<table>
<thead>
<tr>
<th>Page</th>
<th>Section</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>HANDLING / STORAGE</td>
</tr>
<tr>
<td>2</td>
<td>TOOLS</td>
</tr>
<tr>
<td>5</td>
<td>JOB PLANNING / LAYOUTS</td>
</tr>
<tr>
<td>7</td>
<td>SAFETY / PRECAUTIONS</td>
</tr>
<tr>
<td>9</td>
<td>DECK SEAMS</td>
</tr>
<tr>
<td>12</td>
<td>DROP EDGES</td>
</tr>
<tr>
<td>16</td>
<td>SINKS</td>
</tr>
<tr>
<td>19</td>
<td>CUTOUTS</td>
</tr>
<tr>
<td>22</td>
<td>COVE BACKSPLASH</td>
</tr>
<tr>
<td>23</td>
<td>THERMOFORMING</td>
</tr>
<tr>
<td>24</td>
<td>FINISHING</td>
</tr>
<tr>
<td>26</td>
<td>INSTALLATION</td>
</tr>
<tr>
<td>32</td>
<td>COMMERCIAL</td>
</tr>
<tr>
<td>42</td>
<td>REPAIR</td>
</tr>
<tr>
<td>46</td>
<td>PRODUCT INFORMATION</td>
</tr>
</tbody>
</table>
Any fabrication procedure or technique not contained within the Wilsonart® Gibraltar® and Earthstone™ Fabrication Manual will not be recognized by Wilsonart® International as an approved method of fabrication. Deviations from these techniques must be approved in writing from a Wilsonart® Representative.
Handling, Storage and Inspection

• Handling:
  Carry Gibraltar and Earthstone sheets vertically to minimize flexing.

• Storage:
  Store Gibraltar and Earthstone sheet goods flat on pallets or other suitable racks. (FIG. 1A)

  Store Wilsonart Gibraltar sinks in their original shipping boxes until ready to install. (FIG. 1B)

  Store WA8215™ seam adhesive in cool, stable refrigeration unit. The optimum temperature is below 50°F (10°C) and above 32°F (0°C). The shelf life of the seam kits will be greatly increased by refrigerated storage.
  (Do Not Freeze)

• Inspection:
  Every effort has been made to supply high quality materials, free of defects. However, you the fabricator, must conduct a final (precutting) inspection to continue the quality control process prior to fabrication.

• Sheet Selection Process:
  Gibraltar and Earthstone sheets are color matched by lot numbers only. (FIG. 1C)

• Product information labels containing lot numbers are adhered to the Gibraltar and Earthstone panels. The labels must be included on the Warranty Registration Card, and the warranty information labels. Wilsonart International requires this information to validate the 10-year installed warranty.
Suggested Tool List

- The following suggested tool list is only a minimum requirement for professional and successful Gibraltar fabrication.

- Various woodworking and specialized solid surface fabrication tools are available in the market today. (See the Tool Supplier listing in the appendix).

**Stationary Tools**
- Table or Panel Saw
- Miter ("Chop") Saw
- Triple Chip Carbide Saw Blades

**Hand & Power Tools**
- Routers (FIG. 2A)
  - 3¼ HP w/½" (13mm) collet
  - 3¼ HP Plunge base w/½" (13mm) collet
  - 1½ - 2½ HP w/½" (13mm) collet (edge details)
- General Router Bits
  - ½" (13mm) straight cut
  - ½" " (13mm) Bottom bearing flush trim bit
  - 1" (25.4mm) Top bearing flush trim bit
  - Bottom bearing rabbeting bit
  - Various profile bits
- Bowl Bits (Wesley Tools)
  - 300-285 WI-Flush trim bit
  - 300-324 WI-Kitchen profile bit
  - 300-133 WI-Vanity profile bit
- Sanders (FIG. 2B)
  - Random Orbital
  - Dust collection system (suggested)
  - Sanding Disks (Micron)
  - Scotch-Brite pads
- Straight Edges (Phenolic or Metal)
- Clamps (FIG. 2C)
  - Spring clamps
  - Adjustable clamps
  - Bar (or pipe) clamps
<table>
<thead>
<tr>
<th>Recommended Table Saws</th>
<th>Recommended Panel or Vertical Saws</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Powermatic 1-800-248-0144</td>
<td>• Holz Her 1-704-587-3400</td>
</tr>
<tr>
<td>• Delta 1-800-438-2486</td>
<td>• Striebig 1-781-585-4364</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Recommended Routers</th>
<th>Recommended Router Bits</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Porter Cable 1-800-321-9443</td>
<td>• Amana Tool 1-800-445-0077 1-516-752-1300</td>
</tr>
<tr>
<td></td>
<td>• Velepec 1-800-365-6636</td>
</tr>
<tr>
<td></td>
<td>• JCM 1-800-669-5519</td>
</tr>
<tr>
<td></td>
<td>• DML 1-800-242-7003</td>
</tr>
<tr>
<td></td>
<td>• Wesley Tools, Ltd. 1-516-338-5555</td>
</tr>
<tr>
<td></td>
<td>• Leitz 1-800-253-6070</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Recommended Sanders, Belt</th>
<th>Recommended Sanders, Random Orbital (Electric)</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Porter Cable 1-800-321-9443</td>
<td>• Fein 1-412-331-2325</td>
</tr>
<tr>
<td></td>
<td>• Porter Cable 1-800-321-9443</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Recommended Sanders, Random Orbital (Air)</th>
<th>Recommended Sandpaper</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Dynabrade 1-716-631-0100</td>
<td>• 3M 1-800-328-5949</td>
</tr>
<tr>
<td>• Master Power 1-410-876-0076</td>
<td>• Micro Mesh 1-319-732-3240</td>
</tr>
<tr>
<td></td>
<td>• Norton 1-800-446-1119</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Recommended Pipe and Bar Clamps</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Bessey 1-800-828-1004</td>
</tr>
</tbody>
</table>
## Recommended Manufacturers Tools

- **Fein Power Tools**
  - 1-800-441-9878
  - Dustless sanding system

- **The Pinske Edge**
  - 1-800-874-6753
  - Specialized solid surfacing tools

- **Specialty Tools**
  - 1-800-669-5519
  - Tool catalog

- **Art Betterley**
  - 1-612-755-3425
  - Tool catalog

- **Alignrite**
  - Disc sanders and attachments

- **A.M.P.S.**
  - 1-800-678-8692
  - Straight edge

## Recommended Saw Blades

<table>
<thead>
<tr>
<th>Tool Manufacturer</th>
<th>Phone#</th>
<th>Part#</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Amana</td>
<td>1-800-445-0077</td>
<td>610721</td>
<td>10” (254mm) dia. 5/8” (15.9mm) bore 72 teeth</td>
</tr>
<tr>
<td></td>
<td>1-516-752-1300</td>
<td></td>
<td></td>
</tr>
<tr>
<td>DML</td>
<td>1-800-242-7003</td>
<td>G10605</td>
<td>10” (254mm) dia 5/8” (15.9mm) bore 60 teeth</td>
</tr>
<tr>
<td></td>
<td>1-502-635-8100</td>
<td></td>
<td></td>
</tr>
<tr>
<td>FS Tool</td>
<td>1-800-387-9723</td>
<td>L01250</td>
<td>10” (254mm) dia. 5/8” (15.9mm) bore 80 teeth</td>
</tr>
<tr>
<td></td>
<td>1-416-475-1999</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Guhdo</td>
<td>1-800-544-8436</td>
<td>2045WFA</td>
<td>10” (254mm) dia. 5/8” (15.9mm) bore 60 teeth</td>
</tr>
<tr>
<td></td>
<td>1-616-698-2161</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Wood's Power Grip Co.</td>
<td>1-800-548-7341</td>
<td></td>
<td>Suction Cups</td>
</tr>
<tr>
<td></td>
<td>1-406-628-8231</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Art Betterley Enterprises</td>
<td>1-612-755-3425</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Forrest</td>
<td>1-800-733-7111</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Lietaz</td>
<td>1-800-253-6070</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Perfect Seam</td>
<td>1-770-463-8321</td>
<td></td>
<td>Seam leveler</td>
</tr>
<tr>
<td>Beaver Tools</td>
<td>1-314-773-5991</td>
<td>AL-1</td>
<td>Pneumatic adhesive remover</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Gibraltar / Earthstone Countertop Layout
Conventional Seam Locations

