

## Encore Radius Ends Formation Process

This leaflet is designed as an extension to the “Encore installation instruction” leaflet supplied with all Encore worktops. Please read both leaflets, especially the section “before you start” with respect to colour variance and conditioning before starting work.

### **Essential Installation Tools and Materials**

**Hand Router:** At least 200 watts variable speed.

**Router Cutter, ½”x50mm:** Use high quality double flute tungsten carbide tipped cutters - we recommend Titman H122. The rotational speed of the router must be set to at least 18,000 RPM.

**Guide Bush:** 30mm.

**Edge trimmer/Edge profiling machine:** Such as Makita 3703.

**Edge Trimmer Cutter:** For trimming away overhanging edge strip. We recommend Titman BGT90S.

**Edge Profile Cutter (3mm radius):** We recommend Titman ROCB3.

**Palm sander and sanding sheets:** For the front edge - orbital palm sander at least 500 watts and 2mm sanding stroke, 180,240,320 grits.

**Hand Held Circular Saw/Blades:** Refer to Encore installation instructions. Minimum blade diameter required is 230mm.

### **50ml Encore Colour Coded Seaming Adhesive and Adhesive Applicator**

**Clamps Type ‘G’:** 2 clamps to temporarily secure the radius jig.

**Clamps Type ‘A’ :** Refer to Encore installation instruction. Recommend one at every 70mm or less.

**Encore Radius End Jig:** An encore jig is available and cuts radii 230, 300, 400, 450mm. For others you may need to make your own remembering to allow for guide bush radius.

**Encore Radius End Edging Strip:** 1000x47x1.7mm. Do not use the standard 5mm edge strip.

**Encore Installers Installation Kit:** Contains cleaning, sanding and finishing materials. Including Imanol solid surface cleaner and white lint free wipes. To clean both mating faces of the solid surface.

## Planning/Recommendations:

Encore radius ends can be formed using two different methods:

**Option 1:** Simple overlapping radius edge. This is a much simpler option but take care not to over sand when sanding the radius edge to blend with the front edge. Over sanding will reduce edging thickness possibly making it translucent. On occasion it may be possible to see an adhesive line at the point of overlap.

**Option 2:** The radius edge strip is inlaid into the 5mm factory edge strip. This option requires greater degree of accuracy, both during cutting and hand sanding of the edge strip to match the rebate to ensure an accurate juncture.

With both of the above options we strongly recommend removing the entire factory fitted short edge, replacing it in entirety with the new radius edge strip. Ensure that at least 17mm is removed from the edge during sizing.

### Radius end jig – see Drawing 1:

A jig set is available to cut 230mm – 300mm 400mm and 450mm radii.  
The jig is designed to work with ½” router cutter and 30mm guide bush.

As shown in sketch, the **short front alignment leg** is offset by 8mm for easier front alignment and to facilitate smooth introduction of the router cutter.

To achieve Option 1: the **short front alignment leg** is set flush with the front edge allowing the edging strip to overlap the front edge.

To achieve Option 2: the **short front alignment leg** is set back by approx 1.5mm to allow for the edging strip.

In both cases we recommend you carry out trials first, perhaps practise on an offcut of high pressure laminate worktop.

### General rough sizing:

Refer to the Encore installation instructions when general sizing Encore, paying special attention to the direction of cut. Always cut into the factory fitted edge and never out of it. Please allow for:

- 1.7mm edging strip thickness
- joints or end caps at the opposite end

We recommend you form and finish radius ends in **oversized** worktops, final sizing including joints to be formed after. Do not attempt to apply radius ends after the worktops are fixed. Always work on the bench and complete the work before fixing.

