

# SUBERRA

## **Fabrication Guide**

### **Cutting**

Suberra ultra high density cork slabs cut and machine easily with standard woodworking saw blades, router bits and shapers. Most carbide tipped saw blades including ATB combination and fine tooth blades perform well and cut with minimal tear out. Because of its high density, Suberra can be mitered and machine's well with most types of decorative profile tooling.

### **Seams**

**\*IMPORTANT** - Trim outer edges

Make a clean – square cut on all edges to be seamed. The cork slabs are typically less dense on the edges due to the manufacturing process. You may need to cut between 1/4' to 3/8" off of each edge to reveal the high density material consistent within the rest of slab.

### **Check alignment and fit**

Butt the slabs together and check the gap between the two slabs. The fit should be tight, revealing only a hairline where the 2 pieces meet.

Biscuits, splines and other woodworking techniques may be used to align the pieces and can aid in keeping the pieces from slipping during glue up..

### **Glue Up**

Once aligned, apply standard woodworking adhesives to the edges of both slabs. Most PVA, Polyurethane and Epoxy adhesives are acceptable.

Fit the slabs together and apply even pressure with standard woodworking clamps. Do not over tighten when clamping. You should apply enough pressure to see a bit of glue squeeze out evenly along the seam. Reference the instructions on the adhesive to determine clamping and cure times.

Note: Depending on which adhesive is used, after the panels have been clamped you may want to wipe off the squeeze out with a clean damp rag.

### **Sanding**

Suberra is pre-sanded with 120 grit paper. We recommend sanding first with 150 grit and finishing with 180 grit with a random orbital sander. Studies have shown that going beyond 180 grit has minimal effect on the surface texture. With a high level of workmanship, the seam should be barely visible, similar to a traditional wood glue joint.

### **Support**

Cabinets with front and back stretchers or full tops will be sufficient in supporting Suberra surfaces. When spanning more than 12" it is necessary to block out with plywood or other rigid material.

Suberra laminates well to standard substrate materials such as particle board or MDF using PVA and polyurethane glues. Adequate clamping pressure is required for good adhesion.

### **Table Top Application:**

Laminating plywood materials to the underside of Suberra will aid in keeping the tops rigid as well as improve screw holding power when fixing table bases.

### **Fastening:**

In applications when strong mechanical fastening is required, Suberra should be laminated to a plywood substrate to improve screw holding tolerances.

For light duty fastening Suberra will accept a coarse thread woodworking screw. Over tightening may cause the screw to strip.

Other fastening such as H bolt connectors, threaded inserts etc should be tested by the fabricator to determine performance.

### **Finishing**

Applying a finish coat will add performance to Suberra's natural stain and moisture resistance. A finish coat will also enhance the color and keep it even as the top ages.

Suberra can be coated with most oil, urethane, lacquer, varnish and epoxy finishes. Cork can be stained, however, a "hard coating" such as polyurethane or lacquer would need to be applied over the stain to prevent the stain from wearing off.

Our recommended finish for commercial applications is 3 coats of Waterlox Original Finish (Satin). Using a fine bristle brush, clean rag or a microfiber roller, apply a thin coat of Waterlox to the surface. Allow to dry for approximately 24hrs between coats. Buff back with maroon grade scotchbrite between coats. This coating is zero VOC and food safe when cured.

Also, for a zero VOC hand applied finish we recommend Wood Countertop Finish by Bioshield. [www.bioshield.com](http://www.bioshield.com) or any off the shelf mineral or butcher block oil.

### **Maintenance**

Suberra Ultra high density cork surface can be refinished multiple times. Depending on the applied finish, the top can be scuffed with scotch brite and recoated, or taken through a re-sanding and finishing process. The look and density of Suberra is even throughout the entire thickness of the slab, therefore multiple re-sanding and re-finishing processes will not have an adverse effect to the look and feel of the surface.

If a gouge is taken out of the top, it is possible to fill the void using crumbled up cork grain and wood glue for repair. Contact eco supply for more information

For further technical information in regards to fabrication or maintenance, please call Eco Supply at 1-800-883-7005.