Radius all inside corners minimum
1/2" (13mm)

Offset seams at least 1" (25.4mm) from corners

Place seams no closer than 3" (76.2mm) from any cooktop cutout or dishwasher

Figure 5A
Gibraltar / Earthstone Countertop Layout
PT Seam Locations
Miter Fold, Vertical and Stacked Edges

Corner Support Block Requirements:

Profiles a 1/4" or less require:
• Minimum 1/2" x 1/2" block
• Minimum 1/2" inside corner radius

Profiles larger than 1/4" require:
• Minimum 1" x 1" block
• Minimum 1" inside corner radius
SAFETY / PRECAUTIONS
General, Adhesive, Tooling

General Safety

• All normal safety precautions must be followed while working with Gibraltar or Earthstone materials, including the use of eye, ear (sound) and face protection, safety shoes and hand protection. (FIG. 7A & 7B)

• Dust collection should be utilized when cutting, routing and sanding. The use of tools with dust collection is advised at all times.

Tools Not Recommended

• Jigsaws – Rout all cutouts. (FIG. 7C)

• Auger type drill bits – Use holesaw/router for larger holes. (FIG. 7D)

• ATB (Alternate Top Bevel) or ripping saw blades – Use only triple chip or solid surface cutting blades.

• Belt Sanders – Do not use belt sanders at seam areas. (FIG. 7E)

WA8215 Seam Adhesive

• WA8215 is for professional use only. WA8215 contains the following hazardous ingredients: Methyl Methacrylate, Benzoyl Peroxide, and Dibutyl Phathlate. Avoid prolonged breathing of vapors. Use only in a well ventilated area. Keep out of reach of children. Eye protection is always recommended. Motors and other equipment must be UL labeled explosion proof. For further information refer to WA8215 Material Safety Data Sheet included in each package.

Contact your local distributor or call 1-800-433-3222 for immediate response to a question concerning WA8215.
Fabrication

• Do not use lacquer thinner, acetone or other solvents on Gibraltar and Earthstone material.

• Colored or printed towels can leave a residue which will contaminate the seam material and cause a weak or stained bond line.

• Refer to the Thermoforming Section when forming or bending Gibraltar or Earthstone. Spot heating or cold bending will introduce internal stress into the product.

• All edges should be sanded smooth and free of sharp corners and kerf marks which result in stress points.
Deck Seams–Conventional

• Machine both edges to be seamed. (FIG. 9A)

• Seams should fit tightly when dry fitted.

• Place a release material (such as clear packing tape) under the seam to prevent contamination of deck seam.

• Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.

• Position sheets to be seamed 3/16” (4.8mm) to 1/4” (6.4mm) apart.

• Prepare clamping materials (Attach glue blocks if using this technique).

• Prepare seam kits.
  □ Purge cartridge & tip to ensure proper mixture of adhesive.

• Fill the seam to 1/2 full.
  □ Damming the ends will make this easier.

• Slide the sheets together. Make sure there is adhesive squeeze out along entire seam.

• Clamp the seam together. (FIG. 9B)

• DO NOT OVERTIGHTEN clamps.
  □ Over tightening will cause starved, weak seams.

• Remove adhesive squeeze out with router on “skis,” surface leveler, or random orbital sander.
  (FIG. 9C)
  □ Do not scrape, chisel or use belt sander on seam.

• All seams must be reinforced with a 4” (101.6mm) wide, 45° beveled Gibraltar seam support adhered to the back of the panel. (FIG. 9D)
  □ Reinforcement strip must be sanded smooth
  □ Reinforcement strip must cover length of seam.
  □ Overlap seam support 2” (50.8mm) on each side.
  □ Ensure complete adhesive coverage.

• Sand the finished seam to job specifications.
  (See Finishing Section, page 24)
Deck Seams–PT Seam

This method can be used with miter fold, vertical and stacked edges.

• Machine all edges to be seamed. (FIG. 10A)

• Optional biscuits can be used for alignment purposes only. (FIG. 10B)

• Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.

• Prepare clamping equipment.

• Prepare seam kit.
  □ Purge cartridge and tip to ensure proper mixture of adhesive.

• Apply two 3/16" (4.8mm) beads of adhesive on the edge of one panel to be seamed. (FIG. 10C)
  □ Apply sufficient adhesive which will cover entire drop edge and allow squeeze out along entire seam.

• Clamp the seam together. (FIG. 10D)

• DO NOT OVERTIGHTEN clamps.
  □ Over tightening will cause starved, weak seams.

(continued next page)
• Adhere a Gibraltar/Earthstone block into the inside corner and clamp in place. Block must cover entire length of seam from top of deck to bottom of drop edge. (FIG. 11A) (See page 6 for minimum requirements.)
  □ Squeeze out is required on both top and bottom of the seam and all sides of the corner block.

• Remove adhesive squeeze out with router on “skis,” surface leveler, or random orbital sander. (FIG. 11B)
  □ Do not scrape, chisel or use belt sander on seam.

• Rout radius at inside corner. (See page 6 for minimum requirements. (FIG. 11C)

• To accommodate face frame installs, a 1” minimum seam thickness is required over cabinet base, thus eliminating notching the cabinet base. (FIG. 11D)
Drop Edges - Stacked

- See page 13 for drop edge requirements for Melange and Earthstone patterns.

- Sand backside of areas to be seamed.

- Dry fit edge strips and fasten hot melt blocks. (FIG. 12A)

- Clean surfaces to be seamed thoroughly with denatured alcohol and clean white shop rag.

- Purge cartridge and tip to ensure proper mixture of adhesive.

- Apply WA8215 adhesive and clamp with spring clamps at 2" - 3" (50.8 - 76.2mm) intervals. (FIG. 12B)

- Make sure there is adequate glue squeeze out along entire seam.
  □ Check carefully for voids.

- Do not sandwich other materials (wood, metal, laminate, etc.) between Gibraltar / Earthstone edges. Use these type of inlays in a routed groove. (FIG. 12C)

- Flush trim drop edge. (FIG. 12C)

- Route requested edge profile.
Drop Edges - Vertical

• Gibraltar Solids, Tempest and Mirage patterns - Vertical and rebated vertical edge approved. (FIG. 13A-13D)

• Gibraltar Melange Patterns - Vertical suggested with rebated vertical edge preferred. (FIG. 13A-13D)

• Earthstone patterns - Rebated vertical edge required. (FIG. 13B-13D)

Vertical Edge Fabrication

• Inspect the edge of the Gibraltar sheet for chip distribution variation.

