

### PRE-INSTALLATION CHECKS

Ensure cabinets are fitted correctly and level prior to installing the Evostone work surface.

It is a condition of the Evostone 10 year limited warranty that before any fabrication or installation work is commenced, the Evostone sheet condition is fully inspected for batching, colour matching issues or imperfections.

### INSTALLING EVOSTONE

To secure Evostone, apply liberal dabs of silicone every 150-200mm to the top edges of the cabinets.

We recommend using 'Fuller 770 sanitary silicone' (available from your Evostone Distributor).

Apply the Evostone work surface to the cabinets and press into position.

Provide 1mm per metre expansion clearance at each end to allow for expansion and contraction against walls or panels.

### DESIGN CONSIDERATIONS / OVERHANGS & SPANS

Evostone should be adequately supported.

Spans that exceed 600mm must be supported at the front edge by using the 'Evostone structural aluminium support rail' (available from your Evostone Distributor), the carcass rail on its edge, or other suitable support.

Overhangs larger than 300mm will require additional support by using 'Evostone Stainless Steel Support Brackets' (available from your Evostone Distributor). Alternatively, a substrate material or other suitable support brackets may also be used.

Overhangs smaller than 300mm are less likely to require additional support. This will depend on the ratio of the width to the length of the counter top, climate and is a design consideration that can be determined by a qualified cabinet maker or suitably qualified tradesperson.

### BENCHTOP JOINS

Evostone is supplied pre-finished with an arras to the finished edges.

When joining Evostone cut to length and arras the cut edge to match the finished edges.

Sand joining faces with coarse grit for a better bond.

Using a lamella style biscuit or equivalent will aid in maintaining a more flat and precise join.

Apply 'Evostone Acrylic Adhesive' (available from your Evostone Distributor) to the bottom 2/3<sup>rd</sup> of the thickness just short of the front edge and then apply silicone to the remaining top 1/3<sup>rd</sup> of the join edge and down front edge.

Clamp together and ensure complete seal and clean away any excess silicone.

Allow time for the Evostone acrylic adhesive to fully cure.

30 Minutes in warmer climates and up to 45 minutes in cooler climates.

### WATERFALL END JOIN

To join a waterfall end to the underside of the counter top, simply apply a 1mm arras and sand the edge that is to be joined.

Use a lamella style biscuit or equivalent to hold waterfall end in position flush along the end of benchtop. Apply silicone to both pieces being joined prior to clamping together and ensure complete seal. Clean away excess silicone.

Waterfall Ends are supplied polished both sides, no polishing is required on the inside face.

### MACHINING EVOSTONE

Evostone can be machined by several methods;

CNC Machine - 16mm diameter diamond cutter in a 2-pass process.

We recommend Leitz cutters Z1+1 Tool code 91272 or equivalent (available in right and left hand).

Sliding table Saw - Triple chip tungsten carbide blade with negative rake.

Router with clamped straight edge - Tungsten carbide router bit using progressive passes of 5mm depth.

Circular Track saw - Fine tooth blade suitable for hard reinforced plastics.

Always support the offcut during the machining process.

### PENETRATIONS

Penetrations including sinks & cooktops can also be machined by several methods;

CNC Machine - 16mm diameter diamond cutter in a 2-pass process.

We recommend Leitz cutters Z1+1 Tool code 91272 or equivalent (available in right and left hand).

Router with clamped straight edge - Tungsten carbide router bit using progressive passes of 5mm depth.

Hole Saw & Circular Track saw – Use hole saw for corners then, fine tooth blade suitable for hard reinforced plastics.

Tap holes can also be using a hole saw.

Penetrations require a minimum 10mm radius to the internal corners of the cut out and apply a 2-3 mm arras to the top and bottom edges and ensure all penetrations are free of any jagged edges and sanded smooth.

Always ensure that penetrations including tap cut-outs are at least 75mm away from any joins.

For cooktop penetrations apply the 'Evostone foil tape & felt' (available from your Evostone Distributor) to protect the internal edge and surface from any heat.

#### POLISHING END CUTS

In some circumstances a top will be trimmed to size requiring a polished edge at both ends. This can be achieved by sanding the cut edge.

Sand a matching arras on the edges and work through sanding grits from 120 through to a 500grit soft pad.

#### REFINISHING

Evostone product has the ability to be refinished and even completely repaired. The following outlines general procedures.

Minor marks or scratches can be removed using a Vuplex Solid Surface Cleaner or mild abrasive polish.

For a complete refinish using a random orbital sander requires even sanding of the entire surface. Ensure proper dust extraction equipment is used with the orbital sander and that the surface is wiped clean between each grit level.

Depending on the surface finish starting at 120 grit and followed by 240 grit, 320 and finishing with 500 grit soft pad is recommended. This will finish the surface to a satin finish. A high gloss finish can be achieved by continuing to use finer grits.

