

This bulletin summarizes the quality standards that must be met when fabricating and installing DuPont Corian® to ensure that “installed warranty” coverage is considered.

**CTDC-117 Rev. March, 2006 (effective 5/01/06)**

## **Technical Bulletin**

DuPont Corian®  
Wilmington, DE

# **Required Fabrication and Installation Procedures for Corian® Products**

The 10-Year Limited Residential Installed Warranty for DuPont Corian®, where offered, does not cover damage caused by failure to follow proper fabrication and installation procedures, fabrication for which DuPont does not have published procedures, or damage caused by customer abuse. The list below highlights mandatory procedures. Items added since the January 2000 issue of CTDC-117 are shown **bold italicized**. For complete details of these procedures, refer to the “Corian® Fabrication Manual” (C956-H71343),

### **1. Seams**

- Reinforce all shop and field seams. This Corian® reinforcement also serves as the seam support.
- Use only approved adhesives.
- Do not rigidly adhere Corian® to other solid surface products. Use only silicone to adhere wood, steel, ceramic tile, granite, marble, engineered stone, etc., or other solid surface products to Corian®.

### **2. Cutouts**

- Use only routers. Use  $\frac{3}{8}$ ” (9.5 mm) or larger diameter bits. Round over top and bottom edges of the cutout to a  $\frac{1}{16}$ ” (1.5 mm) minimum radius.
- Remove all nicks, tool marks, etc. Use 150-grit or finer sandpaper.
- Sand back edge of countertop behind cooktop smooth and round over top and bottom edges to  $\frac{1}{16}$ ” radius.
- Support within 3” (76 mm), but no closer than 1” (25 mm), from the edge of the cutout.

- Leave at least  $\frac{1}{8}$ ” (3 mm) clearance space on all sides to allow cooktop/sink expansion.
- High-strength cutouts are required on all cutouts made for heat-generating appliances.

### **3. Installation**

- The tops of the cabinets must be flat and true to within ***1/8” over a 10’ run***.
- Provide only perimeter support (top edges of cabinets with or without buildup strips). Use only dabs of flexible adhesive no less than 12” (305 mm) apart to fasten tops of Corian® to the perimeter support.
- Allow  $\frac{1}{16}$ ” (1.5 mm) minimum clearance between Corian® and walls.
- Support overhangs exceeding: 6” (152 mm) for  $\frac{1}{2}$ ” (13 mm) Corian®; 12” (305 mm) for  $\frac{3}{4}$ ” (19 mm) Corian®.
- Never install mechanical fasteners (screws, nails, etc.) into Corian®. Brass inserts are the only approved fastener.

- In wet wall installations, leave a 1/2" (13 mm) air gap at the bottom of the substrate wall to prevent water leaks from wicking up between the Corian® and the substrate.
- Leave a min. 12" x 12" piece of color match material from each counter on the job for future repairs screwed to the inside of the sink base cabinet.
- Apply 3M brand aluminum tape (3M stock number 4253UAL35175) around cooktop cutouts. The tape must cover all Corian® surfaces under the entire flange, including the vertical edges of the cutout.
- Radius all inside corners of L, U, etc., shaped tops to reduce corner stresses to minimum 1/2" (13 mm) radius. Offset seams in Corian® buildup strips minimum 1" past end of radius.
- Do not install Corian® over underlayment or over old countertops. Integral "dust covers" may be left in place if removal is unacceptable to the customer.

**For additional requirements with hot and cold food service and buffet counters, follow all procedures described in CTDC-125 or Fabrication Manual—Section 20 (C956-H71343).**

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