

# FABRICATING DARK COLORS

## INTRODUCTION

This bulletin addresses some additional considerations for fabrication of dark DuPont™ Corian® solid surface colors.

## OVERVIEW

Dark DuPont™ Corian® solid surface colors are fabricated with the same techniques as lighter colors, but as these colors are often fabricated with higher gloss finishes some additional care is warranted during fabrication. Any deviations from a flat surface can be more easily seen at higher gloss finishes.

## A. CUSTOMER EXPECTATIONS

Dark colors are often finished to semi-gloss or gloss finishes. The smoother surfaces create a darker, richer color. Scratches may be more visible, particularly with a gloss finish.

The new DeepColor™ technology platform from DuPont greatly reduces scratch whitening. While DeepColor™ series products still may be scratched, the scratches are much less visible.

Higher gloss levels also make it easier to see flatness variation in the surface, particularly with low angle reflections from light sources such as windows.

## B. CUTTING

Guidance as described in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Cutting and Cutouts* (K-25289) does not change for cutting dark colors. Note that the technology that reduces scratch whitening in the DeepColor™ series also reduces whitening of shavings and saw dust. Thus shavings and dust from cutting operations will be much darker than for other colors.

## C. SEAMING

It is important to minimize sanding of seams and to blend any sanding into the surrounding area. Excessive material removal will make it difficult to create a flat surface with a uniform reflection. Use a router on skis or a block plane set on a low angle to remove excess seam adhesive. Additional information is available in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Seaming* (K-25292).

## D. FINISHING AND POLISHING

It is important to use quality microfinishing disks or P-grade sandpaper. If the size distribution of the abrasive is not well controlled larger abrasive material will leave scratches that will persist through later finishing steps. Follow the procedures in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Finishing and Polishing* (K-25298) to produce a uniform finish. Remember that even with a uniform finish, any flatness variation will be visible with certain lighting. Take care not to remove excess material when sanding seams or by applying uneven pressure while finishing.

As with cutting, the technology that reduces scratch whitening in DeepColor™ products also reduces whitening of sanding dust. Thus dust from finishing DeepColor™ products will be much darker than for other colors.

## E. HOUSEKEEPING

Proper housekeeping is essential both for safety and product quality. Guidance on dust management is provided in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Tools and Accessories* (K-25284) and *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Combustible Dust* (K-26832). Dust or shavings of differing colors can contaminate seams. This is true whether the contamination is dark in a light seam or light in a dark seam. However, as lighter materials tend to be more translucent contamination may be more visible with dark contamination in the seams of light color seams. While dry DeepColor™ shavings and dust are much darker than that for Nocturne, when wet, such as in seam adhesive, they will have a similar color.

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### F. REFERENCED DOCUMENTS

*DuPont™ Corian® Solid Surface Fabrication/Installation  
Fundamentals – Cutting and Cutouts (K-25289)*

*DuPont™ Corian® Solid Surface Fabrication/Installation  
Fundamentals – Seaming (K-25292)*

*DuPont™ Corian® Solid Surface Fabrication/Installation  
Fundamentals – Finishing and Polishing (K-25298)*

*DuPont™ Corian® Solid Surface Fabrication/Installation  
Fundamentals – Tools and Accessories (K-25284)*

*DuPont™ Corian® Solid Surface Fabrication/Installation  
Fundamentals – Combustible Dust (K-26832)*

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