



GUIDE

FABRICATION

INSTALLATION

MAINTENANCE



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introduction



CURAVA quartz slabs are made of polyester resin and quartz, with quartz being the main ingredient by weight.

CURAVA slabs can be cut, polished and polished much the same way as your standard quartz surfaces on the market.

** This fabrication guide is not intended for beginner fabricators*

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disclaimer

This fabrication manual is intended for CURAVA certified and/or experienced fabricators of the marble/granite/engineered stone industry.

Any variation in color, quartz distribution, thickness, surface finish, etc. between the samples or printed material and the actual slabs is an inherent property of Curava surfaces due to the factory process to produce these slabs. Curava will not accept any responsibility for this variation. For general tolerances please refer to the Marble Institute of America (MIA), www.marble-institute.com, guidelines available online or on literature.

Curava will not accept any returns on installed material claims involving any variation mentioned above. All slabs are to be inspected upon receipt and Curava is to be notified immediately of any breakage, damage, or inconsistent color between slabs. Slabs that are cut or altered from their original state are deemed accepted and are not refundable or subject for return.

It is the responsibility of the fabricator and/or distributor to make sure that this disclaimer is clearly explained to the customer, along with the tolerances and acceptable variations.

Samples provided by Curava are only intended to provide the fabricator, distributor, and customer with the general color pattern of slabs. They do not serve any other purpose.

It is the responsibility of the fabricator, distributor, or customer to make sure that adequate quantity slabs of a particular color are available prior to beginning a job with Curava slabs.



inspection

Curava slabs need to be inspected by the fabricator prior to cutting. While our process strives to ensure color uniformity for each color, the exact particulate dispersion and concentration may vary within a slab and between slabs. The fabricator, distributor, or customer needs to perform the inspection prior to altering the slab in any way.

Upon receiving the slabs, the fabricator/distributor/customer must carefully inspect the slabs for any irregularity and must notify Curava right away in the event of any irregularity.

It is the responsibility of the fabricator, distributor, or customer to ensure that the slabs match for projects requiring multiple slabs. .

Once the slab is altered from its original state (including altering the surface finish), Curava will consider the slabs to be accepted and will not accept any claim for return or refund. We will not accept any claims for installed finished product.

Slab Thickness - Both 2 cm nominal (3/4") and 3 cm nominal



handling and storage

- One of the most important activities related to working with CURAVA products is the handling of the slabs and the finished product.
- Clamp lifters may be used to lift and move CURAVA slabs around. The clamps should be specifically made for lifting stone/quartz slabs and should have white rubber padding in order to avoid any black marks from the tight grip. Always make sure that the clamp is positioned in the center of the slab to avoid any unbalanced movement of the slab upon lifting.
- Vacuum lifting equipment may only be used to move around finished product, and not entire slabs.
- Always store slabs vertically on A-frames or slab racks that are suitable for slabs. Make sure that the vertical beams of the A-frames are on the same plane. It is important to make sure that the bottom of the slabs completely touch the bottom of the slabs behind along the entire length. The same for the top of the slabs. This is to ensure that the entire plane of the slab is resting on the plane of the slab behind. If any adjustments need to be made to ensure this, you can use the clamp to re-position the slab or you can use a wooden board to gently move the corners of the slabs to each other.
- Always store slabs indoors. Store in a manner so that the polished face is not exposed to sunlight.
- Transport finished product on heavy duty single or double-sided transport racks with rubber padding on bottom pads and uprights. Secure with rubber padded steel uprights that are latched to top of rack. Groves Incorporated (www.groves.com) is an acceptable manufacturer of racks.



templating & layout

- Templating for Curava surfaces is similar to templating for marble, granite, or engineered stone. Either electronic templating or plastic templating is acceptable.
- Layout of the countertop is extremely important. The final customer needs to approve the layout of the countertop/vanity top prior to commencing any work on the slab(s). The location of the seams needs to be approved by the final customer as well.
- Please follow our guidelines in the **Rodding and Reinforcing** page for layouts that require reinforcing. Curava will not accept any claims for breakage or damage to the material if the instructions on the **Rodding and Reinforcing** page are not followed.
- Before installing the countertop, make sure you dry fit the top in the shop to make sure everything fits correctly. **This is a crucial procedure to make sure there are no surprises at the installation site.**



cutting



- For best results use granite or quartz cutting blades.
- Always use a bridge saw to cut the slabs into the countertop dimensions. Ensure that all cutting equipment is in good, safe working condition.
- You can cut the slabs in one pass.
- When cutting by hand with a hand grinder, always use diamond blades for granite or quartz. Always make sure you wear proper personal protection equipment (safety glasses, proper respiratory mask, gloves, etc.), as detailed on the Safety page. If you wet cut, ALWAYS make sure that you use GFCI protected equipment and equipment that is completely waterproof and specifically designed for wet cutting.
- Please follow the cutting guidelines as per the Marble Institute of America manual (MIA).



