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Durasein
Inspection



Durasein

Fabrication and Installation Inspection

BULLETIN NO.
Inspection_0525

TECH INFO
Inspection

Introduction

Durasein® Fabricator Product Quality Inspection Requirements

Please note that Durasein will replace any Durasein® Solid Surface material not conforming to product specifications when delivered to your facility.

Durasein prides itself in having state-of-the-art systems to ensure the products we deliver meet the highest standards in the industry. However, non-conforming products may slip through our system and reach our downstream customers. Should this happen, we encourage our customers to work with us and incorporate a stringent inspection protocol in your organization to ensure the non-conforming product does not go all the way through to a final installation. Please inspect all product before final delivery or any fabrication processes. If you catch this material, contact your Durasein representative for replacement. If non-conforming material is fabricated and installed, Durasein will not be held responsible for any labor costs.

1. Sheet Inspection – Listed below are different items you should look for when you make a visual inspection of Durasein® sheets:

- Sheet to Sheet Color Match
- Color Inconsistency Within Sheet
- Particles Pattern Irregularity
- Length Warp
- Warp: Smiles / Frowns

- Black or White Spots
- Face-side Pinholes / Voids / Ripples
- Underside Pinholes / Voids / Ripples
- Edge Cracks / Chips

2. Color Match – Durasein will produce the best color match possible from our state-of-the-art technology. However, sometimes the composition of the solid surface produces slight color variations between production cycles due to the blending of the product. This is an inherent characteristic of Durasein® Solid Surface aesthetics. Therefore, strict guidelines have been set as follows:

Durasein® does not guarantee color match. Since color match cannot always be guaranteed, it is up to the fabricator to inspect and ensure acceptable color match between sheets.

Color match can be checked in three ways:

- Using sheets from the same pallet.
- Making sure the code or run-number on the sheet edges is within the specified range of ± 25 numbers of each other.
- Conducting a trial color match.

For warranty claim purposes, we expect the fabricators to record the run numbers of each sheet of material used on each job. This may be useful in trying to achieve color match in the future.

If color match is found to be unsatisfactory after fabrication, yet run numbers are within range, contact your Durasein® representative immediately.



Durasein

Fabrication and Installation Inspection

BULLETIN NO.
Inspection_0525

TECH INFO
Inspection

3. Color Inconsistency Within Sheet – Inspect sheets for any color inconsistency. If blotches, hue variations or other inconsistencies are apparent and cannot be worked out, please contact your Durasein® representative for a replacement.
4. Particle Pattern Irregularity – If any irregular distribution of particles is visible to the naked eye, set aside sheet for inspection and contact your Durasein® representative for a replacement. In some cases, variances in particle distribution can appear as a color mismatch.
5. Length Warp – Where warp is greater than 1/16" per 48" (1.5 mm per 1220 mm), set aside sheet for inspection and contact your Durasein® representative for a replacement.
6. Warp: Positive/Negative – Where warp is concave to the finished face side, it is classified as positive warp. If warp is concave to the backside, it is classified as negative warp. For sheet with positive or negative warp greater than 1/16" per 48" (1.5 mm per 1220 mm), set aside sheet for inspection and contact your Durasein® representative for a replacement.
7. Face-side Black and/or White Spots – Where large groups of spots occur that are not considered part of the material aesthetic and detract from the visual appearance of the solid color sheet, set aside sheet for inspection and contact your Durasein® representative for a replacement.

Allowable Surface Defects:

Black Spots

Less than 0.01" (0.25 mm)

White Spots

Less than 0.008" (0.20 mm)

Foreign Matter Particles

Less than 0.01" (0.25 mm)

8. Face-side Pinholes, Voids and/or Ripples –

When minor scratches, pinholes, voids or ripples occur on the face-side of the sheet, orbital sanding with 180-grit sandpaper might resolve the problem.

Allowable Surface Defects:

Voids Not to exceed

1 ≥ 0.25 mm per sheet or 5 ≥ 0.10 mm per sheet

9. Underside Pinholes, Voids and/or Ripples – Small voids or pinholes on the back of a sheet are generally not a problem unless they interfere with joining pieces for edge build-up. Set aside any questionable sheet for inspection and contact your Durasein® representative for a decision regarding replacement.



Durasein

Fabrication and Installation Inspection

BULLETIN NO.
Inspection_0525

TECH INFO
Inspection

Acceptable Pinholes, Depressions and Ripples:

Pinholes & Depressions Not to exceed
 $1 \geq 0.25$ mm per sheet or $5 \geq 0.10$ mm per sheet

Ripples & Bumps less than 1/6" (1.5 mm) deep

If serious irregularities occur, set aside sheet for inspection and contact your Durasein® representative for a replacement.

10. Edge Cracks and/or Chips – Cracks or chips can occur during transportation and handling. Inspect shipments and report damages to the delivery carrier as necessary.

Acceptable Chips / or Nicks:

Corner Chips
Less than 3/16" (4.76 mm) wide/deep

Edge Chips / Nicks
Less than 3/16" (4.76 mm) wide/deep

If serious irregularities occur, set aside the sheet for inspection and contact your Durasein® representative for a replacement decision.

11. Shape Product Inspection – Listed below are different items you should look for when you make a visual inspection of Durasein® sinks:

- Broken
- Cracks
- Black / White Spots
- Physical Non-uniformities
- Face-side Pinholes / Voids
- Drain Holes

Always inspect before fabricating
Trial fit the seam areas for flatness
Record the sheet numbers used on each job



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Fabrication and Installation Inspection

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Inspection_0525

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