ConfiAd

Seaming guide of quartz surface

After cutting the pieces to be seamed and subsequent preparation of the cutting edges, you are recommended to apply the following procedures and methods.

I. Cutting:

A. Preparation

1. Equilibrate the slabstocks to the shop temperature prior to their fabrication thereby minimizing a thermal effect on the dimensions.
2. Use a proper cutting tool having a sharp blade.
3. Use a template and a router in cutting curved edges as well as in cutting out shapes.
4. Smooth all cut-edges by grinding.
5. Allow a 1/8 inch (3mm) gap for thermal shrinkage for every 10 ft (3 m) width when the surface is to fit to a wall.

B. Straight cutting

1. Use a diamond-tipped circular saw in wet cutting a large quantity of slabs.
2. Employ a proper cutting speed that suits best for the thickness of the slab and the performance of the saw. For example, recommend a cutting speed of 10 ft (3 m)per minute in cutting a 0.8 inch(20mm)-thick slab with a 7.5-HP 10 inch(30cm)-diameter saw.
3. Use a hand-held power saw (or router) with the aid of a cutting jig in cutting a small quantity and job-site cutting.

C. Curvilinear cutting

1. Use a router for all curvilinear cuttings (CNC : Computer Numerical Control)
2. Use a router having a double-edged blade and a cutting jig to achieve smooth cut surfaces with minimum blemishes.

D. Cutting out shapes

1. Use a router and a template in cutting out a sink bowl pattern (CNC)
2. Round the edges to a radius of 3/16 inch (5mm) or greater in order to eliminate possible sites for stress crack initiation.

II. Surface preparation:

1. Equilibrate the fabricated parts to the temperature of the operation room in order to stabilize their dimensions.
2. Ensure that the adhesive has a matching color with the slabstock and it is still within the suggested use date.
3. Ensure the adhesion surfaces aligned perpendicular to the top and bottom surfaces of the slab.
4. Polish the adhesion surfaces. Rough surfaces often result in a visible seam with a thin white line in the case of dark-color surfaces.
5. Wipe out the adhesion surfaces with an alcohol-wetted white cloth in one direction. This way, you will not contaminate the area you just wiped.
6. Do not use lacquer thinner or a strong solvent.
7. Ensure that the adhesion surfaces are fit and the slab surfaces are level. If necessary, level the slab surfaces by adjusting the legs of the support table.
8. Apply an aluminum masking tape to the lower surfaces of the adhesion joint or to the table surface beneath the joint so that the applied adhesive can be contained.
9. Set apart the adhesion surfaces to an approximately 1/8 inch (3mm) gap.
10. Make available in advance the clamps to use for pulling the adhesion surfaces together. (Suction cups, parallign clamping system, wood block)

III. Gluing with a 50ml / 75ml / 250ml / 485ml ConfiAd Cartridge

1. Before placing the mixing tip on the adhesive cartridge, make sure to purge a small amount of seam adhesive out, to ensure both Component A and B are dispensing properly. Place the mixing tip and tighten with retaining nut and once again purge the trigger twice to make sure you have good mixing at the tip.
2. Inject the adhesive into the gap to half of its depth by applying a steady pressure on the trigger starting from the further end of the joint. Avoid intermittent triggering lest the adhesive stream traps air.
3. Pull the two parts together so that the seam can be narrower than 10mil(250 ㎛)by an adequate clamping force, and maintain the force until the adhesive is completely cured. Front edge : 3~5mil(80~120 ㎛), 45 degree sliced edge : 4~10mil(100~250 ㎛) (80~160mil / 2~4mm edge cutting)
4. Inspect whether some excess adhesive is squeezed out all along the gap, which would indicate a proper application of the adhesive. If a polishing step is to follow, leave the pushed-out adhesive untouched until a complete cure. If a polishing step is not to follow, scrape out the excess after building up 2 to 3 layers of tape on each side of the seam 1/16inch(1.6mm) from the joint. This will act as a dam & wiping guide, allowing the seam to be overfilled
5. Do not try to accelerate curing by heating it with a hot air gun or the like. Heating could cause blemishes. The curing time is approximately 30 minutes at 72°F(22℃).
6. Give a finger-nail test to check the state of curing.

IV. Grinding and Finishing

* Fabrication *

1. Use successively finer mesh diamond pad as follows in grinding and polishing: #50→#100→#200→#400→#800→#1500→#3000→#8000
2. Do not skip grinding with an intermediate mesh pads.
   Otherwise, an unsatisfactory surface with traces of coarse grinding results.
3. Apply a sufficient amount of water during grinding and polishing. Otherwise, the friction heat could
   cause discoloration.

* Installation *

1. Scrape out the excess after curing the adhesives.
2. Shine using a cut polish compound and rag.

V. Maintenance of Engineered Stones

Cleaning ease is one of the advantages with engineered stones. Maintain the stones as follows in order to preserve the lasting beauty, cleanness and gloss.

1. Wipe out light stains with a wet cloth or sponge.
2. Use a dishwashing detergent soaked in a nylon sponge to clean tough stains such as tobacco stains, magic ink and rouge.
3. Repair small chips using a diamond pad. Start sanding with a #400~#800 sandpaper for repair of a
   shallow chip, while starting with a #50~#100 diamond pad for repair of a deep chip.
   Finish both repairs by polishing with a #3000~#8000 diamond pad.

● General idea of Quartz Surfaces features