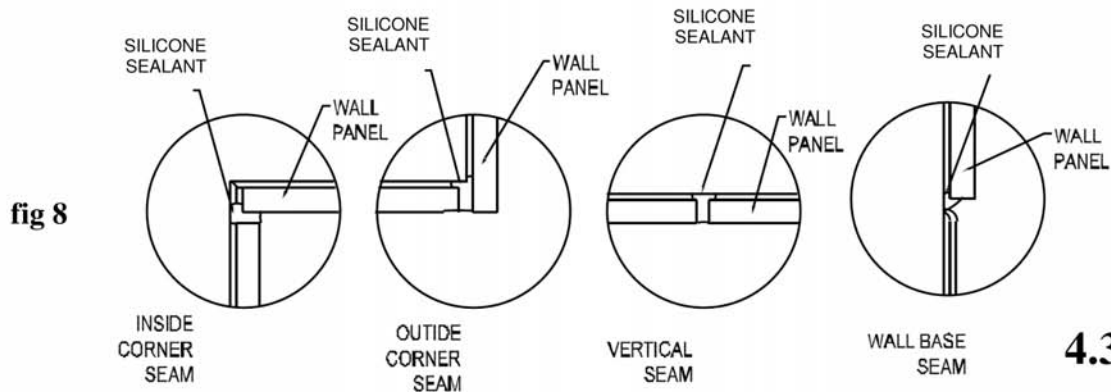
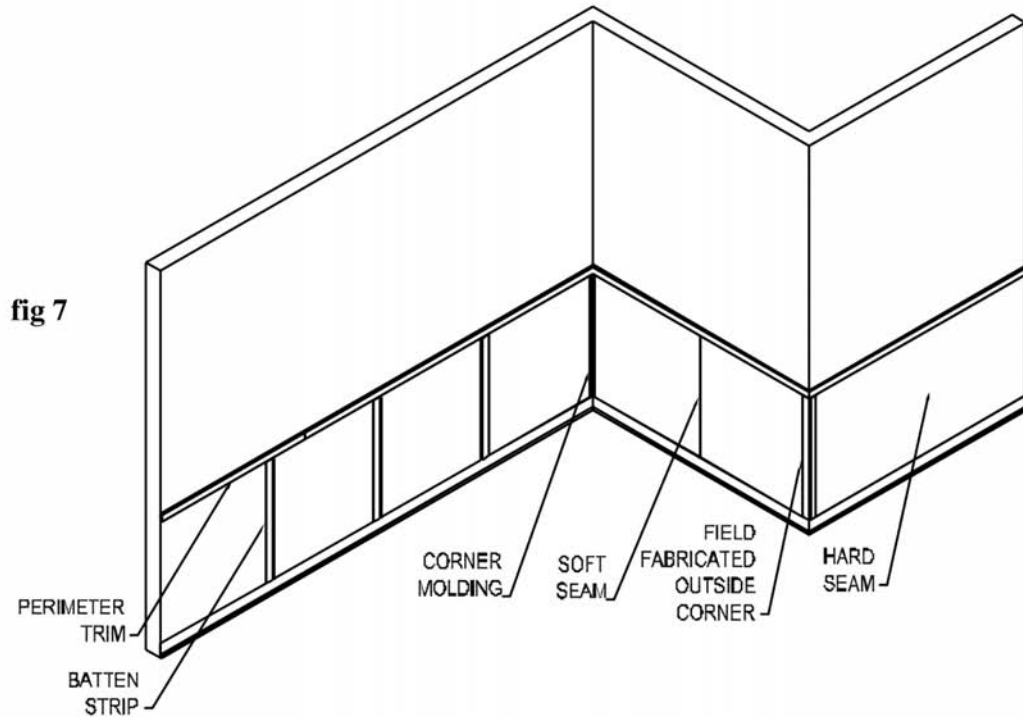
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4.3 Wall Cladding

6. Corner Moldings and Batten Strips - Cut Corner Molding and Batten Strips to the required length. Apply small dabs of clear silicone sealant on the back of the trim. Position and press trim pieces into place. Tape if needed until sealant cures. Clean-up any excess sealant with denatured alcohol.

7. Outside corner pieces - Produce field fabricated outside corner by gluing and clamping solid surface material together with two-part adhesive. Sand and finish corner to match panels.



4.3

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4.4 Vanity Tops

Installation Instructions

Prism® and Illusion Vanity Tops

NOTE: Before installation, check material completely to ensure that it was not damaged in transit. Check size, color and style/model to confirm the product matches the order. Verify that the vanity top is the correct size for the cabinet.

1. Verify that the cabinet or wood frame is level and flat. See figure 1.
2. Wall to wall installation - Measure and check the dimension with the top. Cut or sand edges to fit. Sanding may be needed to fit to uneven walls.
3. Two section tops that are ordered with "Jobsite Butt Fit" - Each section is up to 1" longer to allow for a perfect field fit. Trim extra material with a belt sander and #24 or #36 sandpaper or a saber saw.
4. Saw counter top on backside or use wide masking tape to protect finished surface from scratches or chipping.
5. Only sand or saw edges that will be concealed after installation. DO NOT cut or sand exposed (finished) edges. Always support and protect the material when sanding or cutting
6. Space lateral (front to back) supports 24" or less. See figure 2.
7. Apply a small bead of clear silicone sealant to the top edge of the cabinet or frame. See Figure 3.
8. Carefully lower the vanity top into position and press firmly into place. See Figure 4.
9. Bond side splashes to the vanity top and tool the seams with silicone sealant. See Figure 5.
10. Seal and carefully tool all joints with silicone sealant to provide a smooth contoured joint.

fig. 1

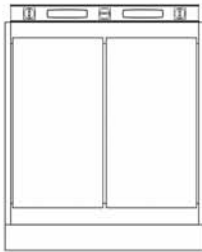


fig. 2

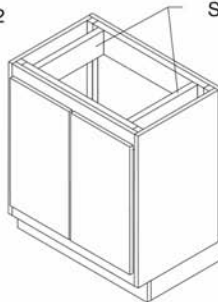


fig. 3

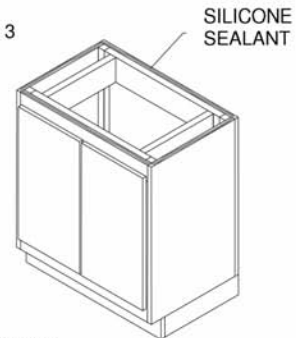


fig. 4

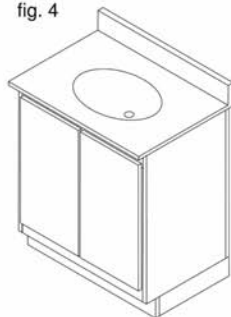
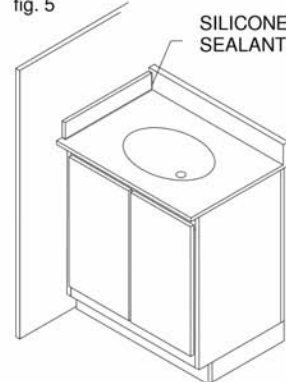


fig. 5



4.4



Questions?

