



SPECTRUM QUARTZ

Fabrication Guidelines





Spectrum Quartz Fabrication Guidelines

- The fabricator must complete a visual inspection for defects before manufacturing and use their judgment to proceed.
- The fabricator must check the color match on sheets to be used on the same job before fabrication.
- Cut to size, shape and polish Spectrum Quartz with the appropriate diamond tooling.
- Join lamination seams with 2-part polyester, epoxy, or acrylic adhesives due to their strength and relative UV stability. Please refer to both the Integra and Glue Boss Adhesives' website and find the "Spectrum" matched colors.

- Inside Corner Radius Criteria:

One section (e.g., L, U, etc.) shaped pieces to minimum of 1/2 inch to reduce corner stresses.	Multiple section (e.g., two piece L and 3 piece U) shaped pieces with seams in the corners (i.e., full 45° miter or mason's miter) do not need to have a radius in the corner.
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- Break all top and bottom edges of straight edge profiles to a **min. of 1/16-inch (1.5 mm) radius** or chamfer.
- Radius all outside corners of straight edge profiles to a **minimum of 1/8-inch (3 mm) radius**.

Cut out Requirements

- Radius corners are recommended on **all cutouts - minimum 1/4" (6mm)**.
- Cutouts in backsplashes (e.g., electrical outlets) that extend past the cutout perimeter **must be filled with 2-part epoxy adhesive** and a **flexible adhesive** must be used around the **entire cutout to secure** the backsplash to the wall.
- Leave at least **1/8-inch clearance space** on all sides to allow cook tops/sink expansion.
- Support cutouts on **all sides within 3 inches (7.6 cm)** of the edge of the cutout.
- Support undermount sinks with brackets.
- Stainless steel and lavatory undermount sinks **must be attached with clips** attached to the underside of the countertop or with cradles attached to the outer perimeter or cabinet.

- All others sink types **must be supported with cradles** attached to the outer perimeter or cabinet.

Installation - General Requirements:

- Spectrum Quartz is not recommended for exterior applications. Spectrum Quartz excludes from warranty coverage any exterior applications.
- The tops of the cabinets must be flat and in the same plane within 1/8-inch of a flat surface over a 120-inch (3 m) length.
- A minimum 1/16-inch gap is recommended between the “Products” and a wall.
- Seal and secure the front top edge of the cabinet to the underside of the Spectrum Quartz top with a 1/16 to 1/8-inch diameter bead of flexible adhesive around the perimeter.
- Use only flexible adhesive to adhere the Spectrum Quartz to wood, steel, ceramic, tile, etc. Do not rigidly adhere the Spectrum Quartz to other materials.
- Apply backsplashes (maximum 6”strips) of Spectrum Quartz to the surface using flexible adhesive.
- Never install mechanical fasteners directly into Spectrum Quartz. Inserts may be used with Spectrum Quartz. If inserts are used, slip fit and glue inserts are required rather than pressure fit inserts.
- Do not install the Spectrum Quartz over old countertops.

Spectrum Quartz Installation Support Requirements:

- For structures with support on **4 sides and depths:**

<26 (66 Cm) inches	Outer perimeter support is sufficient (maximum length is 120”)
>26 Inches (66 cm)	Additional front to back support is required every 36” (90 cm) in addition to the outer perimeter support.

- For structures with support on **3 sides** (e.g., dishwashers, and frameless cabinets) the following is **required:**

2 Cm thick slabs <26inches (66 cm) deep	Additional support is required at widths > 24”
3 Cm thick slabs and<26” (66 cm) deep	Additional support is required at widths > 36”
2 & 3 Cm thick slabs & >26” (66 cm) deep	Additional support is required at widths > 24”

- For the Spectrum Quartz at **2cm thickness**, provide additional support for cabinet overhangs exceeding **10 inches (30 cm)** as follows:

Overhangs 10-18 inches (30-45 cm)	Use solid substrate and corbels evenly spaced at no greater than 36 inch (90 cm) intervals
Overhangs >18 inches (>45 cm)	Use solid substrate along with a leg or column(s)

- For the Spectrum Quartz at **3cm thickness**, provide additional support for cabinet overhangs **>12inches (30 cm)** as follows:

Overhangs 10 inches	Use corbels evenly spaced at no greater than 36 inch intervals
Overhangs >12 inches	Use a leg or column(s)

- Half wall (AKA: knee wall, pony wall) overhang support requirements for **both 2 cm and 3 cm slabs**:

Overhangs <1/3 the depth of the top. [i.e., support wall is 4" (10 cm), total top is 6" (15cm), overhang 2" (5 cm)]	No additional support required. (Figure 1)
For all other half wall overhangs	Corbels are required to support the overhang where the bracket depth is 3/4 of the overhang depth and spacing is a maximum of 36 inches. Corbels should be placed at wall studs.

Please note: Particle Board is **NOT** considered an acceptable support material by Spectrum Quartz. Spectrum Quartz recommends and approves use of: **MDF, quality plywood, hardwood, or structural steel.**

Installation Seam Requirements

- All deck seams must be filled with **premium quality color matched adhesive.**
- Field seams must be filled through **the entire seam thickness.**
- At a minimum field seams must be supported on both sides of the seam in the front and back. In addition, **any seams that extend into an overhang should be supported.** Wherever possible, seam support on both sides of the seam is recommended.
 - Recommended **seam width** is **< 1/16-inch** (1.5mm)
 - Recommended **height mismatch** is **< 1/64-inch** (0.4mm)



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