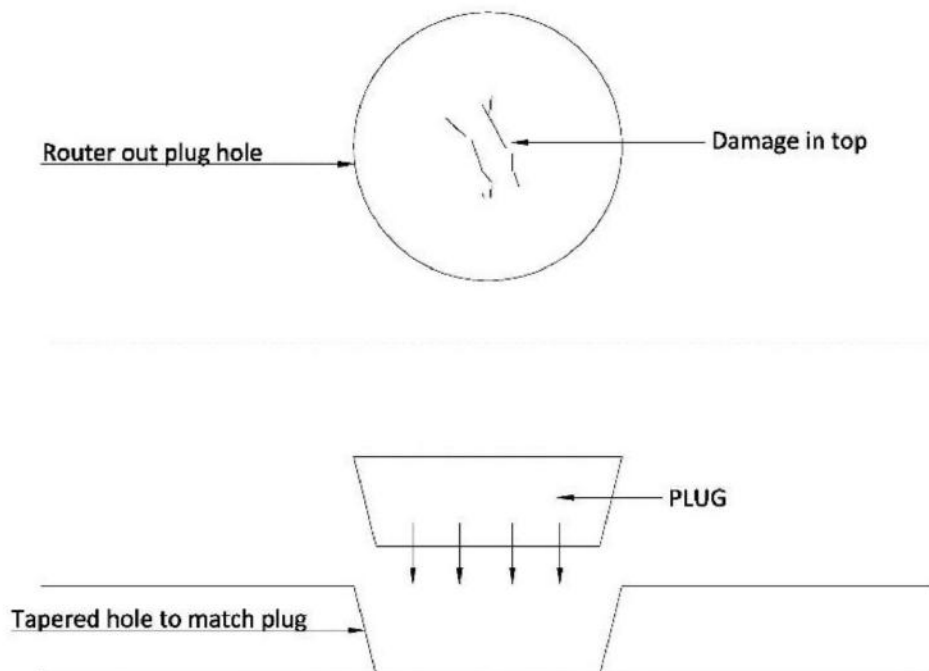
When sanding, alternate the direction and sand in a circular motion overlapping the previous pass

#### REPAIRING

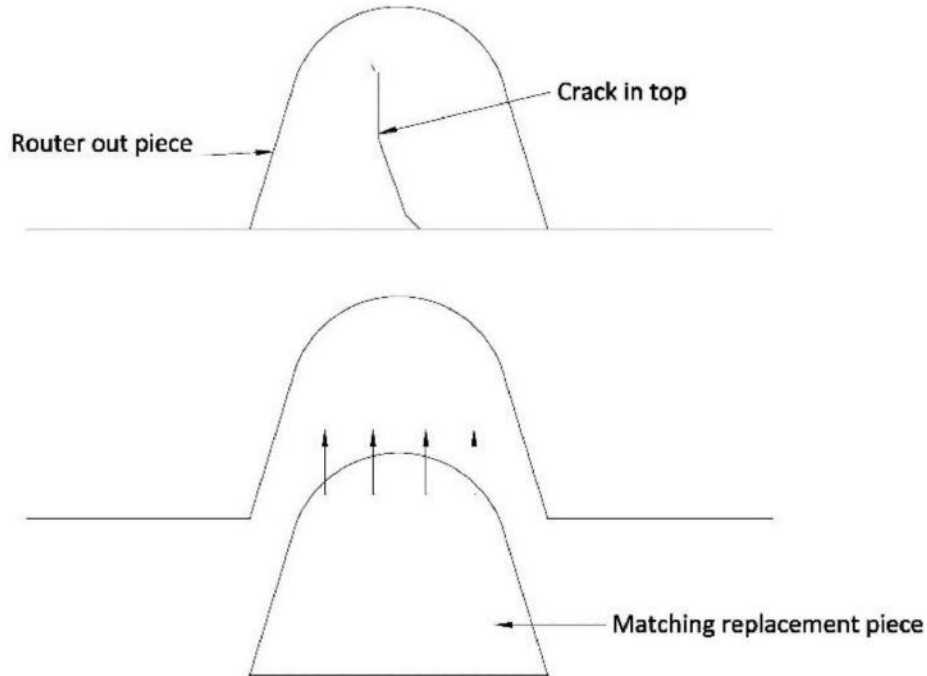
In the event damage has occurred to the surface due improper use or installation cracks and chips can be repaired.

A good practice is to supply cut out to clients so they have matching batch piece to use for repairs.

Small chips can be repaired by making a tapered round plug. Then using a router and jig to router out a matching hole for the plug to fit into. Example below.



For cracks in the edge of tops, machine a curve shape completely removing crack.  
Example below.



Apply repair adhesive and press or clamp replacement piece in place. Allow to cure and refinish top.  
Refer to "REFINISHING"

### SAFETY

A risk assessment should be carried out prior to working with Evostone. All steps must be taken to minimize any risks to health and safety. Dust masks must be worn when working with Evostone and machinery or tools require sufficient dust extraction and good ventilation to the work area.

### TUTORIAL VIDEOS

Please see our tutorial videos at <https://www.youtube.com/channel/UCQpnxD2gDlc02tNu9q3tSeQ>



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