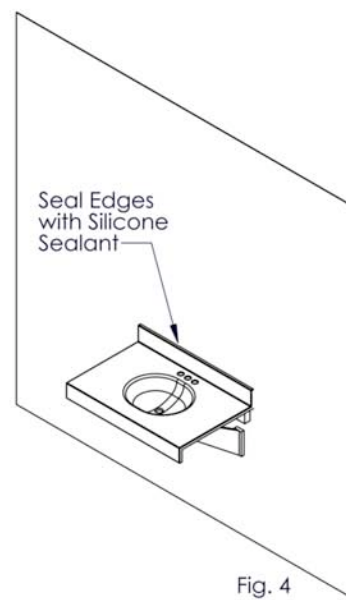
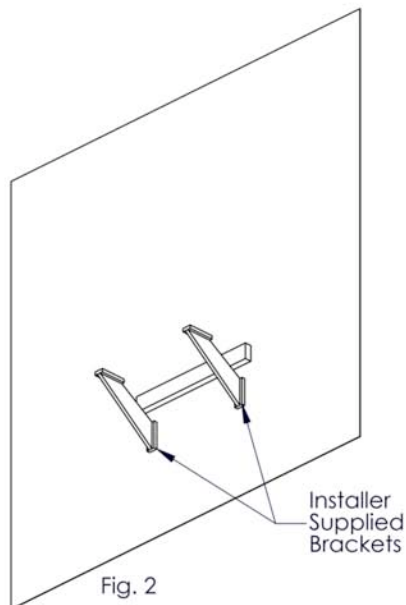
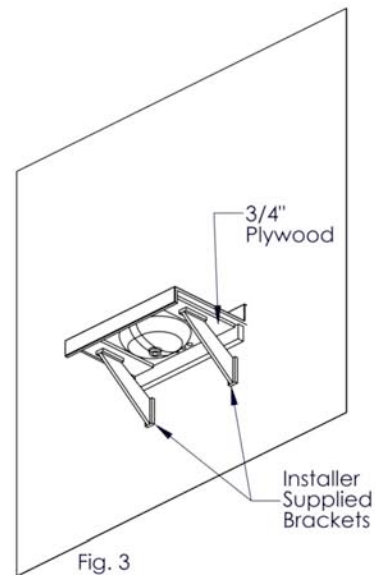
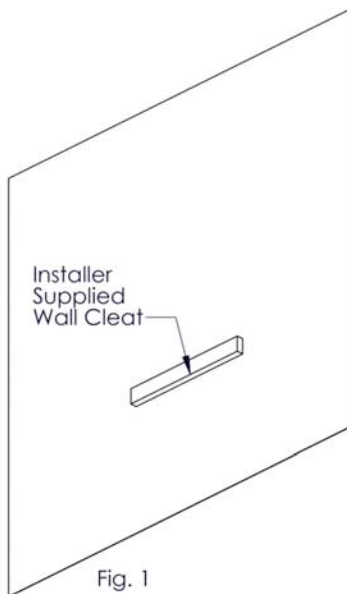
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4.5 Vanity Top without Base Cabinet

Installation of Vanity Top without Base Cabinet

1. Attach a wall cleat to the wall using appropriate fasteners for the substrate. (fig. 1) Allow for the thickness of the vanity top when determining the height of the cleat.
2. Mount wall brackets to the wall so the support surface is the same height as the wall cleat. (fig. 2)
3. Set the vanity top on the wall cleat and the brackets and attach the top using appropriate fasteners. (fig. 3)
4. Make all plumbing connections.
5. Seal all edges with silicone sealant. (fig. 4)



4.5

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4.6 Detached Apron

Installation Instructions

Prism® and Illusion Detached Apron

1. Cut apron to the required length if needed. Determine the position on the bottom of the vanity top. See figure 1.
2. Apply a small bead of clear adhesive to the edge that will mate with the bottom of the vanity top. See figure 2.
3. Position the apron in place and clamp it to blocking that will hold the apron perpendicular for 24 hours. See figure 3.
4. Apply a 1/2" bead of clear adhesive to the seam at the back of the apron. See figure 4.