• Sand back side of areas to be seamed.

• Dry fit edge strips and fasten hot melt blocks.

• See Both Edges below for remaining steps.

Rebated Vertical Edge

• Using a bottom bearing rabbeting bit or a router with a straight edge, route a 1/16" deep by 1/2" wide rebate into the bottom side of the sheet.
  □ For a Bull Nose, route a 1/16" deep by 1" wide rebate to accept a double vertical stack.

Both Edges

• Clean surfaces to be glued thoroughly with dentured alcohol and clean white shop rag.

• Purge cartridge and tip for proper adhesive mixture.

• Apply WA8215 adhesive and clamp with spring clamps at 2" - 3" (50.8 - 76.2mm) intervals. (FIG. 12B)

• Make sure there is adequate glue squeeze out along entire seam.
  □ Check carefully for voids.
Inside Corners

- Inside corners are subject to higher stress, and therefore require special reinforcement.

- One of the following reinforcement procedures must be used.
  - Corner block method: minimum 3” (76.2mm) x 3” (76.2mm) block. (FIG. 14A)
  - Interlocking corner block method. (FIG. 14B)
  - Vertical strips method: Corner block. (FIG. 14C)

- The finished inside corner must be routed to a minimum 1/2” (13mm) radius.
  - Larger radiuses are better.

Outside Corners

- This method may be used up to 9” radius, requiring 1–3 Gibraltar / Earthstone strips placed on the angle. (FIG. 14D)

- For radius larger than 9”, refer to the Thermoforming Section on page 23.
Miter Fold Drop Edges

- Place Gibraltar / Earthstone face down on a solid, flat work surface. Clean miter.

- Remove corner block and trim hinge tape.

- Apply a 1/16" bead of WA8215 adhesive in the entire length of the miter fold seam. Also apply a 1/16" bead at one corner to be folded. (FIG. 15A)

- Fold up drop edge and clamp into place. Cam action clamps are suggested. (FIG. 15B)
  - Clamps should be within 2" (50.8mm) from each corner and located every 12" (304.8mm).
  - Place clamps 1/4" (6.4mm) above the face of the panel to ensure proper pressure.

  NOTE: Once drop edge is folded into place, do not allow the edge to separate from the deck.

- Fold up the end caps and secure in place with spring clamps or 3 way clamps. Clamps should be placed every 2" (50.8mm). (FIG. 15C)
  - Place 3 way clamps 1/4" (6.4mm) above the face of the panel.

- Adhesive squeeze out is required along entire length of seam and at all corners.

- Allow seam adhesive to cure completely before machining.
Sink Installation

• Inspect sink for imperfections and verify color.

• Position sink using center-line dimensions. (FIG. 16A)

  Note: Integral Gibraltar sink/bowls may be mounted over a seam using the same techniques listed below. (FIG. 16B & 16C)

• Multiple bowl configurations are permitted; however, special reinforcement guidelines are required. (See Installation Section, page 26.)

• Scuff area to receive sink using 80 micron or equivalent abrasive.

• Place wooden blocks with hot melt glue to position sink securely during glue up. (FIG. 16D)

• Rout hole in countertop directly under sink drain hole.

  Note: Make sure hole is large enough for pipe clamp

• Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.

(continued next page)
• Apply ample amount of WA8215 Seam Adhesive to sink rim. (FIG. 16A)

• Clamp with pipe clamp through the drain hole. (FIG. 17B)
  
  Note: Use wooden spacers under clamp at sink flange and drain hole to prevent damage.
  Note: Use clamp board (larger than the sink) under countertop to distribute clamping pressure.

• Check for seam kit squeeze out around entire sink area.

• Remove pipe clamps after seam adhesive hardens.

• Rout sink opening(s) using:
  □ Bowl flush trim bit (FIG. 17C)
  □ Bowl profile bit (FIG. 17D)
  See page 2 for suggested bits

• Sand inside of sink for proper finish (See Finishing Section, page 24 for sanding steps).

  Note: Gibraltar sinks must be sanded to provide consistant finish. Failure to finish sinks, very often leads to customer dissatisfaction.
### Product Description – Shaped Goods

Wilsonart kitchen sinks and vanity bowls are specially shaped solid surface products. They may be bonded to Gibraltar / Earthstone panels with Wilsonart WA8215 Seam Adhesive to create an integral bowl and countertop in either matching or contrasting colors. Because the Gibraltar formulation is specifically engineered for optimum performance, a slight variation in color may appear when a kitchen sink or vanity bowl is combined with the same color Gibraltar panels.

**Composition of the Product:** This product is composed of a proprietary mixture of resins and minerals. Wilsonart kitchen sinks and vanity bowls are completely homogeneous. The color has a consistent, uniform pigment throughout the thickness of each bowl.

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>BK222</td>
<td>Square Sink</td>
<td>Inside: 17&quot; x 17&quot; x 8&quot; (43.2cm x 43.2cm x 20.3cm)</td>
</tr>
<tr>
<td>BK324</td>
<td>Rectangle Sink</td>
<td>Inside: 21&quot; x 15 ½&quot; x 7 ½&quot; (53.3cm x 40.0cm x 19.0cm)</td>
</tr>
<tr>
<td>BK326</td>
<td>D-Bowl</td>
<td>Inside: 21&quot; x 16 ½&quot; x 7 ½&quot; (53.3cm x 42.5cm x 19.0cm)</td>
</tr>
<tr>
<td>BK325</td>
<td>Bar Sink</td>
<td>Inside: 9&quot; x 12&quot; x 5 ½&quot; (228mm x 305mm x 140mm)</td>
</tr>
<tr>
<td>BK323</td>
<td>Rectangle Sink</td>
<td>Inside: 10 ½&quot; x 16 ½&quot; x 8&quot; (26.0cm x 41.9cm x 20.3cm)</td>
</tr>
<tr>
<td>BD321</td>
<td>Offset Double Sink</td>
<td>Inside Overall: 30&quot; x 18&quot; x 8&quot; (76.2cm x 45.7cm x 20.3cm)</td>
</tr>
<tr>
<td>BD322</td>
<td>Double Sink</td>
<td>Inside Overall: 30 ¼&quot; x 18&quot; x 8&quot; (76.6cm x 45.7cm x 20.3cm)</td>
</tr>
<tr>
<td>BD323</td>
<td>Double Sink</td>
<td>Inside Overall: 32 ¼&quot; x 18&quot; x 8&quot; (82.5cm x 43.2cm x 19.7cm)</td>
</tr>
<tr>
<td>BK425</td>
<td>Drop Ledge Bar Sink</td>
<td>Inside: 9&quot; x 16&quot; x 8 ¾&quot; (22.9cm x 40.6cm x 21.6cm)</td>
</tr>
<tr>
<td>BK424</td>
<td>Drop Ledge Rectangle Sink</td>
<td>Inside: 21 ½&quot; x 19 ½&quot; x 9 ¾&quot; (55.2cm x 49.5cm x 24.8cm)</td>
</tr>
<tr>
<td>BD421</td>
<td>Drop Ledge Offset Double Sink</td>
<td>Inside Overall: 29 ½&quot; x 18 ½&quot; x 8 ½&quot; (74.3cm x 46.4cm x 21.6cm)</td>
</tr>
<tr>
<td>BD424</td>
<td>Drop Ledge Double Sink</td>
<td>Inside Overall: 28 ½&quot; x 18 ½&quot; x 8 ¼&quot; (72.4cm x 46.4cm x 22.2cm)</td>
</tr>
<tr>
<td>BV421</td>
<td>Drop Ledge Vanity Bowl</td>
<td>Inside: 17 ½&quot; x 15 ½&quot; x 6 ½&quot; (45.1cm x 39.4cm x 16.5cm)</td>
</tr>
<tr>
<td>BK320</td>
<td>Utility Bowl</td>
<td>Inside: 27 3/8&quot; x 17 7/8&quot; x 14&quot; (69.5cm x 45.9cm x 35.6cm)</td>
</tr>
<tr>
<td>BV120</td>
<td>Vanity Bowl</td>
<td>Inside: 14 5/8&quot; x 10 7/16&quot; x 5 3/8&quot; (37.1cm x 26.5cm x 13.6cm)</td>
</tr>
<tr>
<td>BV121</td>
<td>Vanity Bowl</td>
<td>Inside: 15 ½&quot; x 12 ½&quot; x 5 ½&quot; (40.0cm x 32.4cm x 14.0cm)</td>
</tr>
<tr>
<td>BV122</td>
<td>Vanity Bowl (ADA)</td>
<td>Inside: 15 ½&quot; x 12 ½&quot; x 3 ½&quot; (40.0cm x 32.4cm x 8.8cm)</td>
</tr>
<tr>
<td>BV123</td>
<td>Vanity Bowl</td>
<td>Inside: 16 ½&quot; x 13 ⅞&quot; x 5&quot; (41.9cm x 34.3cm x 12.7cm)</td>
</tr>
<tr>
<td>BV125</td>
<td>Oversize Sun Oval Vanity Bowl</td>
<td>Inside: 29 ½&quot; x 13 ½&quot; x 8&quot; (76.2cm x 34.3cm x 20.3cm)</td>
</tr>
</tbody>
</table>