drilling routing

- Faucet hole drilling can be performed the same way as with quartz and granite material.
- Using wet diamond core bits, apply constant moderate pressure to obtain a smooth hole all the way through the slab. Ensure that the CURAVA piece being drilled or cored is supported on an even flat surface to minimize blowout.
- In rare cases where no blowout is accepted on the unfinished surface of the slab, the hole must be cored halfway through the polished surface and the other half needs to be cored out from the bottom surface
- Profiling edges with a router or cnc machine is done the same way as with natural stone, granite, or quartz. The only recommendation is to use bits with continuous diamond bits to keep any chipping at a minimum. All edges that are finished on natural stone and granite (ogee, rounded, bullnose, etc.) can be also finished on Curava.



rodding/reinforcing/overhangs

- Overhangs - 2 cm thick material with an overhang of up to 8" does not need any supporting brackets. An overhang greater than 8" will need supporting brackets installed at 24" intervals. 3 cm thick material with an overhang of up to 12" does not require any supporting brackets. An overhang greater than 12" will need supporting brackets at 24" intervals. Any overhang greater than 16" (both 2 cm and 3 cm material) will need supporting legs at 24" intervals.
- Front to back supports within the cabinet should be every 24". All countertop joints must be supported.
- L-shaped layouts or any layout with small protruding elements where the width of the material is less than 4" are not acceptable, even with reinforcement (see sketch below).



- Never affix mechanical fasteners directly onto Curava.
- Sinks - It is mandatory to support in front and behind all sink cutouts if the distance from sink cutout edge to finished edge is less than 4". Undermount sinks may be installed in the same way as with granite, or engineered stone. Use silicone to adhere the sink edge to the back of the cut material, along with clips to secure the sink to the threaded anchor embedded into the material.



corners/cutouts

- All corners must be rounded to a minimum 3/8" radius in order to avoid stress points. Sharp inside corners can lead to hairline cracks which will not be covered by the warranty. This applies to sink and cooktop cut-outs as well as L-shaped counters in one piece.

A coring bit needs to be used when preparing a cut-out. If the area drilled by the coring bit is damaged by a blade, stress points could be created that may eventually lead to a hairline crack originating from the corner of the cut-out. All cutting needs to be done using wet diamond cutting tools.

A minimum of 3mm (1/8") gap is required between cut-out and cooktop cut-outs and the cooktop in order to allow for thermal expansion and contraction.



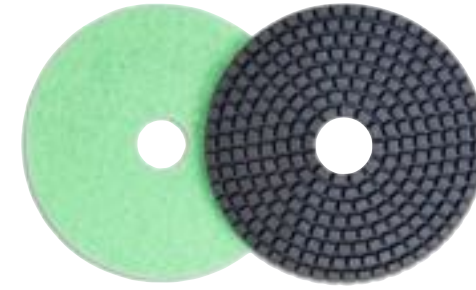
seams

installation

- Seams are a very important element of the finished product. Please use the MIA (Marble Institute of America) as a guideline for seaming tolerances for countertops.
- It is important to have the final customer approve the location and layout of the seams prior to cutting the slab(s).
- The tiny gap of the seam needs to be filled with a clear epoxy or polyester resin and may be colored to match the color of the adjoining material. The edges of the seam need to be covered with tape to prevent any excess resin from spilling over to the actual countertop. If any spilling occurs, make sure to remove the excess resin with a sharp edge or razor blade while it is still curing.
- Prior to installation, make sure that the cabinets are installed correctly and that they are level and on a true plane. Any countertop installed on cabinets that are not on a true plane may break.
- Allow about 1/8" (3 mm) gap between the edge of the countertop and the wall to make sure there is adequate space for any movement by the countertop over time.



edge polishing



- CURAVA edges are polished the same way as granite or quartz edges, using diamond pads and water. DO NOT apply wax to CURAVA, as this will dull the glass and reduce the quality of the polish.
- The recommended polishing sequence is the following, by grit: 50, 100, 200, 400, 800, 1500, 3000, buffing pad. Always wet polish. Do not dry polish.



patching

- In the event of chipping occurring when cutting CURAVA slabs, you can patch the voids with either clear epoxy glue, clear polyester mastic, or preferably Plexus UV Stone Repair Kit. Knife Grade Polyester mastic is an easy patching material if the voids are small because it can be spread easily and because it is the easiest to color match with the CURAVA slab color. For best results, Plexus UV Stone Repair Kit can be used, as the patching will be transparent.
- If an epoxy or polyester mastic is used as patching, use only resins that are neutral or clear in color and that can be colored. You have a choice of coloring the resin to match the color of glass in the material or to leave the resin clear. It is up to the fabricator's discretion to decide which patching material will give an acceptable visual result. Apply the selected resin with a spatula until the void is filled completely. Shave off any excess resin with a razor blade after it is cured.
- If you are patching an edge with epoxy or polyester resin, bring the edge polish to an 800 grit. Apply the desired resin compound (clear or colored, at fabricator's discretion) with a spatula or razor blade until the void is completely filled. Once the resin has cured, continue the polishing process with the higher grits (1,500, 2000, 3000) until the desired polish is reached. This only applies to edge finishes, not surface finishes. Surface finish must not be altered by hand polishing in any way.