fig 1

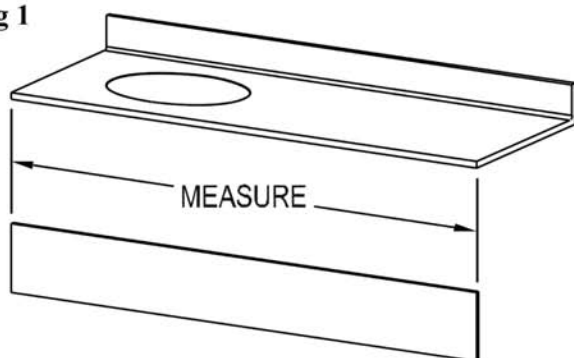


fig.4

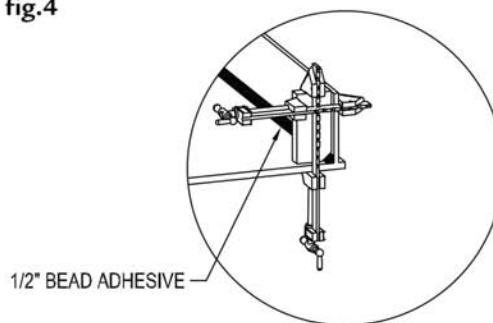


fig.2

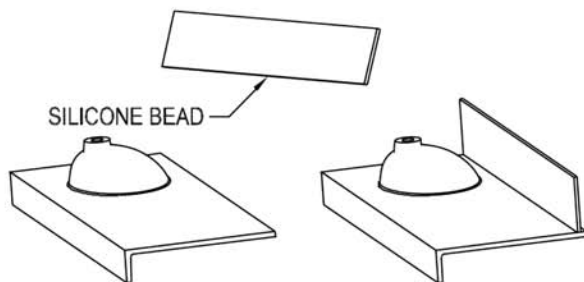


fig.5 - Completed Installation

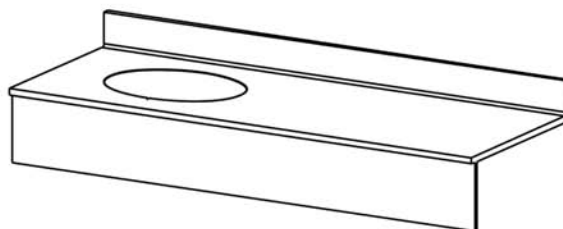
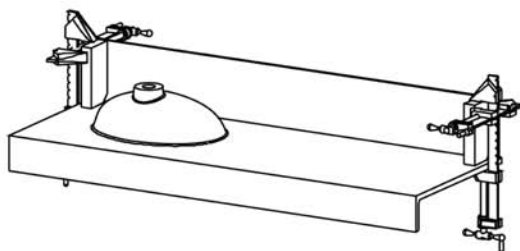


fig.3



4.6

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4.7 Under Mount Sink

fig.1

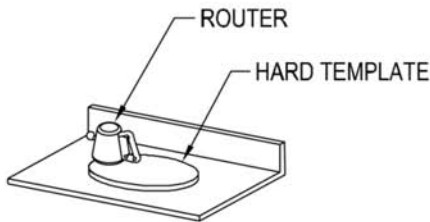


fig.2



fig.3

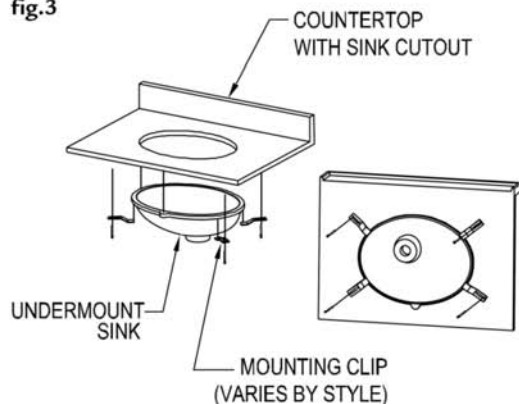
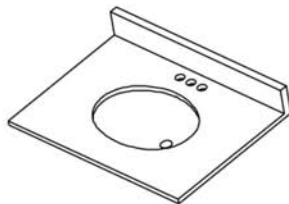


fig.4



Installation Instructions

Prism® and Illusion Under Mount Sink

1. Choose the correct template for your sink. Transfer the template to plywood or masonite to create a hard template. Cut out the plywood or masonite allowing for your saw blade or router bit width. A smooth accurate template is required for a proper fit.
2. Cutout Position - A suggested location for the cutout is centered front to back allowing for faucets. Customer preference may change location.
3. Cut opening with a router bit using the template as a guide. See Figure 1.
4. Basin Installation - Clean flange with denatured alcohol. Apply a bead of silicone around the flange. See Figure 2.
5. Position basin under the countertop, centering it under the cutout. See Figure 2.
6. Attach the basin with screws and clips, tightening them securely but not too tight. Remove excess sealant with denatured alcohol. See Figure 3.
7. Cut holes in the vanity top for faucet. See Figure 4.
8. Attach drain assembly to basin. Attach faucet to vanity top.
9. Follow installation instructions for vanity tops to complete installation.

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4.8 Vessel Sinks

Installation Instructions Prism Vessel Sinks

fig.1

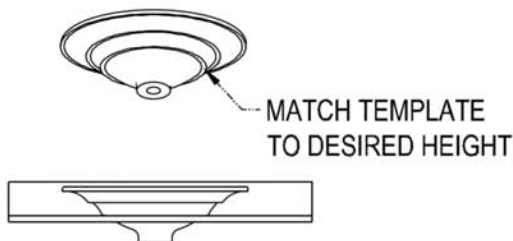


fig.2

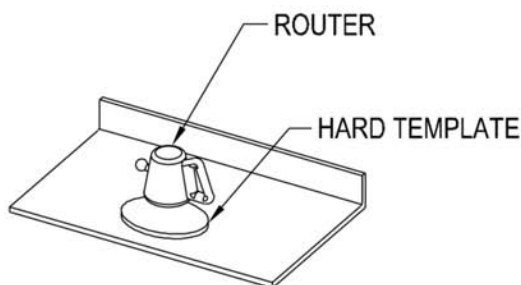


fig.3

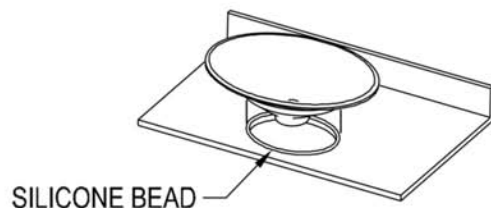


fig.4



1. Choose the correct template for your sink. The Lotus Lav allows for the customer to select the height at which the sink will be mounted. Choose the correct template for that height. See Figure 1.

Transfer the template to plywood or masonite to create a hard template. Cut out the plywood or masonite allowing for your saw blade or router bit width. A smooth accurate template is required for a proper fit.

2. Cutout Position - A suggested location for the cutout is centered front to back allowing for faucets. Customer preference may change location.

3. Cut opening with a router bit using the template as a guide. See Figure 2.

4. Basin Installation - Clean the outside of the sink with denatured alcohol. Apply a bead of silicone around the edge of the cutout. See Figure 3.

5. Position the sink in the vanity top, centering it in the cutout. Remove excess sealant with denatured alcohol. Allow Sealant to cure for 24 hours.

6. Cut holes in the vanity top for faucet. See Figure 4.

7. Attach drain assembly to sink and faucet to vanity top following the plumbing fixture installation instructions.

4.9 Shower Package

Installation Instructions

Prism® and Illusion Shower Packages

STORAGE:

Keep crates in upright positions. When unpacking store panels flat in a clean dry place.

