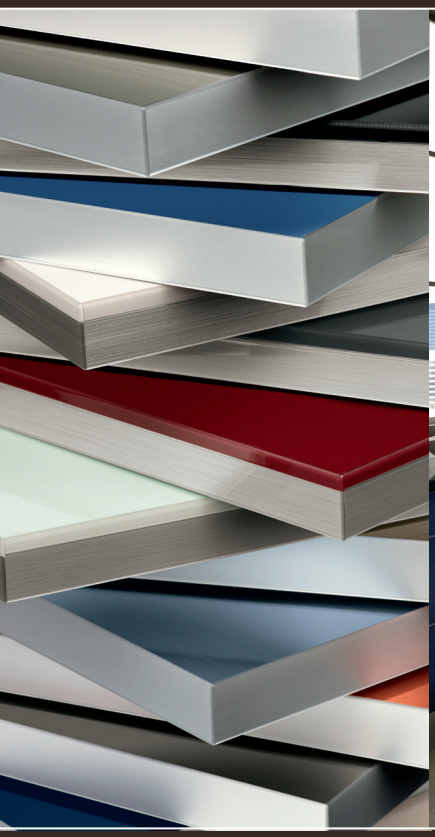
acrylic design guide



KitchenCraft® CABINETRY

2014

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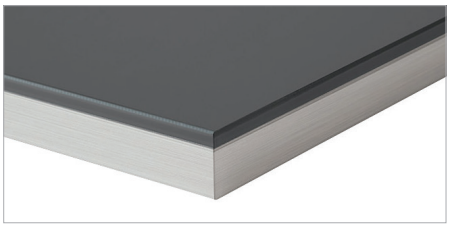
ACRYLIC DETAILS

- Acrylic door and drawer fronts are flat laminated and edgebanded
- Available colors are shown below
- Edgebanding available in 3D aluminum look or two-part layered-brushed aluminum look as noted below
- Backs of doors, drawer fronts and fillers are melamine, in a complementary color as noted on the following page
- ¾" engineered core material

2 PART LAYERED-BRUSHED ALUMINUM EDGE



glacial*

ruby red*

licorice*

glass green*

dark grey*

* solid color

3D ALUMINUM LOOK EDGE

blue*

french cream*

fossil*

metallic bubbly

metallic gibraltar

metallic sapphire

wired bronze

wired cobalt

wired copper

wired mercury

* solid color

- Metallic Acrylics and Wired Colors are directional
- Grain direction will be vertical for both door and drawer fronts

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DOOR FACE AND BACK COLORS

FACE MATERIAL solid color	MELAMINE BACK complementary color
dark grey	storm (grey)
licorice	black
french cream	antique white
ruby red	port
blue	brittany blue
glacial	white
glass green	white
fossil	slate

metallic	complementary color
metallic gilbraltar	slate
metallic sapphire	slate
metallic bubbly	slate

wired	complementary color
wired bronze	slate
wired copper	port
wired cobalt	brittany blue
wired mercury	storm (grey)

Melamine backs of doors, drawer fronts and fillers are a complementary color as noted. They are selected for their relevance to the face color of the item. They are NOT available in any other product types, and are not stocked by Kitchen Craft.

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DESIGN DISCUSSION Clean lines, simple uncomplicated design

AVOID FLOOR TO CEILING INSTALLATION

- For design aesthetics and ease of installation, avoid installation tight to the ceiling
- Use large horizontal doors and drawers
- Use tilt-up doors on upper cabinets, pull-out drawers in base cabinets

NO MOULDING DESIRED OR REQUIRED

- Keep cabinet toplines uncomplicated
- Consider filler use for top trim and use at end of runs for doors to open beyond 90 degrees next to a wall
- Confirm that walls are square and plumb when electing to not use fillers in wall to wall installations
- Cabinet sides will not match the cabinet face unless finished ends are specified
- Cabinet bottoms will not match the cabinet face, and PSV or 5/8" material should be specified