*No right hand garbage bays available at this time.*
Cooktop Cutouts

- A minimum 1/4" (6.4mm) gap is required between edge of cutout and cooktop. (FIG. 19A)

- Cutouts must be performed with a router only. □ Cutouts must be left on job site.

- Corners of cooktop cutouts must be reinforced with 5" x 5" (128.5mm x 128.5mm) Gibraltar / Earthstone corner blocks. (FIG. 19B & 19C) - Note beveled edges.

- Inside corners of all cutouts must be radiused minimum 1/4" (6.4mm). (FIG. 19C)

- Ease top and bottom edges of cutout and reinforcing blocks.

- Sand sides of cooktop cutout to be free of roughness and router “chatter.”

- Wrap entire cooktop opening with Wilsonart 9 mil aluminum heat reflective tape.
  □ Inform cooktop installer that tape must not be removed.
  □ Double tape in corners to ensure coverage. Nomex will assist with heat resistance.

- Do not fold tape under the bottom of the cutout. (FIG. 19D)

- Tape must extend past the edge of cooktop flange. Trim excess (FIG. 19A & 19D)

- Never fasten cooktop to Gibraltar / Earthstone with mechanical fasteners.
  □ Use a wood block between Gibraltar / Earthstone and cooktop fasteners.

- If minimum cutout dimension listed above cannot be met, follow requirements for cooktop mantle.
Cooktop Mantle

• In the event that the 1/4” specification between the heat box and the edge of the cutout cannot be met, then a cooktop mantle is required.

• Refer to Cooktop Cutouts on page 19 for procedures.

• Allow 1/2” (13mm) clearance on all sides of the cooktop box. (FIG. 20B)

• Minimum 1/2” (13mm) radius is required at inside corners of cutouts.
  □ A larger radius if possible is preferred.

• Cut 1/2” (13mm) Gibraltar / Earthstone cooktop mantle pieces to desired length and width. (FIG. 20C)
  □ Minimum 1-1/2” (38.1mm) width is required. (FIG. 20D)
  □ Allow 1/16”–1/8” (6.4mm) gap between ring and cooktop body.
  □ Rectangular rings should consist of four pieces mitered or butt jointed with silicone only.
  □ Round cutouts should consist of a two or four piece ring.

• Rout profile on edge of ring and ease inside edges. (FIG. 20D)

(continued next page)
Cooktop Mantle

(continued)

- Adhere the cooktop mantle to the Gibraltar / Earthstone using a continuous bead of silicone and clamp in place with spring clamps until silicone has cured. (FIG. 21A)
  - Do Not hard seam mantle.

- Apply Wilsonart 9 mil aluminum heat reflective tape around entire mantle. (FIG 21B)
  - Ensure tape is in place after cooktop is installed.
  - Tape should hang straight down, do not fold under countertop.
  - Tape must extend past the edge of cooktop flange and be trimmed after cooktop installation.
  - Do not attach cooktop to ring with mechanical fasteners.
  - Apply a second piece of heat reflective tape in all corners to ensure adequate coverage.
  - Nomex insulation can be used to ensure added protection against excessive heat. (FIG. 21C)
Cove Backsplash

- Cut Gibraltar / Earthstone backsplash to desired height. (FIG. 22A)
  - Allow 7/16” (11.3mm) for cove strip. (FIG. 22A)
- Cut a 7/8” (22.23mm) strip of Gibraltar / Earthstone for coving.
- Bevel 7/8” (22.23mm) cove strip on 45° angle.
  - This will reduce router chatter
- Cut 7/8” (22.23mm) x 1/16” (1.6mm) rabbet into Gibraltar / Earthstone to accept cove strip. (FIG. 22A)
- Clean with denatured alcohol and clean white cloth.
- Adhere cove strip and backsplash to countertop with color matched seam adhesive.
  - 100% coverage is required.
- Ensure cove strip is tight against front edge of rabbet, and clamp with spring clamps and bar clamps. (FIG. 22B)
  - Squeeze out is required the entire length of all seams.
- After adhesive has cured completely, rout cove strip.
Thermoforming

• To thermoform Gibraltar / Earthstone material, an oven that will heat the material is needed. A convection or infrared oven will give the best results. (FIG. 23A)

• The sheet temperatures should be between 280° to 325°F (137.8° to 162.7° C) throughout the thickness during bending.
  NOTE: Cold spots in the sheet will lead to cracks and whitening. Hot spots may cause blistering, discoloration, whitening and cracks.

• Gibraltar / Earthstone material has a minimum bending radius of 3” (76.2mm).
  NOTE: Bending sheets to a smaller radius can result in crazing, whitening, cracking, or reduction in impact resistance.

• For the best result, a set of male and female molds should be used to form the sheet into the desired radius shape (this is highly recommended for thermoforming 1/2” (13mm) sheets. (FIG. 23B)

• Heat Guns, Torches and Cal Rods will cause failure with Gibraltar countertops.
  NOTE: Spot heating or localized heating will cause problems due to the temperature difference between the heated area and the unheated area. The stress build-up at the interface between the heated and unheated area will lead to cracking after the top is installed. (FIG. 23C)

Cool Down
• Allow the thermoformed sheet to cool down in the mold to less that 170° F (76.6° C) before removing from mold. Depending on the surrounding room temperature, cool down will take approximately 20 to 40 minutes.

Seaming
• All seaming must be done after thermoforming.
Procedures

- Wipe all sanding dust from countertop surface between grit changes.
- Be careful when selling dark colors and/or gloss finishes. Inform your customer of the extra care and maintenance required.

