THINSCAPE® Performance Tops Fabrication Highlights



Working with a new surface material often feels like a risk. But when that new material is actually easier to work with than the ones you're used to – when it takes less time and labor to fabricate using familiar tools and methods – the risks disappear. That's THINSCAPE. A surface that's so easy to fabricate, you can complete **three times the number of tops** as other surfaces in the same amount of time.

Less cost. Less labor. More profit.

SAVE ON MATERIAL High-end, nature-inspired designs at entry level cost	SAVE ON FABRICATION Fewer fabrication steps mean fewer hours of labor required	SAVE ON INSTALLATION Durable material makes transportation and handling easier
30% SAVINGS	3X AS FAST	2X AS FAST
 Domestically produced and readily available Lower material cost No dye lots Jumbo slabs up to 5´ x 12´ 	 No surface sanding No edge build down Easy to handle at 3.6 lbs./sq. ft. 	 Stacks flat on pallets Easy to carry tops Easy field adjustments No breakage

Comparing Fabrication Steps

Acquire substrate I Glue panels together I Trim panels I Cut to size I Cut dege strips I Cut edge strips I Glue edge strips I Edge band I Trim edges I Build down edges I Profile edges I Sand edges I Stack horizontally on pallet I Machine unload on A-frames I					
PREPARATION Glue panels together Trim panels Image: Cut to size Cut to size Image: Cut to size Cut holes Image: Cut to size Cut edge strips Image: Cut edge strips Glue edge strips Image: Cut edge strips Glue edge strips Image: Cut edge strips Edge band Image: Cut edge strips Build down edges Image: Cut edge strips Profile edges Image: Cut edge strips Sand edges Image: Cut edge strips Sand top Image: Cut edge strips Transport vertically on pallet Image: Cut edge: Cut e		Acquire substrate			
Trim panels Image: Construction of the second of the s		Glue panels together		•	
FABRICATION Cut holes Image: Cut		Trim panels			
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FABRICATION Glue edge strips Image for the strips Edge band Image for the strips Image for the strips Trim edges Image for the strips Image for the strips Build down edges Image for the strips Image for the strips Profile edges Image for the strips Image for the strips Sand edges Image for the strips Image for the strips Sand top Image for the strips Image for the strips Stack horizontally on pallet Image for the strips Image for the strips Machine unload on A-frames Image for the strips Image for the strips		Cut holes			
FABRICATION Edge band I Trim edges I Image: I		Cut edge strips			
FABRICATION Image:		Glue edge strips			
Trim edges Image: Comparison of the edges Build down edges Image: Comparison of the edges Profile edges Image: Comparison of the edges Sand edges Image: Comparison of the edges Sand top Image: Comparison of the edges Transport vertically Image: Comparison of the edges Stack horizontally on pallet Image: Comparison of the edges Machine unload on A-frames Image: Comparison of the edges		Edge band			
Profile edges Image: Constraint of the second s		Trim edges			
Sand edges Image: Constraint of the second seco		Build down edges			
Sand top Image: Sand top Transport vertically Image: Sand top Stack horizontally on pallet Image: Sand top Machine unload on A-frames Image: Sand top		Profile edges			
Transport vertically Image: Constraint of the second sec		Sand edges			
TRANSPORTATION Stack horizontally on pallet Machine unload on A-frames		Sand top			
TRANSPORTATION Machine unload on A-frames	TRANSPORTATION	Transport vertically			
Machine unload on A-frames		Stack horizontally on pallet	*		
Hand carry with ease		Machine unload on A-frames			
		Hand carry with ease	*		

THINSCAPE

HPL

*At 3.6 lbs./sq. ft., THINSCAPE is easier to handle than other materials.





Quartz or Granite

Solid Surface

THINSCAPE® Fabrication Overview

With a couple of minor adjustments to optimize your tools & settings, you'll find that THINSCAPE is fabricated with less cost and labor than other surfacing materials. Plus, its quality, durability and structural integrity make it easier to handle and less susceptible to breakage during fabrication, shipping, and installation.

For complete details, download the THINSCAPE Fabrication Manual.



Cutting

You can use a vertical panel saw, circular saw or jig saw to rough cut THINSCAPE. The key is choosing the right blade for the density of THINSCAPE:

- triple chip grind
- negative to no hook
- carbide tips



Routing can be done by hand or with a CNC router

CNC Routing

Use the following settings on a dry bed CNC:

- Spindle Speed 14,000 16,000 RPMs
- Feed rate 250-300 in/min

Typically, 2 passes are made with a thin onion skin remaining to keep the vacuum in place. The final cut is with a slow up-spiral finishing bit. Use $3/8^{\circ}$ or $1/2^{\circ}$ shank carbide or diamond bits for strength.

Hand Routing

Use a panel or table saw to rough cut to $1/16^{\circ}$ to $1/4^{\circ}$ oversize. Trim with a 3.25HP plunge type router with a double flute carbide bit. Operate the router at a slower feed rate due to the density of the material.



Seaming

THINSCAPE can be seamed at 45 degrees or with a butt seam. Use a biscuit cutter and #10 or #20 biscuits, and always dry fit panels with biscuits in place. For final seaming, use a two-part epoxy adhesive designed to bond plastics.



Edge Profiling

THINSCAPE can be given a flat, thumbnail, or reverse knife/shark nose profile. Set the profile bit using a straight edge. Limiting the amount of material removed will extend the life of the bit.



Sanding & Finishing

THINSCAPE only requires sanding and finishing on the edges – not the surface. We recommend a 4-step finishing method using a random orbital sander. Start at 100 Micron (120 Grit) and end with Mirka Abralon.

