

## AFFINITY MAJESTIC COLLECTION

### FABRICATION BULLETIN #14-715

The Affinity Majestic collection contains 100% acrylic solid surface colors that offers unique and natural veining patterns. Attention needs to be paid to material layout and sheet orientation while using specific fabrication techniques to achieve the best results for your project. This bulletin contains tips and suggestions to get you started.

#### Affinity Majestic Collection Characteristics

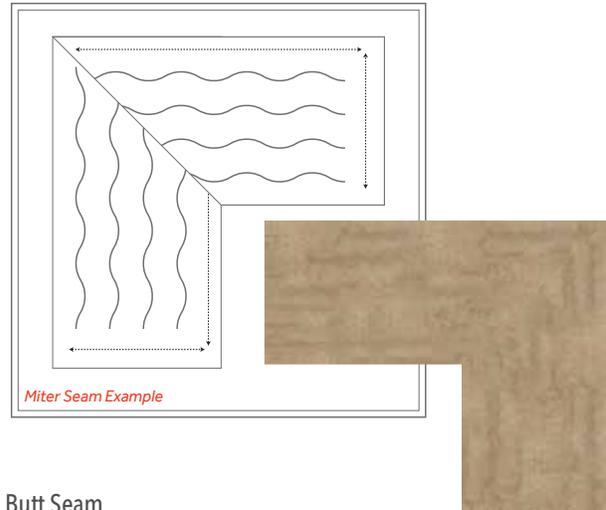
- The veining pattern changes throughout the thickness of the sheet. Cutting into the sheet will reveal a different pattern than on the surface. Use care when fabricating edge profiles, coves, and integrated drain boards.
- The 1/2" edge profile of the sheet will have a different pattern and appearance than the top of the sheet.
- The base color will vary throughout the thickness of the sheet.
- Each sheet contains directional veining with random patterns. Depending on the color the veining will vary from subtle to dramatic which must be considered during both layout and fabrication.
- Do not bid jobs based solely on sheet price and square footage. Additional material may be required to maintain directional orientation to meet client expectations.
- Fabricating with natural veined patterns will often require more solid surface sheets than standard colors. It is the responsibility of the fabricator to properly blend the patterns into a finished piece. Show physical fabricated material samples to the client prior to bidding and fabrication to make sure you can meet expectations for the project. Layout sketches showing the desired veining orientation which are signed and approved by the client prior to fabrication is recommended.

#### Seaming

Affinity Majestic colors contain random veining that does not repeat. There will be a visible break in the pattern at all seams and it is the job of the fabricator to make it as inconspicuous as possible. Seaming generally requires a miter joint to achieve acceptable aesthetics. While some colors with subtle veining patterns may allow the use of the common 90-degree butt seam.

#### Miter Seam

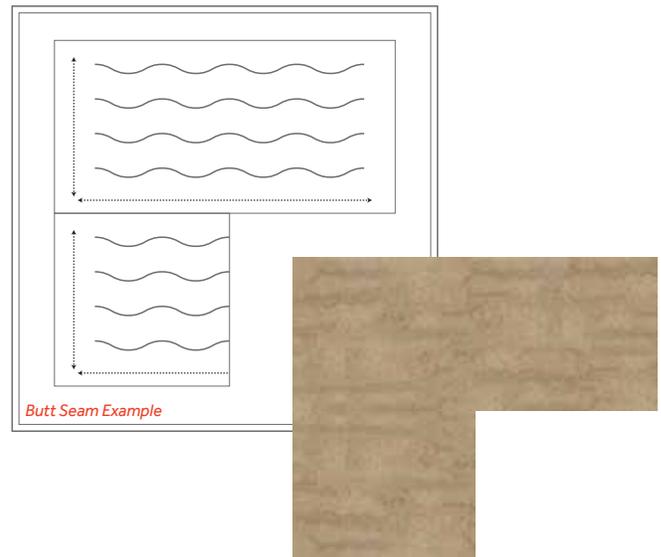
A miter seam allows the directional vein pattern to wrap around an L-shaped turn. Dry fitting the sheets and trimming material as needed to best match and orient the veining pattern is recommended.



Miter Seam Example

#### Butt Seam

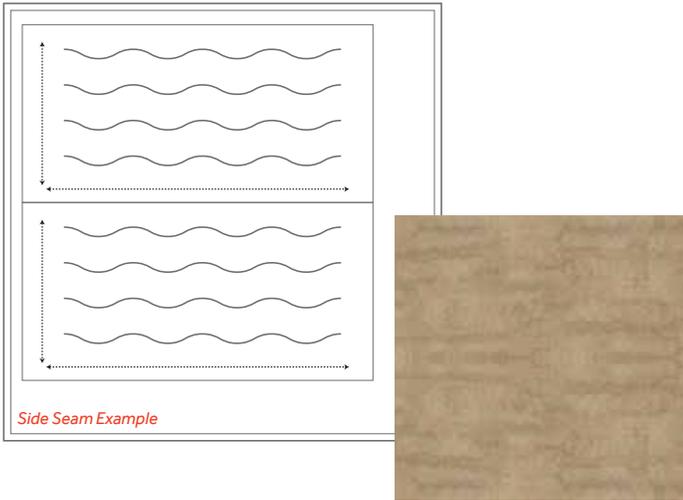
A butt seam is useful for short L-shaped counters by seaming the 30" width of the sheet to maintain a uniform directional pattern. At the seam there will be a break in the pattern which will be more noticeable with dramatic patterns. Additional 30" wide pieces can be seamed to maintain the directional pattern although each butt seam may be visible. Dry fitting the sheets and trimming material as needed to best match and orient the veining pattern is recommended.