Note: Always test the patching options on a scrap piece to determine which one will work best visually. It is up to the fabricator's discretion to determine which method will work best on a particular job.



sealing

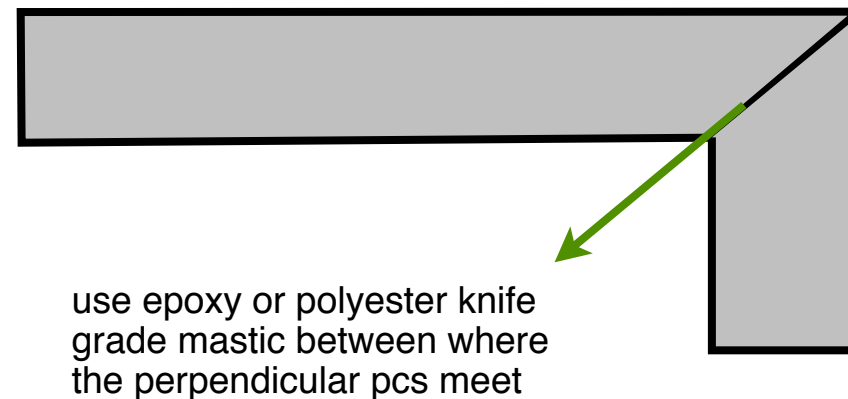
- CURAVA resin based slabs require no sealing and no waxing.



laminating and mitre cuts

- Please ensure that the pattern configuration on the surface of Curava is the same as the cross section (edge in this case). It is entirely at the fabricator's discretion to provide a laminated finish and to ensure that the customer approves the visual result.
- Mitre cuts may be diagonally reinforced with stainless steel pins after being epoxied to the adjacent piece. The same procedure as with natural stone or granite may be used. Please follow the MIA (Marble Institute of America) guidelines. Once again, it is entirely at the fabricator's discretion whether or not to provide a mitered finish and to ensure the customer approves the visual result.

Note: Always test lamination or mitre cut results on a scrap piece to determine the result.



heat sources in kitchen areas

- CURAVA surfaces are not recommended for areas directly above or below heat sources. Our material is heat resistant, not heat proof! Make sure that in the unlikely event that Curava is installed above hot items, there is adequate insulation between Curava and the heated item. The insulation must be fire proof and must not be flammable.
- Do not install Curava in areas with large, rapid temperature fluctuations (alternating chilled/hot conditions in short intervals). As with all natural stone and engineered stone, extreme rapid temperature changes are not recommended.
- Avoid direct contact between Curava and hot pots. Please use hot pads or insulators between hot pots and Curava.



basic maintenance

- CURAVA resin based surfaces are easy to maintain, with just a little care. The surfaces do not need to be sealed or waxed.
- You can clean the surface with common non-abrasive household cleaners, such as SoftScrub® Liquid Gel. Make sure you rinse the surface with clean water after having used a cleaner. Make sure you clean off oils and resins from the surface timely and thoroughly. Avoid aggressive cleaning products with pH greater than 8, and avoid nonabrasive cleaners and solvents or strong chemicals such as paint removers or paint strippers. Some of our colors use sea shells, mainly composed of calcium carbonate. Prolonged exposure to acidic liquids and cleaners may cause the shells to feel slightly rougher to the touch.
- If any of these liquids spill on the countertop, make sure to wipe them off using a paper towel, sponge, or damp cloth. Use water and regular soap or mild detergent.
- In the unlikely event that you have a stain on the surface, you can either call your fabricator, or attempt to remove the stain using water with a mild soap or detergent.
- These are basic guidelines for maintaining your Curava surface. A complete guideline is available online at www.curava.com.



safety

Please make sure you follow all applicable OSHA, local, state, and federal regulations regarding personal protection and workplace safety when working with Curava. All fabricators and workers involved in the handling, storing, fabrication, installation, and maintenance of all Curava products are required to comply with all OSHA regulations, along with applicable local, state, and federal laws and regulations regarding safety.

Some of the most relevant safety issues are:

- personal protection equipment (safety eyewear, dust inhalation protection, gloves, etc.). Please use at all times when cutting or polishing Curava. Please refer to OSHA 29 CFR 1910.134 for approved respiratory protection.
- adequate and lawful disposal of waste
- use of safe and adequate working equipment (grinders, bridge saws, blades).
- safety precautions when handling the material using heavy machinery (cranes, forklifts, etc.)
- use of safe and adequate handling equipment (cranes, slings, clamps, etc.).



tolerances

Slab Thickness Variation - Both 2 cm nominal (3/4") and 3 cm nominal (1.25") have +/- thickness variation tolerance of 1.5 mm.

Surface Divots/Fissures Tolerance - Curava surfaces may have some very small divots on the surface. this is an inherent characteristic of the manufacturing process and is not considered a defect. Divots that are less than or equal to 1/32" deep and less than or equal to 1/16" wide are deemed acceptable. The tolerance for any divots/fissures larger than that is approximately 10 spots per every 45 square feet of material.

Gloss Tolerance - Curava surfaces are manufactured to have a minimum gloss factor of 50%.

Note

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contact

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