BEFORE INSTALLATION:

Check for damage in that may have occurred in transit. Store materials in an environmentally controlled area, 24 hours before installation. Confirm that the sizes, styles/models and colors are the same as your order. Check all specifications to ensure that you have the right material for the job. Shower packages are not intended to be used as steam units.

RECOMMENDED TOOLS

Tape Measure, belt sander with #24 or #36 grit sand paper, Heavy duty electric drill with carbide or high speed steel bits, denatured alcohol, circular saw with carborundum blade, safety glasses, dust masks, caulking gun, level, flat file, buffer, paper towels, masking tape and grease pencil.

USING TOOLS

Sawing: Cut only on unfinished side (back) or use wide masking tape to protect finished surfaces from scratching or chipping.

Drilling: Drill from finished side (front) of material.

Sanding: Only sand edges that will be concealed when installed. DO NOT cut or sand exposed (finished) edges.

Always saw, drill or sand with the material properly supported.

ADHESIVES AND SEALANTS

Bonding: Clear adhesive

Sealants: GE Silicone Dow Tub and Tile Caulk and translucent silicone are recommended.

Use denatured alcohol for cleanup.

PRIMING

Translucent materials require the substrate to be primed with white oil based primer before installation since the materials are translucent.

ROUGH-IN SPECIFICATIONS

Refer to shower receptor detail drawings for drain location of each model.

fig.1

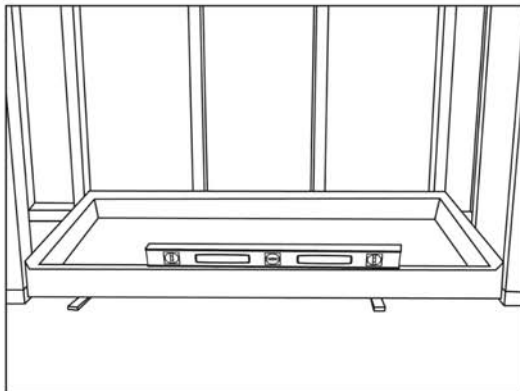
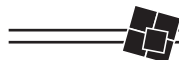
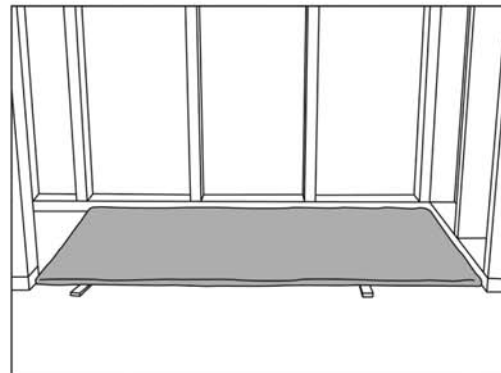


fig.2



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4.10 Shower Package

STANDARD SHOWER PACKAGE ROUGH-IN DIMENSIONS:

Rough-in dimensions Drain Location

32 1/4" w x 32" d Centered and 16" from rear stud wall

36 1/4" w x 36" d Centered and 17" from rear stud wall

48 1/4" w x 32" d Centered and 16" from rear stud wall

38 1/4" w x 36" d Centered and 17" from rear stud wall

48 1/4" w x 42" d Centered and 21" from rear stud wall

60 1/4" w x 32" d Centered and 16" from rear stud wall

60 1/4" w x 36" d Centered and 17" from rear stud wall

36" x 36" from corner 16 3/4" from side and 16 3/4" from rear stud wall

36" x 36" from corner 12" from side and 12" from rear stud wall

42" x 42" from corner 12" from side and 12" from rear stud wall

INSTALLATION OF THE SHOWER RECEPTOR

Note: Before installation make sure floor is level and uniform. Shower receptor is installed before green board is applied.

1. Center the shower receptor in the rough opening and tight against the rear stud wall for standard and custom shower receptors. Shower packages with seat: install receptor in rough opening leaving room for the seat framework and tight to the rear stud wall.
 2. Check the level at the top of the receptor. Shim until level and nail the shims to the floor. See figure 1.
 3. Remove receptor from opening. Mix mortar and sand and apply enough mortar to the floor to level receptor. See figure 2.
 4. Return the receptor to the opening and wiggle the receptor around until it is resting on the shims. See figure 3.
- Support the receptor evenly so it will not wiggle when you step in it. Remove the shims when the mortar is set.
5. Install green board stopping it 1" above the water barrier of the receptor. See figure 4.

fig.3

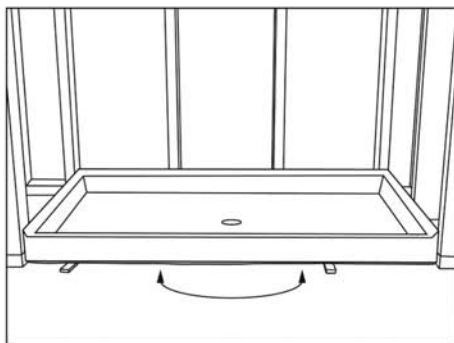
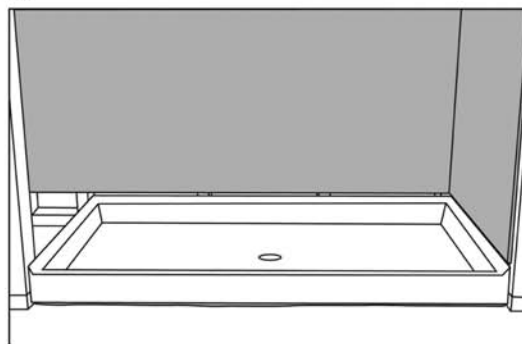


fig.4



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4.11 Shower Package

INSTALLATION OF BACK WALL PANEL AND SEAT (if applicable)

1. Measure the back wall to determine if the back panel requires trimming. Allow 1/8" for expansion in wall to wall installations. See Figure 5. Use a belt sander with #24 or #36 sandpaper or a saber saw to trim panels. DO NOT trim the finished edges of panels. Note: when sanding or cutting panels, always support panels properly. Note: Showers with seats - Notch the rear wall panel to ride over the integral water guard barrier.
2. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a bead of adhesive, on the wall, within 3" of the perimeter of the panel and 1 1/2" diameter portions of adhesive spaced 12" apart over the remaining field. See figure 6.
3. Position the panel on the wall and press into place.
4. Build a seat support from 2"x 4"s, that is 19 1/2"h x 12"d. Attach 1/2" plywood to the front of the seat structure, stopping it 1" above the waterguard barrier on the receptor. See figure 7.
5. Adhere the 3/8" seat riser to the plywood, allowing the bottom edge of the riser to sit on the receptor. See figure 8.
6. Install the 3/4" shower seat to the top of the seat structure with adhesive.