Products

3M® Surfacing Abrasives – 1- 800-364-3577
There are 13 micron grades. Micron grade 100 the coarsest, is approximately equal to a grade 150 in the U.S. standard system. The .3 micron grade, one of the finest grades, is equivalent to a 10,000 grit.

Scotch-Brite® by 3M® – 1- 800-364-3577
3M’s Scotch-Brite® Pad order of coarseness: 7447 Maroon (Fine), 7448 Grey (Very Fine), and 7445 White (Ultra Fine).

3M® Trizact™ Abrasives – 1-800-742-9546 or 1-800-364-3577 in the U.S.A.
651-737-6501 outside the U.S.A.
Decreases the amount of sanding steps involved in finishing a countertop. With the Trizact™ system, there is no need to finish the top with 3M® Scotch-Brite® pads.

Mirka Abralon Pads – 1-800-843-3904
Recommended for dark colors.

Standards

- U.S. standard system: 16 grit (coarsest) to 2,000 grit (finest)
- Trizact™: 60mx (coarsest) to 20,000mx (finest)
- Micron system: 100 micron (coarsest) to .3 micron (finest)
- Abralon: Medium (coarsest) to mirror fine (finest)
Abrasives
Sanding Steps
“Quick Steps” to Final “Finish”

For final finishing use the following steps located in the Abrasive Cross Reference Chart below:

<table>
<thead>
<tr>
<th>Finish Type</th>
<th>USA Grit Scotch-Brite™</th>
<th>3M™ Micron Scotch-Brite™</th>
<th>Trizact™ Film</th>
<th>Mirka Abralon</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Matte</td>
<td>150</td>
<td>100u 80u 60u 7447</td>
<td>366L Brown 100u 268XA Green A35 268XA Blue A10/7447</td>
<td>N/A</td>
<td>Recommended Standard Finish Easy/Low Maintenance</td>
</tr>
<tr>
<td></td>
<td>180</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>220</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7447</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Satin</td>
<td>150</td>
<td>100u 80u 60u 7448</td>
<td></td>
<td>100u 80u 60u</td>
<td>Medium 360</td>
</tr>
<tr>
<td></td>
<td>180</td>
<td></td>
<td>100u 80u 7448</td>
<td></td>
<td>Slightly More Difficult Medium Maintenance</td>
</tr>
<tr>
<td></td>
<td>220</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>280</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7448</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Semi Gloss</td>
<td>150</td>
<td>100u 80u 60u 7448</td>
<td>366L Brown 100u 268XA Green A35 268XA Blue A10 268XA Orange A5</td>
<td>100u 80u 40u 60u Medium 360 Super Fine 1000</td>
<td>Requires special customer instructions Requires Fabricator to refinish</td>
</tr>
<tr>
<td></td>
<td>180</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>220</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>280</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7448</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7445</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Gloss</td>
<td>150</td>
<td>100u 80u 60u 7448</td>
<td>366L Brown 100u 268XA Green A35 268XA Blue A10 268XA Orange A5 568XA White CeO</td>
<td>100u 80u 40u 60u Medium 360 Super Fine 1000 Mirror Fine 4000</td>
<td>Recommended for vertical surfaces only Requires fabricator to refinish</td>
</tr>
<tr>
<td></td>
<td>180</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>220</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>280</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7448</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>7445</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Buffer with Polishing Compound</td>
<td>Buffer with Polishing Compound</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

The gloss finish is not recommended for high traffic areas. It requires a trained fabricator to maintain its finish.
Jobsite Preparation

- Install web supports as required.
  - Place around perimeter of countertop and at each cabinet support.

- Webbing must be straight, flat and level after installation. If shims are used, they must be installed between the cabinet and the web frames, not directly under the countertop. (FIG. 26A)

- Do not install Gibraltar over a solid substrate, except at overhangs. (See page 27)

- Certain unsupported areas are in need of stronger frame material. These include inside corner cabinets, especially lazy Susans, dishwasher openings, sink base fronts, desks and anywhere else that the cabinet is weaker than others. (FIG. 26B)

- Place web supports at both sides of all cutouts. Place supports no closer than 1" (25.4mm) and no further than 3" (76.2mm) from sides of cutout.
  - See page 28 for additional web support requirements.

- Multiple bowl installations require special reinforcement to provide adequate support.
  - Place web support at both sides of the bowl installation.
  - Place solid wood, MDF or plywood supports between each bowl.
  - Supports must rest on cabinet base or be attached to cabinet base to alleviate flexing.
Overhangs

- Additional support is required when the countertop overhangs the cabinet. (FIG. 27A) Refer to the following chart to determine support required:

<table>
<thead>
<tr>
<th>Overhang</th>
<th>Support Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>0 - 6” (0-152.4mm)</td>
<td>None</td>
</tr>
<tr>
<td>6 - 12” (152.4mm-304.8mm) (FIG. 27A)</td>
<td>Brackets (corbels) (Under web frame support) or 3/4” plywood underlayment</td>
</tr>
<tr>
<td>12 - 18” (304.8mm-457.2mm) (FIG. 27B)</td>
<td>Brackets (corbels) (Under web frame support) and 3/4” plywood underlayment</td>
</tr>
<tr>
<td>18 - 24” (457.2mm-609.6mm)</td>
<td>Brackets (corbels) and 3/4” plywood underlayment and supporting legs</td>
</tr>
</tbody>
</table>

- When brackets (corbels) are used, place them no more than 24” (609.6mm) apart. In addition, place brackets 12” (304.8mm) from open ends and against wall ends. (FIG. 27B & 27C)
Web Support Layout

Recommended web support material includes: Medium Density Fiberboard (MDF), particle board, plywood, hardboard etc.

Figure 28A (Option 1)

Figure 28B (Option 2)
Securing the Countertop

- Use only 100% pure silicone to secure countertop to web frame.
  - No construction mastic

- Use dime sized dabs every 18” (457.2mm) to 24” (609.6mm). (FIG. 29A)
  - Secure all outside corners
  - Do not run continuous beads
  - Do not place silicone in the inside corners

- No mechanical fasteners should be used to fasten the countertop. Never screw, staple or nail into Wilsonart Gibraltar. (FIG. 29B)

Fitting the Countertop

- Provide minimum 1/8” (3.2mm) gap at all walls for every 12 foot of countertop. (FIG. 29C)

- Scribe to wall as necessary. (FIG. 29D)
Hot and Cold Food Wells

- Base cabinets should be vented and contain a fan for continuous air flow.

- Seams are not allowed through cutouts. (FIG. 32A) 
  - Seams must be a minimum 3" from all cutouts.

- An 1/8" (3.2mm) flexible silicone seam is required between hot and cold food wells. (FIG. 32A)

- All cutouts must be routed.

- Minimum 1/2" (13mm) gap between edge of cutout and heat source. (FIG. 32B)

- Minimum 1/2" (13mm) radius required on all inside corners of cutouts. (FIG. 32A)  
  - Prefer larger radius if possible.

- Inside corners of all hot well cutouts must be reinforced with 5" x 5" beveled Gibraltar high strength reinforcement blocks. (FIG. 32B & 32C)

- Ease top and bottom of all cutouts and reinforcement blocks.

- Sand cutouts free of roughness and router chatter.