Butt Seam Example

### Side Seam

Side seams are useful for islands and other areas where the overall width is greater than a single sheet. Seaming sheets with the same directional pattern will provide a natural appearance. At the seam there will be a break in the pattern which will be more noticeable with dramatic patterns. Dry fitting the sheets and trimming material as needed to best match and orient the veining pattern is recommended.



Side Seam Example

### Butt Seam (90-degree)

The common 90-degree butt seam is generally not desired as the abrupt change in pattern veining direction will be noticeable and not result in a natural appearance.

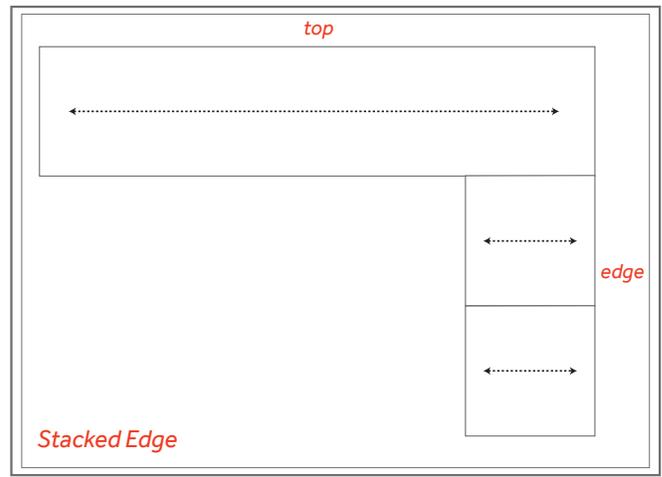


Butt Seam (90-Degree) Example

### Edge Profiles

#### Stacked (sandwich) Edge

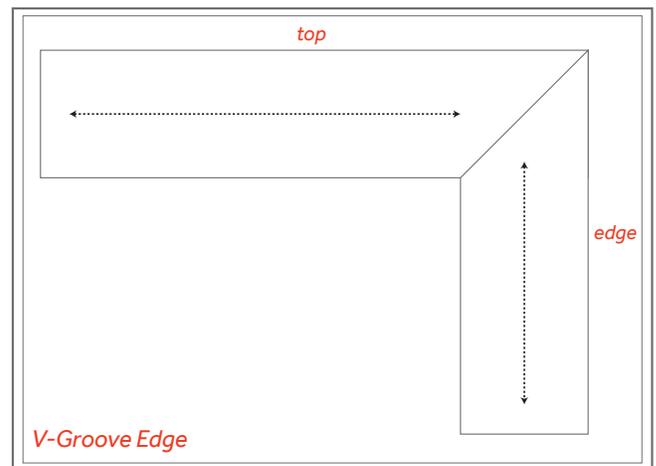
Stacked edges will have a different but generally pleasing aesthetic displaying the full edge profile of the 1/2" strips of material. Dry fitting and using denatured alcohol to check for color appearance prior to seaming the material is recommended. All stacked pieces should have the same orientation as the top deck. This is often the most flexible and practical edge for fabrication and design. A 1/2" or larger round-over with the gradual transition from surface to profile edge will provide a more natural appearance.



Stacked Edge

#### V-Groove Edge

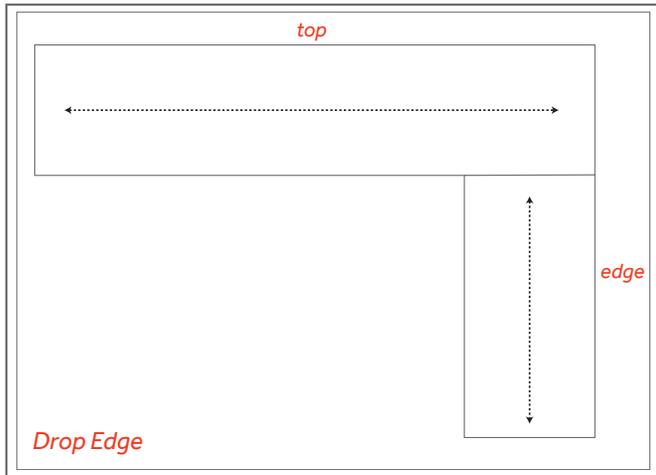
If a uniform edge profile is required, a v-grooved edge will have the most natural appearance. For tight corners and zero radius bends v-grooving is recommended. V-grooved edges allow the veining pattern to wrap or fold from the horizontal surface to the vertical surface. To avoid revealing a different subsurface pattern use the smallest possible radius edge profile.