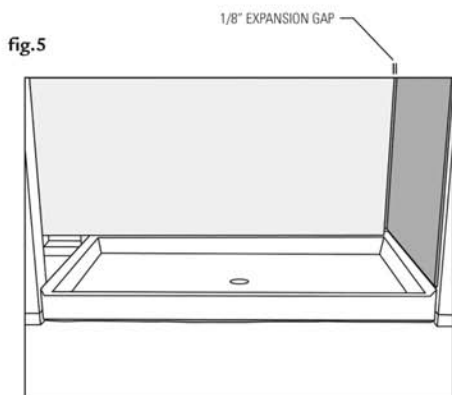


fig. 6

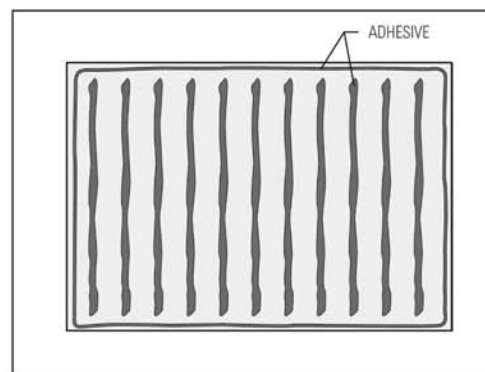


fig.7

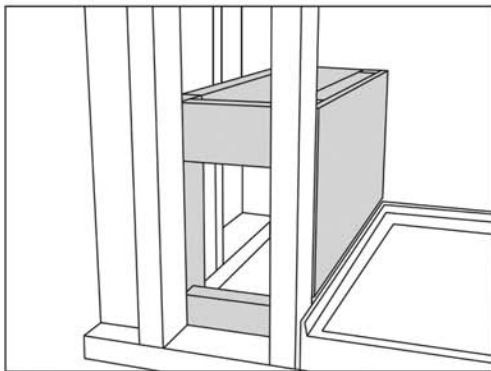
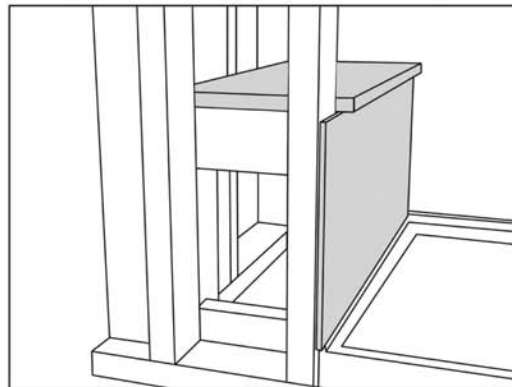


fig.8



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4.12 Shower Package

INSTALLATION OF SIDE PANELS

1. Mark the side panels for the location of any plumbing fixtures.
2. Drill or cut holes of an appropriate size in the marked locations using carbide tipped drill bits or saws. See figure 9.
Drill from the face side and cut from the back side. Cutting can be done on the front side if the surface is protected with masking tape. Allow 1/8" for expansion in wall to wall installations. Always support the panels properly when drilling sanding or cutting.
3. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a bead of adhesive, on the wall, within 3" of the perimeter of the panel and 1 1/2" diameter portions of adhesive spaced 12" apart over the remaining field. Apply a solid band of adhesive 3" x 72" on the outer edge of each side panel to provide added support for shower door installation. See figure 10.
4. Position the panel and press into place. Brace panels for 24 hours after installation.
5. Caulk perimeter joints and all seams using silicone sealant. Clean up excess caulk with denatured alcohol. See figure 11.

fig.9

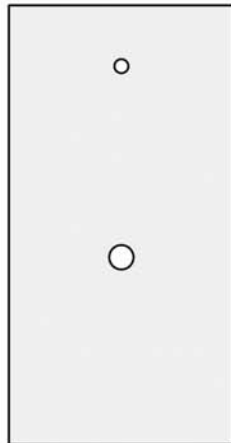


fig.10

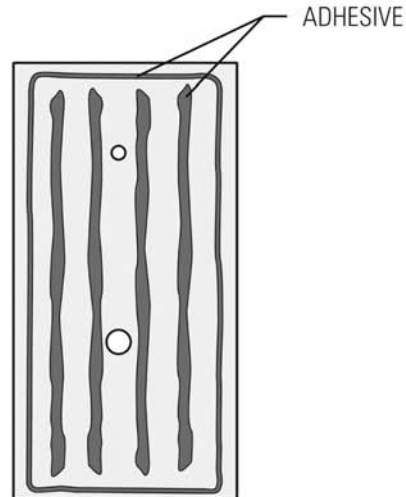
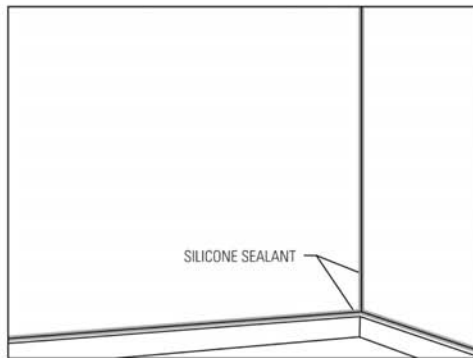


fig.11



4.12



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4.13 Shower Package

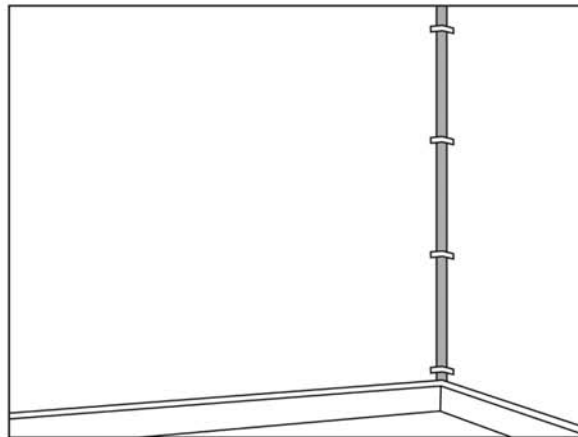
INSTALLATION OF BATTEN STRIPS AND CORNER MOLDINGS

1. Check the height of the product and belt sand if needed.
2. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a thin bead of silicone/adhesive caulk to the outer edge of the corner molding and the back of the batten strip.
3. Position the components and temporarily tape them in place. Clean up excess caulk with denatured alcohol. See figure 12.

