

CORIAN® ENDURA™ QUALITY AND INSPECTION

Introduction

This fabrication bulletin discusses the product quality inspection of Corian® Endura high performance porcelain.

Overview

Visual inspection for defects or color match is essential when working with Corian® Endura™ high performance porcelain and is standard good trade practice.

The following simplified product specifications are given to you as a reference tool.

Do not work with product that will result in a defect being incorporated in the final design. DuPont will replace any Corian® Endura™ high performance porcelain not conforming to product specifications when delivered. However, DuPont will not pay for labor costs for any fabrication done on defective material.

Call your Authorized Distributor of Corian® Endura™ high performance porcelain for assistance whenever you are unsure of raw material quality. Be prepared to give the manufacturer's batch number.

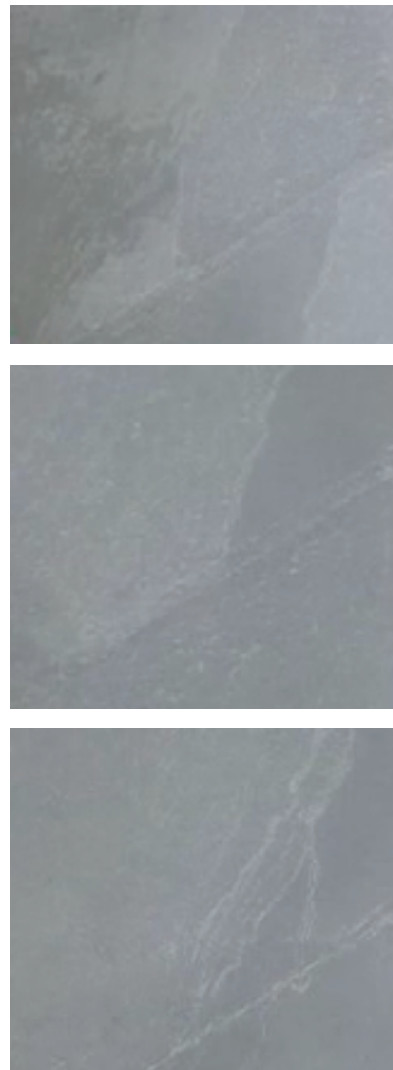
A. Corian® Endura™ Slab Inspection

Check every single slab before fabrication. Observation should be made at a distance of 60 cm (24"), perpendicular to the surface and in natural light.

B. Color Match

Variability in processing can lead to slight variations in pattern development during slab firing. For optimum color match, particularly for slabs used adjacently, use slabs from the same batch number. Three examples of the variation are shown below.

Figure B-1: Examples of Tone Variation



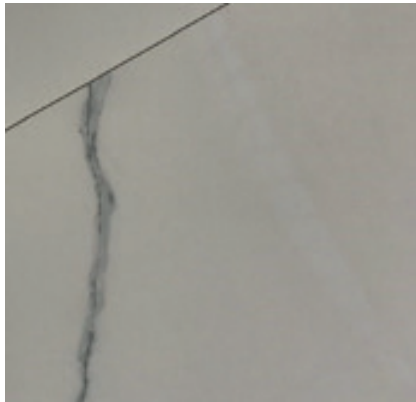
For optimum color match the last three characters (shown in red below) of the Batch Code should match. The batch code is an alphanumeric code of the format AA#AA##A##.

C. Color Inconsistency within Slab

Except for solid colors, Corian® Endura™ high performance porcelain slabs have complex aesthetics that range from subtle to bold. This includes variation of the shade of the background. Other than book match aesthetics the patterns will not align at seams and a visual break in the pattern is expected. Book match aesthetics do have patterns that lend to continuity at seams, but slight shifts in the pattern can be expected and are not considered defects.

Pattern defects such as the light stripe running from the top center to the bottom right shown in the photo below should be rejected.

Figure C-1: Example of Pattern Defect



D. Gloss Level

The gloss level specification (measured at 60°) is:

Glossy	> 65	Variation within slab < 10
Matte	< 10	Variation within slab < 5
Mineral	< 15	Variation within slab < 5

E. Length and Width

Corian® Endura™ high performance porcelain slabs are 163 x 324 cm (64 x 128") and sold in a non-rectified format that require trimming prior to use. The guaranteed size after trimming is 160 x 320 cm (63" x 126"). The fabricator is responsible for ensuring the slab is trimmed to the edge of the pattern where applicable.

F. Thickness

Corian® Endura™ is sold in three thicknesses, 6-, 12- and 20-mm. The 6-mm and 12-mm slabs have a fiberglass mesh on the back that brings the total thickness to 6.7 mm and 12.7 mm.

Acceptable ranges

6 mm	6.4 - 7.0 mm
12 mm	12.1 - 13.3 mm
20 mm	19.0 - 21.0 mm

The Mineral finish has a more pronounced texture, 0.84 mm is the difference between the lower minimum and the higher maximum thickness of the texture.

G. Flatness

The flatness of the slab must be checked on a perfectly horizontal and stable surface as a surface that is not flat will give erroneous results. A milled granite slab is often used for this purpose.

Using an aluminum straight-edge to check for deviations in flatness across the length and the width. The maximum deviation from flat is ± 2 mm over the entire slab.

H. Contamination

Corian® Endura™ high performance porcelain stone slabs are obtained by processing natural raw materials. Small imperfections are considered to be acceptable with the following limitations:

Contamination (black or other color spots or foreign particles) that are not part of the graphic:

- No spots allowed bigger than 1 mm (0.04") diameter.
- In 10 x 10 cm square (4 x 4") maximum 6 spots allowed.
- A maximum of 10 spots allowed per slab.

I. Defects

I.1. EDGE STRIPES

Stripes in the edges of the slab are not acceptable.

Figure I-1: Defect in Edge of Slab



I.2. POLISHING DEFECTS

Polishing marks or polishing irregularities such as gloss non-uniformity, streaks or blotches are not allowed.

I.3. CHIPS, VOIDS AND PITS

No chips or voids/pits are allowed within the thickness of the slab.

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