### Option 1: Simple overlapping radius edge:

- Oversize and cut the worktop to the required size. During all cutting/routing operations we recommend the worktop is supported using ample trestles on a base board to provide additional secondary support.
- Work with the factory fitted front edge always facing toward you and the end to be routed to the right, with worktop face up or down depending on the desired handing of radius end.
- Refer to drawing 2. Place the jig in position, square up and align the **short front leg of the jig** with the front edge of the worktop.
- Using x2 ‘G’ Clamps secure the jig in position.
- Set cutter depth to 15mm and position the router on the worktop front edge, plunge and push the router along until you reach the 8mm in offset point. Carefully follow the jig stepping in - you will start cutting at this point.
- Finish the cut, reset the cutter depth twice more in increments of 15mm and complete the cut.
- Remove the jig, thoroughly vacuum clean the routed edge and face of all dust & debris.
- Cut the edging strip to required length using a hacksaw, ensuring the start point at the front edge front overlaps the router cut start point by 2mm and 5mm over lap at the back edge.
- Wash your hands thoroughly to ensure grime does not taint the joint. Using Imanol and a bleached lint free wipe, vigorously clean the solid surface edge and face of the end to be edged.
- Repeat for the scarified back edge of the edging strip.
- Consider repeating for lighter colours to assure absolute cleanliness. Do not touch the cleansed faces again. If by accident you do, repeat the cleaning process.

**NB: At this stage make sure enough 'A' clamps are to hand.**

Assembly:

- Load up the adhesive gun with Encore colour coded adhesive.
- Take a wooden spatula from the installation kit and thoroughly clean it with Imanol and a clean wipe, allowing it to dry.
- Refer to Encore installation instruction section on edging and apply 3 generous beads of adhesive as described.
- Also apply adhesive to the cut solid surface edge of the worktop, then using the clean wooden spatula evenly spread the adhesive so that the complete solid surface edge is covered.
- Apply the edge to the worktop, ensuring the start point at the front edge front overlaps the router cut start point by 2mm.
- Ensure adhesive squeezes out along the entire joining face of the edging strip.
- Temporarily secure the edge in place at the front edge using an 'A' clamp, followed by two more equally spaced around the radius and one at the rear edge.
- Next apply an 'A' clamp directly over the 2mm front edge overlap.
- Apply 'A' clamps at least every 70mm or less around the entire edging strip. Applying plenty of clamps ensures an accurate fit following the cut edge.
- Ensure all the 'A' clamps are tightly clamped in place.
- Allow the adhesive to cure for at least 40minutes at room temperature.
- Trim away the overhanging edge along the face, bottom and rear edge using an electric hand trimmer with a fixed tip guide cutter.
- The front overlap needs to be sanded and blended in carefully. Using 180grit sand paper and just the orbital mode of a random orbital sander carefully sand the bulk away at the edge/worktop join, taking care not to oversand.
- Once the bulk has been sanded away using a palm sander carefully blend taking care not to overly sand into the radius edge strip.
- Next apply a 3mm radius to the top edge using an electric hand trimmer with a 3mm radius cutter. Test that the cutter accurately meets the factory profile on the 5mm front edge.
- Using a palm sander blend in the new 3mm profile and the factory edge.
- Final finishing of the radius end surface is as with a straight edge strip as described in Encore installation instructions.

### **Option 2: The radius edge strip is inlaid into the 5mm factory edge strip**

This option allows the edge to be rebated into the factory fitted front edge. Rebated edge fitting requires a greater degree of accuracy, both during cutting and hand sanding of the edge strip to match the rebate to ensure an accurate juncture.

- Work with the factory fitted front edge always facing toward you and the end to be routered to the right, worktop face up or down depending on the desired handing of radius end.
- **Refer to Drawing 2.** However, the **short front leg of the jig** is set back from the front edge by approximately 1.5mm (or thickness of the edging strip) to allow for the edging strip to locate into the factory front edge rebate.
- Place the jig in position, square up.

**NB : Cutters / guide bushes diameters do tend to vary. Bearing this in mind the jig may need to be reset if desired set back is not achieved.**

- Follow procedures as described in Option 1 to router the radius end. The 1.5mm variance in jig position from Option 1 will produce a 1.5mm rebate in the front edge.
- To prepare the edging strip, start with an oversized edge strip.
- To ensure the edge locates within the rebate the rear face of edging strip will need to be carefully hand sanded to match the routered radius of the routered rebate..

**NB : Due to router tilt the vertical join line can be slightly off square, the edging strip can easily be shaped to suit.**

- Use 180grit sand paper fixed to solid sanding block to hand sand/shape the edging strip.
- Test assemble and adjust until you are satisfied that the final fit is accurate.
- Only now should you cut edging strip to length allowing for 5mm overhang at the back edge.
- Ensure that the rebate and edge radius is vigorously cleaned with Imanol and is kept very clean.
- Now follow the procedures as described in Option 1 (Assembly) except that the edging does not overlap the front edge, but locates within the rebate during assembly to form a neat join.