INSTALLATION OF CEILING PANEL (if used)

1. Check the dimensions of the ceiling panels. Use a belt sander with #24 or #36 sandpaper or a saber saw to trim panels. DO NOT trim the finished edges of panels.
Note: when sanding or cutting panels, always support panels properly.
2. Drill holes in the ceiling panels at proper locations.
3. Attach panel to the ceiling with mechanical fasteners.
4. Note: DO NOT install ceiling panels where there will be excessive moisture or heat.

fig.12



4.13



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4.14 Tub Surrounds

Installation Instructions

Prism® and Illusion Tub Surround

1. Tub should be in position and secured to the stud walls in accordance with the manufacturer's installation instructions. See figure 1.
2. Install green board 1" above the tube flange. See figure 2.
3. Measure the back wall to determine if the back panel requires trimming. Allow 1/8" for expansion in wall to wall installations. Use a belt sander with #24 or #36 sandpaper or a saber saw to trim panels. DO NOT trim the finished edges of panels. Note: when sanding or cutting panels, always support panels properly. Note: Showers with seats - Notch the rear wall panel to ride over the integral water guard barrier.
4. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a bead of clear adhesive, on the wall, within 3" of the perimeter of the panel and 1 1/2" diameter portions of clear adhesive spaced 12" apart over the remaining field. Position the panel on the wall and press into place. See figure 3.
5. Mark the side panels for the location of any plumbing fixtures. Drill or cut holes of an appropriate size in the marked locations using carbide tipped drill bits or saws. Drill from the face side and cut from the back side. Cutting can be done on the front side if the surface is protected with masking tape. Allow 1/8" for expansion in wall to wall installations. Always support the panels properly when drilling sanding or cutting. See figure 4.
6. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a bead of adhesive, on the wall, within 3" of the perimeter of the panel and 1 1/2" diameter portions of adhesive spaced 12" apart over the remaining field. Apply a solid band of adhesive 3" x 72" on the outer edge of each side panel to provide added support for shower door installation.
7. Position the panel and press into place. Brace panels for 24 hours after installation.
8. Caulk perimeter joints and all seams using silicone sealant. Clean up excess caulk with denatured alcohol. See figure 5.
9. Installation of Batten Strips and Corner Moldings
10. Check the height of the product and belt sand if needed.
11. Wipe the back of the panels making sure they are clean dry and free of dirt and grease. Apply a thin bead of silicone/adhesive caulk to the outer edge of the corner molding and the back of the batten strip.
12. Position the components and temporarily tape them in place. Clean up excess caulk with denatured alcohol.

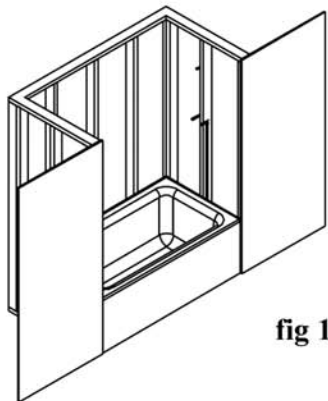


fig 1

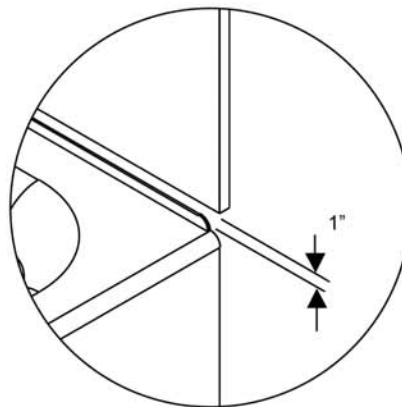


fig 2

4.14



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4.15 Tub Surrounds

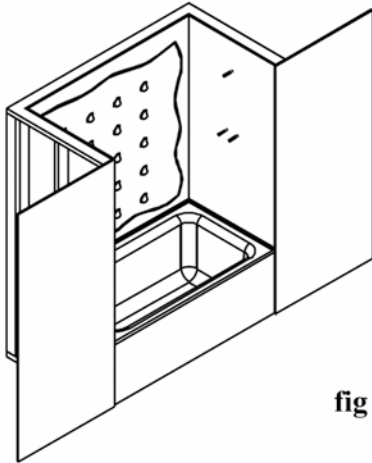


fig 3

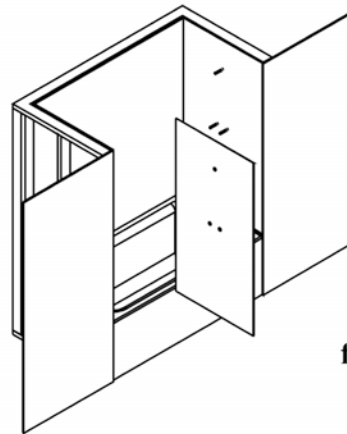


fig 4

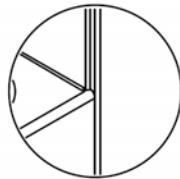


fig 5

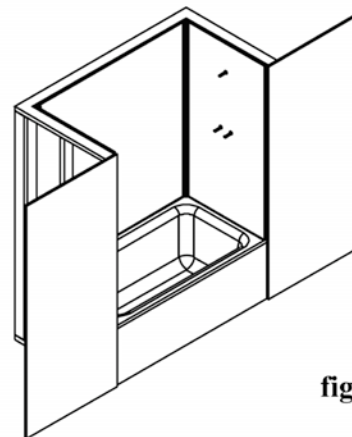


fig 6

4.15



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4.16 Countertop with Drop-in Sink

Installation Instructions

Prism® and Illusion Solid Surface Counter Top with Drop-in Kitchen Sink

NOTE: Before installation, check material completely to ensure that it was not damaged in transit. Check size, color and style/model to confirm the product matches the order. Verify that the counter top is the correct size for the cabinets. Follow plumbing fixture installation instructions when installing drains and faucets.