MIX MATERIALS

- Pair acrylic with complementary materials such as woodgrains, melamines, etc. to soften the look

SEGMENT TALL PANELS

- Use top of base cabinet line or bottom of wall cabinets to divide the tall space
- Limit to 96" tall per segment

USE THICK SURFACES TO AVOID END PANELS

- PSV, fillers and end panels are available. Scribe, batten and other decorative mouldings are not available with Acrylic product

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DESIGN DISCUSSION continued

FINISHING COMPONENTS	AVAILABLE OPTIONS
fillers (overlays)	edgebanded with matching acryilc material on all four sides, width = 3" minimum, length = 96" max
light rail	recommend to split a 4" overlay
toe kick	acrylic on 1/4" engineered core
large panels/peninsula backs	standard BP 5/8" panel material with face color matching edge banding

FINISHING COMPONENTS	MATERIALS
finished end options	finished end option for cabinets is also available
PSV	acrylic with pressure sensitive adhesive, available in standard PSV sizes
finished cabinet bottoms	1/4" cut to size panels on engireered core
finished cabinet interior options	available–see Kitchen Craft price book for details
appliance panels	material for Appliance Panels will be 1/4" thick with no edgebanding– see Kitchen Craft price book for details

COMPONENTS NOT AVAILABLE
frame, insert and mullion doors
crown and trim mouldings
external shaped shelves

HOW TO DRILL FOR HARDWARE

- Leave the peel coat on while drilling, and use a sharp bit (no requirement of carbide over steel)
- Do not remove the peel coat until after the hardware is installed and the project is complete
- Avoid over-tightening the hardware as some "ripple" effect may occur on the acrylic surface

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CARE AND CLEANING FOR ACRYLICS

- Do not store panels outside or in direct sunlight
- Avoid sliding the panels on the outer surface
- Clean with a wet micro-fiber cloth or chamois
- Use water or a mild soap and water solution
- Never dry wipe the acrylic finish
- Avoid acetone, harsh household cleaners and abrasives including paper towels, brushes and scouring pads
- A protective peel coat is applied to the acrylic product, this layer is removed after cabinet installation
  Use fingernail to remove, not sharp objects
- Ultra-Gloss Superpolish Kits are available for purchase
  Kit includes: Ultragloss Superpolish and DGS (Durable Gloss Sealant)
- Applying Ultra Gloss Superpolish + DGS on a monthly basis will optimally maintain the acrylic finish
- Do not clean acrylic in direct sunlight

The high gloss surface on acrylic doors becomes more scratch resistant during the first thirty days after the protective film is removed.

We advise to polish the acrylic doors immediately after removing the protective film to accelerate the process for best results.

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INSTALLING ACRYLIC

Acrylic panels can be sawn, drilled or router cut. Be sure to use very sharp carbibe tools amd moderate feed rates. Ensure the masking film (peel coat) is cut cleanly, and adjust the process so that there are no masking strands at the edge. Strands can be removed by lightly rubbing the edge with a medium ScotchBrite® pad.

ROUTERING

Router cutting is the preferred method for cutting acrylic panels and fillers

- Router cut using a feed rate of 10-15 meter/minute with a spindle speed of 20,000 rpm
- Solid carbide router cutters will deliver the best finish
- Position the acrylic panel face down to avoid feathering of the masking film when using a standard straight single or twin flute cutter
- Twin flute compression cutters are ideal. They minimize edge chipping and eliminate feathering on either side of the sheet

SAW CUTTING

- Use very sharp carbide tipped blades with 3-5 teeth per cm
- Best results are achieved using a 300mm blade at a speed of 3200 rpm
- A scribe blade will avoid chipping of the backing layer

DRILLING

- Be sure to drill with high speed steel or carbide tipped drills
- Use slow to medium speeds to avoid overheating the acrylic material
- For best results, use drills with a tip angle of 110 to 130 degrees