

**corian.**
**Fabrication of Stone Collection colors**
***Stone Collection colours:***


4 new colours of the 2008 offering (Clam Shell, Sonora, Lava Rock and Aztec Gold) belong to the Stone colour family. This new family consists of exciting new patterns that will allow you to offer completely new aesthetics to your customers.

These colours present random veins, colour shades and particles. Due to this random effect, it is unlikely to have a continuous flow of the pattern when 2 sheets or 2 pieces from the same sheet are seamed together. The change of the pattern and colour shades will show up at the seam area.

We advise you to inform your customers about this fact during the sales process. 100x100mm samples are too small to fully represent the random pattern of these colours. A full size display, which clearly shows the pattern, is the recommended way to demonstrate to the end consumer the actual look of Stone colours.

This technical bulletin contains several design ideas and recommendations on new layout and assembly techniques to obtain the best results. Nevertheless, it is the responsibility of the Fabricator to blend the patterning into the assembly in order to meet end consumer expectations.

## **1. Countertop Seams**

Because the Stone Collection has random directional patterns, countertop seams may require more than a typical butt seam (90° seam) to be acceptable to the consumer. You may find that some colours may have acceptable results with a 90° seam, other might require a mitre seam (45° seam).

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*Examples of standard 90° seams:*

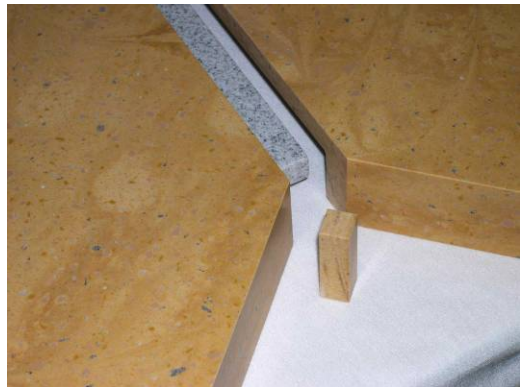


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When using a mitre seam, use the insert block method to get the proper inside corner radius. Please remember that reinforcement is also needed, as described in the Fabrication Manual. Be sure that the joint between the reinforcement strip and the corner block is completely filled with adhesive.

*Examples of mitre seam*


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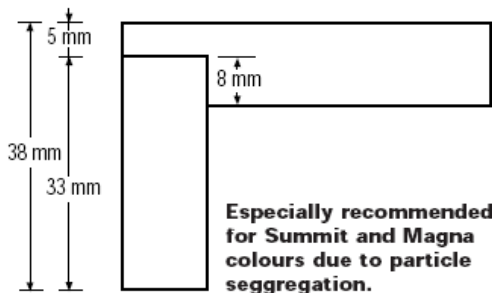
### 2. Edge details

**Stone Collection** has a mix of random particles and veins which runs throughout the sheet. A standard drop or stacked edge may or may not have the expected aesthetic results.



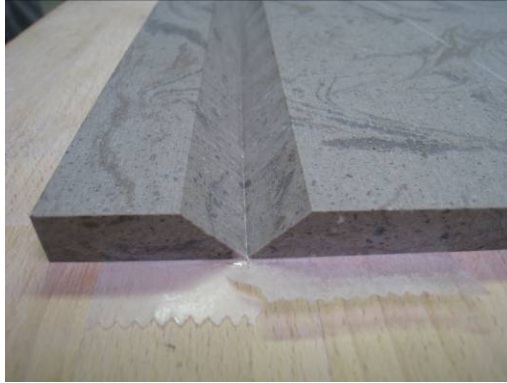
#### Recommendation:

Rebated and V-grooved edges are recommended in order to allow the flow and continuity of the veins.



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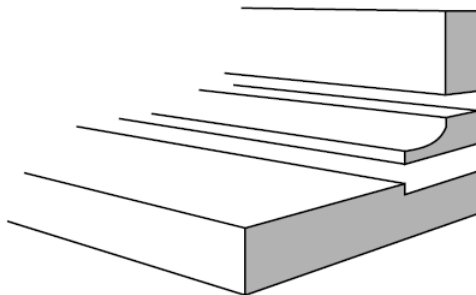
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### 3. Backsplashes

For **butt backsplashes**, follow the standard procedures described in the Corian® Fabrication Manual. Pay attention to the direction of the veins and patterns when cutting the strips, and fit them on the countertop following the original direction. This will help you to have a natural flow of the pattern. V-grooving is also a good alternative.

**Coved backsplashes** on the Stone colour family, because of its random effects, tend to make the pieces more visible, not resulting in a monolithic look.

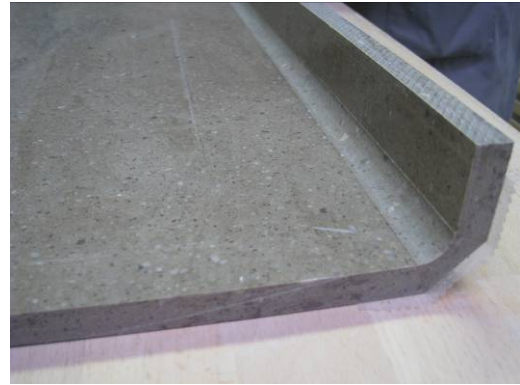
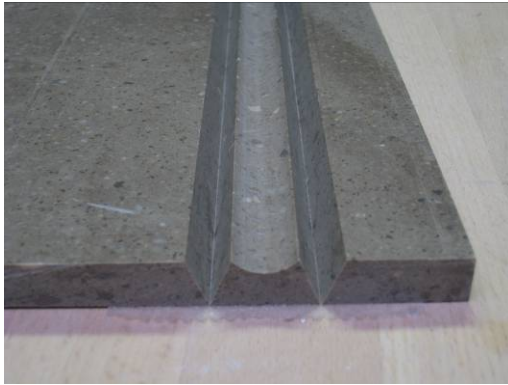


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Results obtained with V-grooved backsplashes are the same.



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#### ***4. Thermoforming***

**Stone** colours show a similar performance to the Magna series when thermoforming: in order to avoid whitening and micro-cracks due to the size of the particles, radii will have to be bigger than normal. For more details, please refer to the Corian® Fabrication Manual, chapter 17.

By thermoforming at lower temperatures than usual there will be less whitening and also less particles popping-up or separating. Best results are achieved at a temperature of **140°C**

#### ***5. Finishing and sanding***

All typical finishing methods are suitable to use on Corian® **Stone** colours. For more information, please refer to the Corian® Fabrication Manual, chapter 19.

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