1. Verify that the cabinets are level and flat. See figure 1.
2. Two section tops that are ordered with "Jobsite Butt Fit" – Each section is up to 1" longer to allow for a perfect field fit. Trim extra material with a belt sander and #24 or #36 sandpaper or a saber saw. (Follow Standard Solid Surface Fabrication Procedures for seaming). See figure 2.
3. Saw counter top on backside or use wide masking tape to protect finished surface from scratches or chipping. Always support and protect the material when sanding or cutting.
4. Determine the location of the sink on the counter top.
5. Choose the correct template for your sink. Transfer the template to plywood or Masonite to create a hard template. Cut out the hard template allowing for your saw blade or router bit width. A smooth accurate template is required for a proper fit.
6. Cutout Position – A suggested location for the cutout is centered front to back allowing for faucets. Customer preference may change location.
7. Cut opening with router bit using the template as a guide. See figure 3.
8. Space lateral (front to back) supports 24" or less. See figure 4.
9. Apply a small bead of clear silicone sealant to the top edge of the cabinet or frame. See figure 5.
10. Carefully lower the counter top into position and press firmly into place. See figure 6.
11. Sink Installation – Follow the plumbing fixture installation instructions for installing drain and faucet.
12. Clean underside of sink flange with denatured alcohol. Apply a bead of silicone around the flange. See figure 7.
13. Position the sink in the opening of the countertop. Press the sink into place to secure it. Wipe up any excess sealant with denatured alcohol.
14. Bond side splashes and back splashes to the counter top and tool the seams with silicone sealant. Seal and carefully tool all joints with silicone sealant to provide smooth contoured joints. See figure 8.
15. Complete plumbing connections.

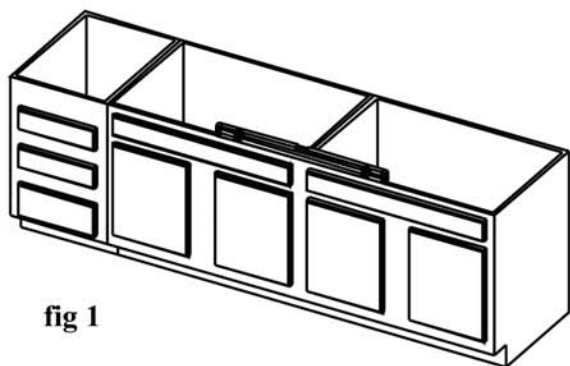


fig 1

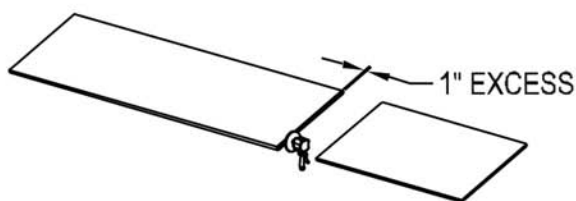


fig 2

4.16

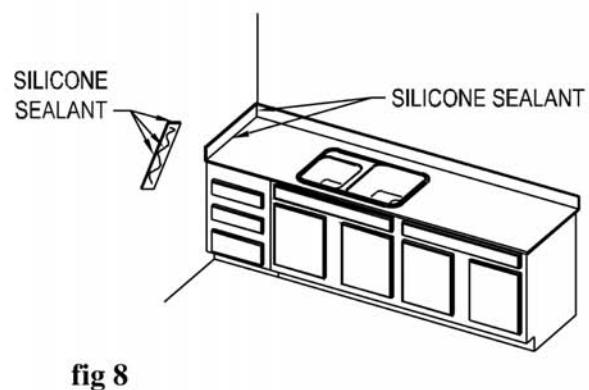
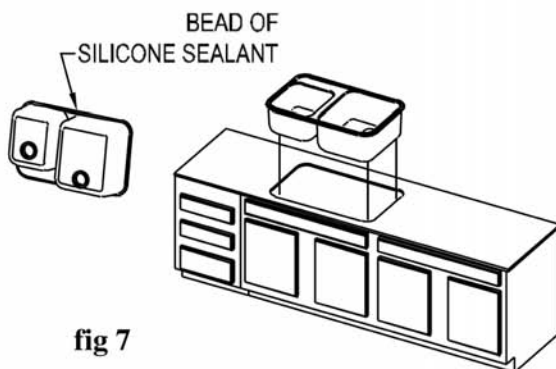
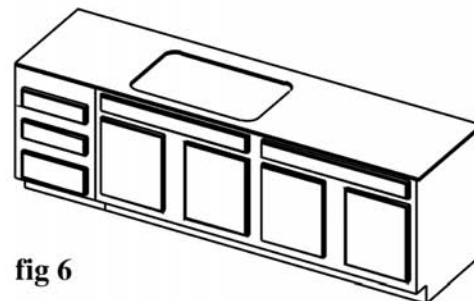
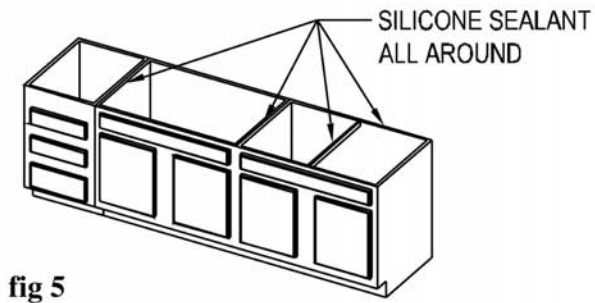
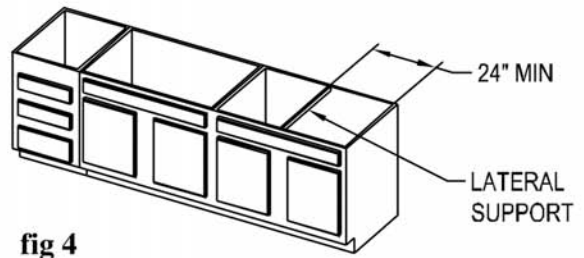
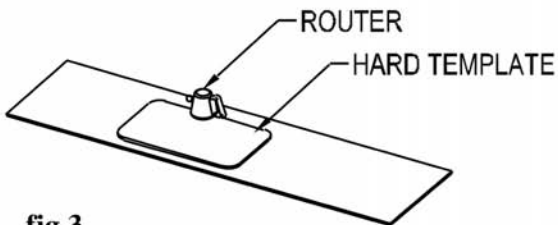


