

EXTERIOR CLADDING REPAIR

INTRODUCTION

This bulletin addresses the repair of damaged DuPont™ Corian® Solid Surface installations.

OVERVIEW

Occasionally, surfaces may be damaged during fabrication, transport, installation or in use. Most of the time damage can be repaired by the procedures in this bulletin. Always discuss your repair technique with the customer prior to starting the process. Ensure that the customer agrees with your recommendation. This will avoid any issues the customer may have concerning repair over replacement.

A. MINOR REPAIRS

Minor repairs may be required for damage such as:

- deep scratches
- chemical stains
- scorches or burns
- general stains
- minor impact marks

All minor damage should be repaired with a light abrasive cleaner and a 3M™ Clean Sanding Disc - Scotch-Brite™ 7447 (maroon), or fine P-grade paper for heavier damage.

Steps to Completion:

1. Identify the extent of the damage and determine whether a minor repair will rectify the problem.
2. Begin repair by attempting to remove damage with an abrasive cleaner or a Scotch-Brite™ 7447 (maroon) disc.
3. If Step 2 is unsuccessful, it may be necessary to hand-sand with P240 wet or dry paper. Use only air powered tools when wet sanding.
4. If Step 3 is unsuccessful, use heavier-grades of paper. Always make provisions to control dust.
5. If Step 4 is unsuccessful, it may be necessary to consider other repair options.

B. PLUG REPAIRS

Plug repairs are a simple and effective way to replace a small section in a countertop which may have been damaged and cannot be refurbished using a minor repair technique. The plug repair removes a small circular section which is replaced with a color-matched piece of Corian® Solid Surface using similar techniques to an inlay. This piece is then adhered with Corian® Joint Adhesive, DuPont™ Joint Adhesive, or DuPont™ Joint Adhesive 2.0 to form a smooth repair.

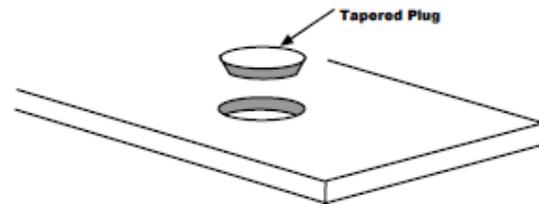


Figure B-1

The Round Plug System

Steps to completion:

System will only work with a plunge router.

For safety purposes, it is best to fasten router to an oversized base plate made of plywood or 1/4" (6 mm) Corian® sheet.

For best results, use a color-matched piece of Corian® sheet to make repair plug.

Steps to completion:

1. Determine which router bit pair is needed to remove the damage.
2. Insert plug cutter bit into plunge router. Set router to plunge to within about 1/32" (0.8 mm) of the entire thickness of a color-matched Corian® sheet. Fasten router onto the backside of the piece. Plunge router slowly until router reaches full depth. Remove router.
3. Remove plug from rest of sheet and carefully sand off the flash around the top of the plug.

The flash around the top of the plug is very sharp and will cut fingers easily. Wear proper gloves.

Clean plug with denatured alcohol¹.

¹Denatured alcohol is the preferred solvent for cleaning Corian® Solid Surface products. Acetone is approved for cleaning in regions where denatured alcohol is prohibited. Please see *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Approved Cleaning Solvents* (K-25701) for more details.

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4. Insert bevel bit into plunge router and set plunge depth to about $\frac{7}{16}$ " (11 mm). Fasten router securely over damaged area. If clamps cannot be utilized, place hot melt glue around the outer perimeter of the router base plate and allow to cool completely. Do not put hot melt glue under the router as this can cause the router to tilt slightly. Plunge router slowly until all damage is removed and router reaches full depth. Do not remove router at this time. Trial fit the plug in the hole. Set router deeper if necessary, and rerout opening until plug sits about $\frac{1}{32}$ " (0.8 mm) above deck. Remove router. Clean hole with denatured alcohol.
5. Seal underside of deck with aluminum tape. Prepare the Corian® Joint Adhesive, DuPont™ Joint Adhesive, or DuPont™ Joint Adhesive 2.0, and apply adhesive into opening and coat edges of plug. Insert plug into opening, press down firmly and secure.
6. After the adhesive cures, use a router on skis or a direct drive random orbital sander to remove excess plug and adhesive. A router on skis is preferable as sanding will tend to remove material from outside the repair area. Do not overheat the repair area through excessive sanding. Complete the repair with standard finishing and polishing techniques as described in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Finishing and Polishing* (K-25298).

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