- A Mantle is required for all hot wells. (FIG. 32D)

- Wilsonart 9mil heat reflective tape and Nomex insulation is required on all hot wells. 
  - The heat reflective tape must extend past flange of heat source and then be trimmed.

---

**Figure 32A**

Required min. 1/8" (3.2mm) silicone seam between hot and cold food wells

- 3" (76.2mm) minimum between cutouts
- 1/2" (13mm) radius minimum at each inside corner
- Flexible Seam
- Seam must be 3" (76.2mm) minimum away from cutout

**Figure 32B**

Minimum 1/2" radius required on all inside corners

- 1" Minimum Typical (25.4mm)
- 6" (128.5mm)

**Figure 32C**

Outer edge should match front edge detail

- 1/8" (3.2mm) Roundover

**Figure 32D**

Gibraltar Mantle

Gibraltar Deck

Nomex insulation

Wilsonart 9mil Aluminum Heat Tape

- 1-1/2" Minimum (38.1mm)
Provide 1/8" (3.2mm) silicone breaks between hot and cold sides of food bars to accommodate differing rates of dimensional movement.

Silicone break can be covered with a decorative batten strip.

Always leave expansion and contraction space

Seal with silicone

Block up Sneeze Guard Support with wood block

To provide longer service and add design flare, use stainless, brass or steel rods

Brace tray slides as required, see page 27 for details.
These instructions are for 1/4" and 1/2" thick Wilsonart Solid Surface.

Substates

- The following are substrates which will allow proper support of Gibraltar wall cladding.
  - Plywood - A-face preferred
  - Masonite
  - Drywall
  - Cement board
  - Tile

- Substrate surface must be sound, flat, smooth and free of dust or other contaminants during installation. Any loose ceramic tile must be removed and the void filled level to tile surface with thinset or above substrates.

Recommended Adhesives

- 100% Silicone - All substrates and required expansion joints
- Liquid Nails 933 - Wood and drywall substrates
- 8215 - Approved hard seams

Installation Requirements - General

- Minimum 1/8" silicone filled expansion gaps are required at:
  - All inside corners (Figure 34A)
  - Between finished floor and ceiling on full height wall cladding. (Figure 34B)
  - Every 10'-12' of wall length/height.
  - 1/8" minimum off finished floor for all wainscoting.

- A combination of hard seams and silicone seams can be utilized for wall cladding installations.
  - See Wall Cladding Seam Option Drawings on pages 39-41.

- Panels must be routed to size, no saw cuts.

- All seams must be flat/level and well supported by a sound recommended substrate.

- All hard seams must have release material between the substrate and the seam adhesive, Do Not seam to substrate.

- All cutouts must be routed.
  - Allow minimum 1/16" expansion gap around entire cutout.
  - Minimum 1/4" radius required at inside corners of cutouts.

(continued next page)
Installation Requirements - General (continued)

• Ease all edges including inside of all cutouts.

• Accessories like hand rails, grab bars, seats, etc., must be supported by wall framing.
  • Oversize all holes for accessories 1/8” larger than attaching hardware to be used.
  • Do not over tighten.

• All accessories applied to the face of the Gibraltar must allow for expansion and contraction.

• Apply LN933 flexible wall panel adhesive to wall, not on panels.

• Insure back side of wall panel has been scuffed or sanded to remove gloss.

• Final finish to be provided by fabricator. See Finishing Section in Wilsonart Solid Surface Fabrication Manual.

Safety Notes and Suggestions:
Maintain all local, county, state and federal work area safety requirements. Always use personal protective equipment including eye, ear (sound) and face protection, safety shoes and hand protection. Read and follow the manufacturers’ application and safety instruction information for LN933 flexible panel adhesive, silicone adhesive sealant and WA 8215. Ensure adequate ventilation before applying adhesives or caulking materials.
Size Panel

- Check corner to see if vertically plumb.
- Measure width and height of area where wall panel is to be installed.
- Allow for min. 1/8" gap at floor, ceiling and corners as indicated on page 34. (Figure 36A)
- For non-plumb corners, scribe the side of panel to be placed at the corner so that the opposite edge of panel is plumb.
- Trim panel to size with a router and a straight edge.
- Place shims on floor and dry fit panel to wall.
- With a pencil, outline the edge of the panel on the wall to indicate area to accept wall panel adhesive. (Figure 36B)

Adhesive Application

- Apply a continuous 1/4" bead of silicone 3/4" inside the perimeter of the panel outline. (Figure 36C)
- Apply a continuous 1/4" bead of silicone or flexible panel adhesive every 6"-8" inside the perimeter bead. (Figure 36C)
- Place panel on shims and press to wall. Apply firm pressure from the center of the panel working towards the edges.
- Dabs of hot melt on the wall will assist to hold panel in place.
- Use a J-roller or comparable tool to apply pressure.
- Brace panel as necessary until adhesive has set. (Figure 36D)
- Remove all excess silicone.
Multiple Panel Installation

- Refer to pages 39-46 in this section for seam options and requirements.

- Prepare as many seams as possible in shop.

- All edges to be seamed must be routed.
  - Refer to the Deck Seams Section of this manual for seam preparation techniques.

- After sizing the second panel, dry fit and mark outline of second panel on wall. (Figure 37A)

- Apply wall panel adhesive as described on previous page. (Figure 37B)

- Apply release tape on wall if WA8215 adhesive is used to make an inconspicuous seam.

- Apply sufficient seam adhesive (WA 8215 or silicone) along edge of panel, lap joint and/or batten to provide 100% coverage and adhesive squeeze out along entire seam. (Figure 37B)

- Place second panel on shims and angle panel to allow only areas to be seamed to come into contact. (Figure 37B)

- With firm pressure towards the seam, press panel to wall and apply firm pressure to entire surface of panel as described on page 2.

- Clamp seam together and insure seam is level.

- Brace panel as necessary until adhesive has set. (Figure 37C)

- Remove excessive adhesive.
  - WA8215 - Refer to the page 9 of the Deck Seam Section in this manual for approved techniques.

- Finish seam to job specification.
  - Refer to page 25 of the Finishing Section of this manual for finishing steps.
Molding Installation

- Adhere baseboard moldings and/or crown moldings as needed with 100% silicone only.
- Do Not hard seam molding
- Provide min. 1/8" silicone gap at all inside corners.
- Apply a continuous bead of silicone to top and bottom of moldings. (Figure 38A-38C)

- Apply small dabs of hot melt to hold moldings in place until silicone has cured. (Figure 38A-38C)
- Locate moldings on wall and press in place.
- Remove all excessive silicone.

Wainscoat Molding Installation

- Adhere baseboard moldings and/or chair rail moldings as needed.
- Do Not hard seam molding
- Provide min. 1/8" silicone gap at all inside corners and between top of panel and molding. (Figure 38D)

- Apply a continuous bead of silicone to top and bottom of moldings. (Figure 38D)

- Apply small dabs of hot melt to hold moldings in place until silicone has cured. (Figure 38D)

- Locate moldings on wall and press in place.
- Remove all excessive silicone.
Silicone Butt Joint

Figure 39A

Silicone Joint w/ Batten Strip

Figure 39B
Silicone Lap Joint

Figure 40A

Hard Seam Butt Joint Batten Supported (recommended hard seam)

Figure 40B
Hard Seam Butt Joint

Figure 41A
Plug (Pie) Repair

• Tools required: Plunge router, repair template, double stick tape, random orbital sander and a 1/2” beveled cutter with a snap ring template guide repair set (FIG. 42A) available from:
  * Specialty Tools  1-800-669-5519
  * Art Betterley  1-800-871-7516

• Make a template from 1/4” (6mm) material to the size and shape necessary to remove damaged area of countertop.