V-Groove Edge

### Drop Edge

A drop edge is the least desirable edge design since it will show a distinctly different pattern over the full 1/2" edge of the top sheet compared to the horizontal surface of the drop edge strip. A drop edge is only useful for the most subtle veined patterns and should be dry fitted and inspected prior to seaming.



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### Thermoforming

Thermoforming can be useful for large radius corners. Affinity Majestic colors thermoform better at cooler temperatures (300-320 F°) and may require a larger minimum radius.

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### Coving

Coving is generally useful only with subtle veining patterns. More dramatic veining patterns will increase the chance of visible pattern transitions and this can vary from sheet to sheet. A v-groove cove has the most acceptable aesthetics since the backsplash, cove, and deck will have the same orientation. It is important to use physical samples and set client expectations prior to starting a project.

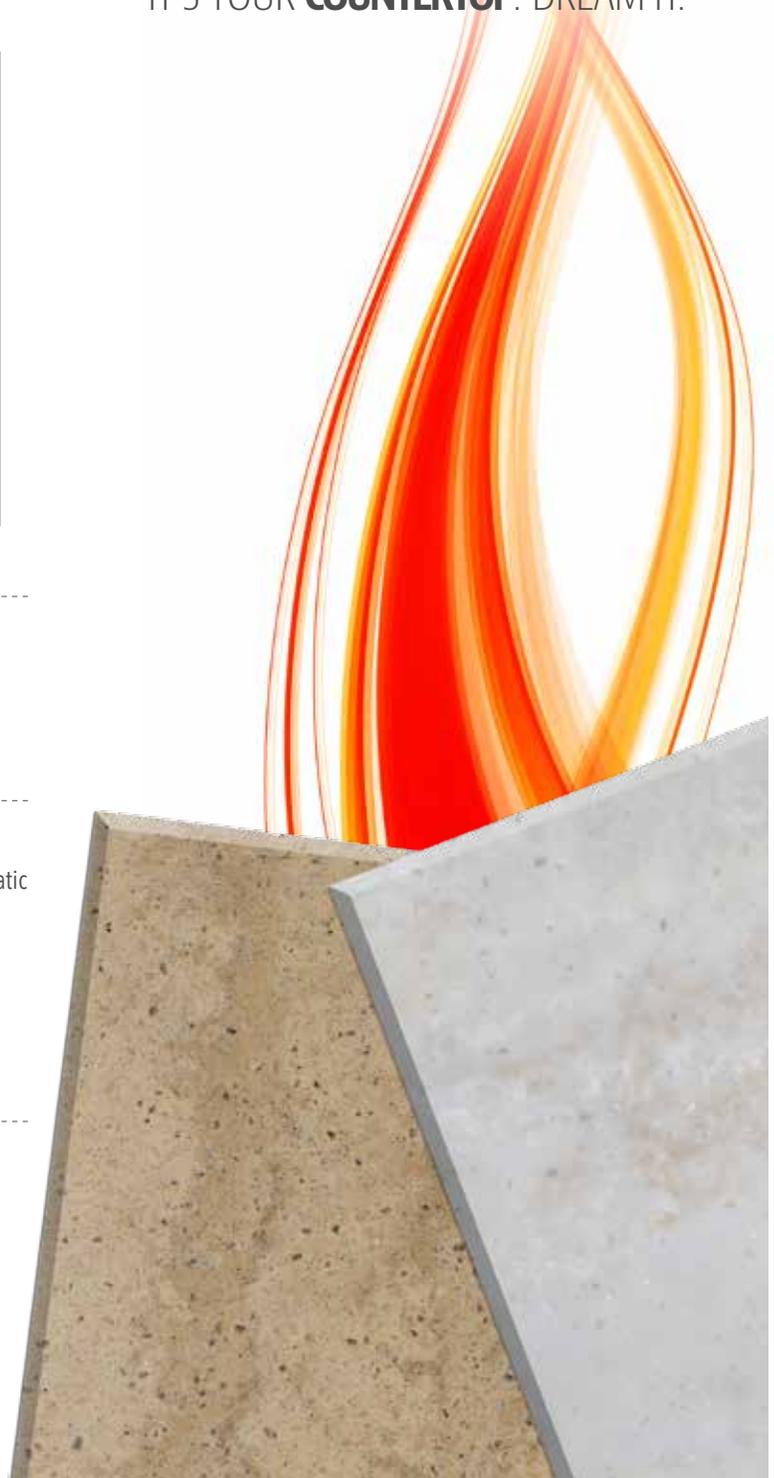
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### Sanding

All standard solid surface sanding techniques are suitable for Affinity Majestic colors. During sanding it is possible that certain areas of the sheet may sand faster or slower. Greater care should be taken to achieve the desired results. Hard backup pads are recommended when sanding to reduce this effect. It may be necessary to use a finer final grit sanding paper for the Affinity Majestic colors. A higher finish may be needed on darker colors however the client should be aware of and sign off on the care and maintenance requirements for the final finish level.

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