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4.17 Countertop with Drop-in Sink



4.17

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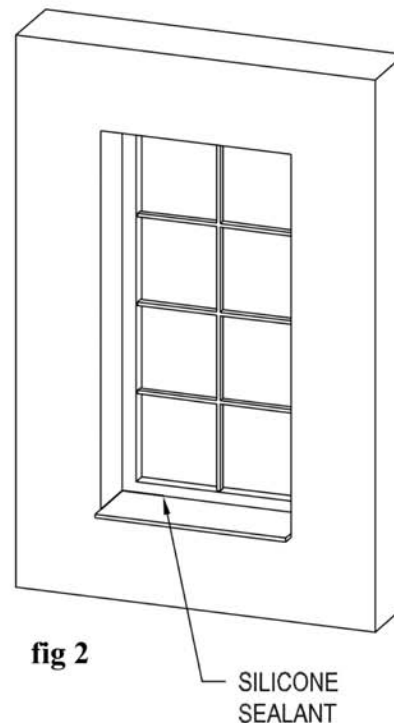
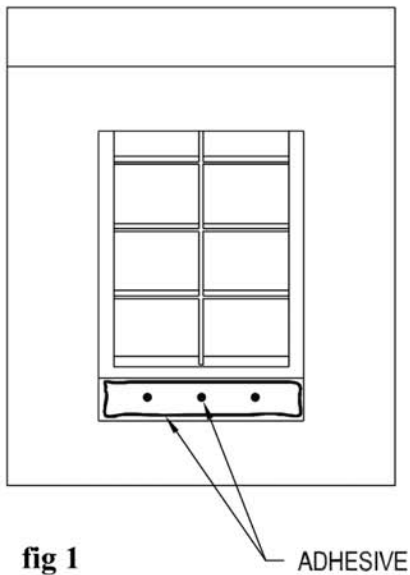
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4.18 Window Sills

Installation Instructions

Prism® and Illusion Window Sills

1. Window sills are manufactured to your specifications. If trimming is required use a belt sander with #24 or #36 sandpaper or a saber saw to trim sills. DO NOT trim the finished edges of sills. Note: always support sills properly when sanding or cutting.
2. Apply a bead of clear adhesive within 2" of the perimeter of the area where the sill will be installed. Apply 1" diameter portions of clear adhesive spaced 8" apart over the remaining field. See figure 1.
3. Position the sill in the opening and press the sill it into place.
4. Apply a bead of silicone sealant around the perimeter of the opening. See figure 2.



4.18



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5.1 Clean-up

Prism Solid Surface and Illusion Solid Surface Clean-up and Maintenance

Precautions

Avoid placing hot objects on the solid surfacing counter top. Use a trivet or other insulator under hot pots, pans, electric frying pans, crock-pots, toaster ovens and similar appliances. (Toasters, coffee makers and microwave ovens DO NOT need protection.) Avoid contact with oven cleaners, nail polish removers, paint removers, acid drain cleaners and other strong chemicals. If accidental contact should occur, flush the area immediately with water. Your solid surfacing countertop can withstand significant loads, but do not sit or stand on your countertop.

General Cleaning

Wipe surface with a cloth or sponge and soapy water. Rinse and dry after wiping.

Stubborn Stains, Scratches and General Restoration

Matte Finish & Sinks

1. Scour with a green Scotch-Brite pad and an abrasive cleanser followed by the general cleaning instructions.
2. For really stubborn stains, sand with a sanding block and 60 micron (P-grade, P220 grit) silicon carbide sandpaper in a circular motion. Use consistent pressure. If you are not skilled at sanding, do not attempt this method. Then follow step 1.

Semi-Gloss

1. Scour with a green Scotch-Brite pad and a non-abrasive cleanser followed by the general cleaning instructions.
2. For really stubborn stains, sand with a sanding block and 40 micron (P-grade, P320 grit) silicon carbide sandpaper in a circular motion. Use consistent pressure. If you are not skilled at sanding, do not attempt this method. Then follow step 1.

5.1



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5.2 Warranty

Limited Warranty

InPro Corporation (InPro) warrants to the purchasers that all Prism and Illusion Solid Surface products sold by it will be free of manufacturing and material defects. Failure to use certified fabricators, proper fasteners, adhesives, other finishing or maintenance accessories and/or other installation methods consistent with InPro installation instructions shall relieve InPro of any liability. Physical abuse, misuse, neglect, abnormal usage, movement from original location, structural movement, excessive temperature damage or breakage not due to a defect in the material is not covered by the warranty. The warranty does not apply to damage to the product caused while in transit nor does it cover slight imperfections, warp or shade variations in products. Each Illusion item has unique shading and veining patterns; the warranty does not cover any claims regarding color, shading and veining. The warranty does not cover exterior usage of this product or exposure to exterior elements. Any defective product will be replaced free of charge if a claim, proof of purchase and original location is presented in writing to InPro within TEN (10) YEARS following the date of sale. InPro will not be responsible for any removal or installation costs involved in such replacement. Replacement will include shipment costs within the United States. The obligation to the warranty allows InPro the right to use colors, shapes and sizes that are available at the time of the replacement as the replacement. This warranty is IN LIEU OF any other warranty, express or implied, including, but not limited to, any implied warranty of MERCHANTABILITY or fitness for a particular purpose. Our liability under this warranty is limited to replacement of product and does not include any responsibility for incidental, consequential, indirect, special, punitive or exemplary damages of any nature, whether or not based in warranty, contract, indemnity, tort (including negligence) or any other theory or law or equity. This warranty gives you specific rights and you may have other rights which vary from state to state. Some states do not allow limitations of implied warranties or consequential damages, so these limitations may not apply to you. This warranty is non-transferable.



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Inspect contents soon. You must file a claim with the carrier within 15 days of your receipt of product if damage within the carton is found.



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