• Locate template over the area to be repaired and clamp or hot melt in place.

• Make an alignment on the template and countertop to ensure proper fit.

• With snap ring in place index plunge router to completely cut through countertop and route along perimeter of template. (FIG. 42B & 42C)

• Apply double stick tape under the repair material and press on to flat work surface.
  □ The tape will secure repair material in place while cutting.

• For color matched repair material use sink or cooktop cutout section.

• Clamp template over repair material. Remove snap ring and index plunge router to cut through the repair material and route along perimeter of template. (FIG. 42D)
  □ Rout slowly to ensure exact cut.
Plug (Pie) Repair

- Make an alignment on the plug and countertop to ensure proper fit.

- Dry fit repair plug to ensure proper fit.

- Clean repair plug and cutout with denatured alcohol.

- Place wood support covered with clear tape underneath cutout to keep adhesive from falling into cabinet base.

- Glue in place with color matched WA8215 seam adhesive. (FIG. 43A)
  - □ 100% coverage is required.
  - □ Squeeze out is required along entire seam.

- Reinforce repair area with required seam support.

- Allow seam adhesive to cure completely.

- Remove adhesive squeeze out with router on “skis,” surface leveler, or random orbital sander.
  - □ Do not scrape, chisel or use belt sander on seam.

- Feather to existing finish. (FIG. 43B)
  - □ Follow recommended finishing procedures located on page 25 in this manual.
Plug (Pie) Repair

Tools required: Plunge router, 1/2" (13mm) cutter, repair template, double stick tape and random orbital sander and disk sander.

- Make a template from 1/4" (6.4mm) material (i.e. hardboard or phenolic) with a hole saw or butterfly circle cutter.

- Locate template over the area to be repaired and clamp in place. (FIG. 44A)

- Using a plunge router, 5/8" (15.9mm) template guide and 1/2" (13mm) cutter, remove the Gibraltar. (FIG. 44B)

- Remove template and place on Gibraltar repair material and pencil exact template shape. (FIG. 44C)
  - For color matched plug or inlay material use sink or cooktop cutout section.

(continued next page)
(continued)

• Rough cut the penciled shape leaving about 1/8" (3.2mm) around perimeter. (FIG. 45A)

• Using a disk sander, slowly size plug to fit cutout. (FIG. 45B)

• Make an alignment mark on the plug and countertop to ensure proper fit. (FIG. 45C)

• Slightly bevel bottom side of plug to allow proper bonding between countertop and plug.
  □ Take care not to touch top edge of plug.

• Clean repair plug and cutout with denatured alcohol.

• Place wood support covered with clear tape under neath cutout to keep adhesive from falling into cabinet base.

• Glue in place with color matched WA8215 seam adhesive. (FIG. 45D)
  □ 100% coverage is required.
  □ Squeeze out is required along entire seam.

• Remove adhesive squeeze out with router on “skis,” surface leveler, or random orbital sander.
  □ Do not scrape, chisel or use belt sander on seam.

• Feather to existing finish.
  □ Follow recommended finishing procedures located on page 25.
## Gibraltar Products Available in Temple

<table>
<thead>
<tr>
<th>Price Point</th>
<th>Design Number</th>
<th>Design Name</th>
<th>30” x 144”</th>
<th>60” x 144”</th>
<th>1/4” Material</th>
<th>Custom Size</th>
<th>Seam Kit Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>D30SL</td>
<td>Almond</td>
<td></td>
<td></td>
<td>•</td>
<td>A127</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>D354SL</td>
<td>Designer White</td>
<td></td>
<td></td>
<td>•</td>
<td>A129</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>D309MG</td>
<td>Fawn Mirage</td>
<td></td>
<td></td>
<td>•</td>
<td>A126</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>D315TM</td>
<td>Platinum Tempest</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A128</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>D426MG</td>
<td>Raven Mirage</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A131</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>D431MG</td>
<td>Alabaster Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A100</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>D50TM</td>
<td>Khaki Brown Tempest</td>
<td></td>
<td></td>
<td></td>
<td>A132</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1530TM</td>
<td>Beige Tempest</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A101</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1531TM</td>
<td>Light Beige Mirage</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A101</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1572SL</td>
<td>Antique White</td>
<td></td>
<td></td>
<td>•</td>
<td>A102</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1573SL</td>
<td>Frosty White</td>
<td></td>
<td></td>
<td>•</td>
<td>A103</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1573MG</td>
<td>Frosty White Mirage</td>
<td>•</td>
<td>•</td>
<td></td>
<td>A103</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9013SP</td>
<td>Amaryllis Solid - Premium</td>
<td></td>
<td></td>
<td>•</td>
<td>A151</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9021MG</td>
<td>Graphite Mirage</td>
<td></td>
<td></td>
<td>•</td>
<td>A108</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9022MG</td>
<td>Atlantis Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A109</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9023ML</td>
<td>Acadia Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A110</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9024ML</td>
<td>French Blue Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A111</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>9026CY</td>
<td>Crystal Blue</td>
<td></td>
<td></td>
<td>•</td>
<td>A134</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9030ML</td>
<td>Baja Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A101</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9031ML</td>
<td>Mojave Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A101</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9032ML</td>
<td>Arabian Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A112</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9033ML</td>
<td>Caramel Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A113</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9040MG</td>
<td>Burnt Amber Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A115</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9041ML</td>
<td>Quarry Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A115</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>9043RS</td>
<td>Bluff Riverstone</td>
<td></td>
<td></td>
<td>•</td>
<td>A132</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>9045RS</td>
<td>Woodland Riverstone</td>
<td></td>
<td></td>
<td>•</td>
<td>A115</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9047ML</td>
<td>Chicory Cream Melange</td>
<td></td>
<td></td>
<td>•</td>
<td>A142</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>9053SN</td>
<td>Sonata Spruce</td>
<td></td>
<td></td>
<td>•</td>
<td>A134</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>9054CY</td>
<td>Crystal Mint</td>
<td></td>
<td></td>
<td>•</td>
<td>A134</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9060ML</td>
<td>Copper Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A116</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9070ML</td>
<td>Arctic Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A112</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9072ML</td>
<td>Aspen Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A103</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9073ML</td>
<td>Calypso Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A120</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9077ST</td>
<td>Milk Glass Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A147</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>9079CR</td>
<td>Pisa Creta</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A148</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9081MG</td>
<td>Seacrest Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A123</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9082ML</td>
<td>Cascades Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A124</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9085MG</td>
<td>Juniper Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A143</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>9087MG</td>
<td>Garden Mirage</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A140</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9090ML</td>
<td>Eureka Melange</td>
<td>•</td>
<td></td>
<td>•</td>
<td>A125</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>9091ML</td>
<td>Midnight Melange</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td>A108</td>
<td></td>
</tr>
</tbody>
</table>

Contact your distributor for products inventoried locally
### Gibraltar Products Available in Temple

<table>
<thead>
<tr>
<th>Price Point</th>
<th>Design Number</th>
<th>Design Name</th>
<th>30” x 144”</th>
<th>60” x 144”</th>
<th>1/4” Material</th>
<th>Custom Size</th>
<th>Seam Kit Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>2</td>
<td>9092MG</td>
<td>Black Onyx Mirage</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A139</td>
</tr>
<tr>
<td>4</td>
<td>9094CR</td>
<td>Murano Creta</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A149</td>
</tr>
<tr>
<td>4</td>
<td>9096RS</td>
<td>Moon Riverstone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A135</td>
</tr>
<tr>
<td>4</td>
<td>9097RS</td>
<td>Whitewater Riverstone</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A136</td>
</tr>
<tr>
<td>3</td>
<td>9098ST</td>
<td>Stardust Spectra</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A139</td>
</tr>
<tr>
<td>2</td>
<td>9130MG</td>
<td>Marzipan Mirage</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A146</td>
</tr>
<tr>
<td>4</td>
<td>9131CR</td>
<td>Venetian Creta</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A101</td>
</tr>
<tr>
<td>4</td>
<td>9132CR</td>
<td>Fresco Creta</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A150</td>
</tr>
<tr>
<td>2</td>
<td>9135MG</td>
<td>Cashmere Mirage</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A141</td>
</tr>
<tr>
<td>4</td>
<td>9136RS</td>
<td>Dry Creek Riverstone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A113</td>
</tr>
<tr>
<td>4</td>
<td>9137RS</td>
<td>Blanco Riverstone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A137</td>
</tr>
<tr>
<td>4</td>
<td>9138RS</td>
<td>San Gabriel Riverstone</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A101</td>
</tr>
<tr>
<td>2</td>
<td>9139MG</td>
<td>White Sands Mirage</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A145</td>
</tr>
<tr>
<td>5</td>
<td>9144SN</td>
<td>Sonata Chocolate</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A134</td>
</tr>
<tr>
<td>5</td>
<td>9145CY</td>
<td>Crystal Champagne</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A132</td>
</tr>
<tr>
<td>3</td>
<td>9170ST</td>
<td>Astral Spectra</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A147</td>
</tr>
<tr>
<td>2</td>
<td>9171MG</td>
<td>Snowy Mirage</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A138</td>
</tr>
<tr>
<td>3</td>
<td>9172ST</td>
<td>Candy Spectra</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A144</td>
</tr>
<tr>
<td>3</td>
<td>9173ST</td>
<td>Sea Salt Spectra</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A147</td>
</tr>
<tr>
<td>5</td>
<td>9191SN</td>
<td>Sonata Expresso</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A134</td>
</tr>
</tbody>
</table>

### Earthstone Products Available in Temple

<table>
<thead>
<tr>
<th>Price Point</th>
<th>Design Number</th>
<th>Design Name</th>
<th>30” x 144”</th>
<th>60” x 144”</th>
<th>1/4” Material</th>
<th>Custom Size</th>
<th>Seam Kit Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>9034EA</td>
<td>Terrazo</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A101</td>
</tr>
<tr>
<td>5</td>
<td>9036EA</td>
<td>Pebble</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A101</td>
</tr>
<tr>
<td>5</td>
<td>9037EA</td>
<td>Sandrift</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A101</td>
</tr>
<tr>
<td>5</td>
<td>9038EA</td>
<td>Flagstone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A101</td>
</tr>
<tr>
<td>5</td>
<td>9042EA</td>
<td>Bedrock</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A115</td>
</tr>
<tr>
<td>5</td>
<td>9048EA</td>
<td>Hearthstone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A120</td>
</tr>
<tr>
<td>5</td>
<td>9074EA</td>
<td>Bluestone</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A124</td>
</tr>
<tr>
<td>5</td>
<td>9075EA</td>
<td>Palomino</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A128</td>
</tr>
<tr>
<td>5</td>
<td>9084EA</td>
<td>Palmetto</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A119</td>
</tr>
<tr>
<td>5</td>
<td>9088EA</td>
<td>Prairie Sage</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A119</td>
</tr>
<tr>
<td>5</td>
<td>9093EA</td>
<td>Mineral</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A112</td>
</tr>
<tr>
<td>5</td>
<td>9099EA</td>
<td>Basalt</td>
<td>•</td>
<td></td>
<td></td>
<td>•</td>
<td>A115</td>
</tr>
<tr>
<td>5</td>
<td>9140EA</td>
<td>Nevada</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A108</td>
</tr>
<tr>
<td>5</td>
<td>9174EA</td>
<td>Durango</td>
<td>•</td>
<td></td>
<td></td>
<td></td>
<td>A153</td>
</tr>
</tbody>
</table>

| Clear Seam Adhesive | A134 |

Contact your distributor for products inventoried locally
# Wilsonart Solid Surface Sinks

<table>
<thead>
<tr>
<th>Vanity Bowls *</th>
<th>Description</th>
<th>Double Bowls</th>
<th>Description</th>
<th>Single Bowls</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>BV120</td>
<td>Lavatory</td>
<td>BD321</td>
<td>Offset Double</td>
<td>BK222</td>
<td>Square</td>
</tr>
<tr>
<td>BV121</td>
<td>Lavatory</td>
<td>BD322</td>
<td>Double</td>
<td>BK323</td>
<td>Rectangle</td>
</tr>
<tr>
<td>BV122</td>
<td>ADA Lavatory</td>
<td>BD323</td>
<td>Double</td>
<td>BK324</td>
<td>Rectangle</td>
</tr>
<tr>
<td>BV123</td>
<td>Lavatory</td>
<td>BD324</td>
<td>Double</td>
<td>BK325</td>
<td>Bar</td>
</tr>
<tr>
<td>BV125</td>
<td></td>
<td>BD421</td>
<td></td>
<td>BK326</td>
<td></td>
</tr>
<tr>
<td>BV129</td>
<td></td>
<td>BD424</td>
<td></td>
<td>BK320</td>
<td></td>
</tr>
<tr>
<td>BV421</td>
<td></td>
<td></td>
<td></td>
<td>BK424</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>BK425</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>RV322</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>SB101**</td>
<td>Display</td>
</tr>
</tbody>
</table>

All bowls are stocked and available in the following colors:
- D354SL
- 1572SL
- D30SL
- 1573SL

** SB101 For display purposes only and available in 1575SL only.

## Custom Information

### 1/2” Custom Size Orders

Check the availability listing to see if the pattern requested can be made into a custom size.

Custom Size orders require full batch quantities per color.

Approximate minimum orders by design are:
- Solids - 1,045 sq. ft.
- Mirage/Tempest/Melange/Riverstone - 1,155 sq.ft.
- Earthstone - 900 sq.ft.

Customer is responsible for full batch yield +/- 10%.

Contact your Distributor for pricing

Custom size orders require a 6 to 8 week lead time.

### 1/2” Custom Color

Custom color orders require a three (3) batch minimum.

Submit your sample request to Temple.

If the pattern can be matched - Wilsonart will send a cell cast sample for approval.

Customer is responsible for full batch yield +/- 10%.

Contact your Distributor for pricing

Custom color orders require a 6 to 8 week lead time after approval of cell cast.

### 1/4” Custom Size Orders

Check the availability listing to see if the pattern requested can be made into a custom size.

Custom Size orders require full batch quantities per color.

Approximate minimum orders by design are:
- Solids - 2,090 sq. ft.
- Mirage/Tempest/Melange/Riverstone - 2,310 sq.ft.

Customer is responsible for full batch yield +/- 10%.

Contact your Distributor for pricing

Custom size orders require a 6 to 8 week lead time.

Contact your distributor for products inventoried locally.