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Durasein
Seams



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Fabrication and Installation Seams

BULLETIN NO.
Seams_0525

TECH INFO
Seams

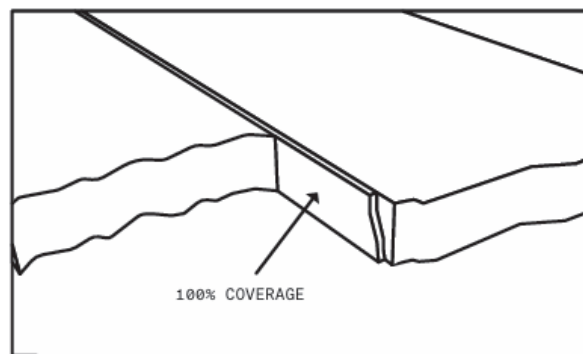
Seams are an essential element for solid surfacing. The monolithic look achieved by a well-done seam is a key selling feature and one of the factors that customers look for in a quality installation.

Factors contributing to a professional seam in solid surfacing include:

- Always use the correct color matched adhesive. Consult Durasein's color match recommendations for the best results.
- The best results for preparing the faces to be seamed include a router and accurate straight edges or a mirror-cut procedure. There are some saw blades that can make "seam-quality smooth" cuts, however, these are dependent on the condition of the blade and the type of saw being used to make the cut. The best saw blade is one that is Triple Chip Tooth and a 10 degree rake having a minimum 6 teeth per inch. The router option is still the best to ensure a smooth cut. It is the fabricator's responsibility to be sure that the seam faces are completely flat and chip free before seaming.
- Keep things clean. Clean the faces to be seamed thoroughly with denatured alcohol. Denatured alcohol is the preferred solvent for cleaning Durasein® Solid Surface products and where denatured alcohol may not be used, acetone is recommended. Be sure dirt, debris, ink, marker or pencil marks are removed. This includes the sheet batch and sequence numbers printed on the

sheet. Even marks on the bottom can show up as dark areas in the seam if they are not thoroughly removed before the seam adhesive is applied.

- Apply the seam adhesive thoroughly and properly. 100% coverage is important.



Clamp the seam properly. There are many clamping systems on the market today that will produce quality results. One factor to consider is that over-clamping can reduce the amount of material in the seam and consequently reduce the strength of the seam.

- Align the sheets accurately for a deck seam. Using a vacuum clamping system can help to align the sheets from the top, thus reducing sanding time after the seam adhesive has cured.
- Always use seam reinforcements. The Durasein reinforcement should be at least 2" (51 mm) wide, and it needs to be continuous for the full length of the seam.



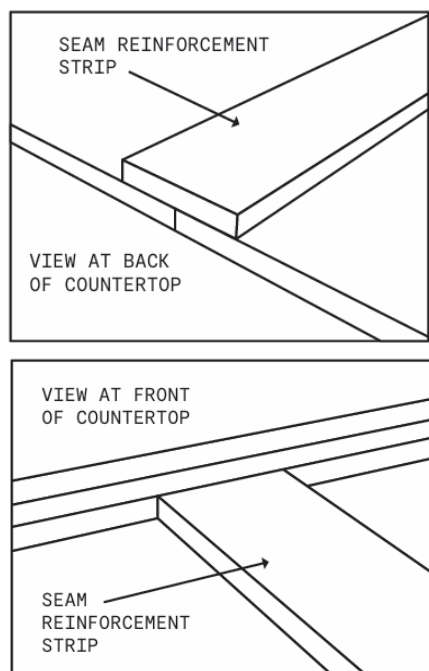
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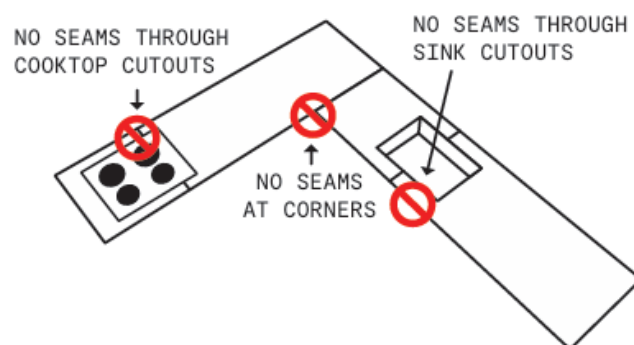
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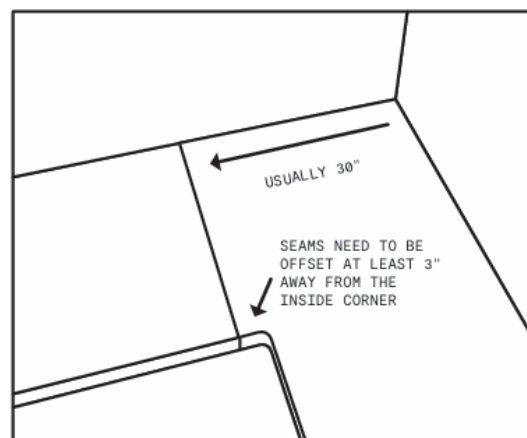
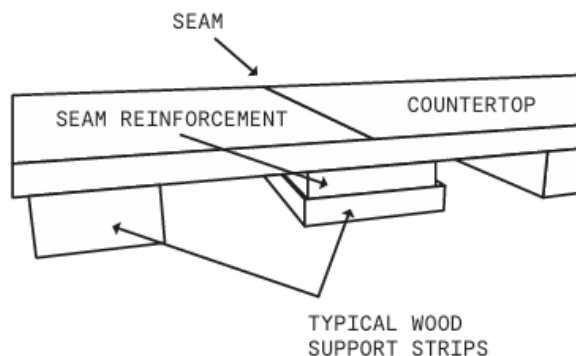


Avoid locating seams in areas that may be subjected to stress. Seams need to be located as follows:



To reduce the potential for stress damage to seams follow these guidelines: Do not place seams at corners. Place deck seams at least 3" (76 mm) away from inside corners. Avoid seams through cutouts. Place seams at least 3" (76 mm) away from cutouts. Butt seams in edge build-up strips should be at least 2" (51 mm) away from inside corners.

At a minimum, seams need to be supported at both ends. Continuous wood or metal support under the reinforcement piece is recommended.





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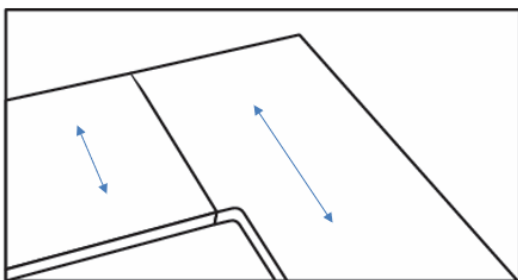
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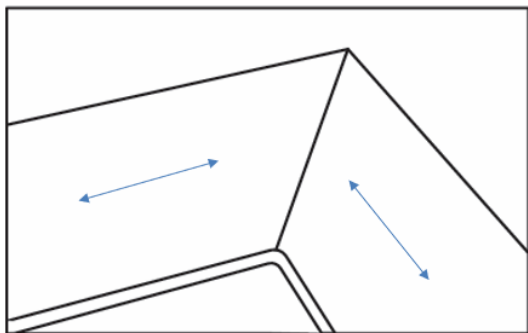
Corner Details for Directional Patterns

The inside corner using the traditional detail with the deck pieces on the return leg rotated so that the directional pattern is parallel with the corner piece. This may result in more deck seams to achieve the required length of the top.



Offset Corner

An alternative is to cut the inside corner at a 45 degree miter. This results in an acceptable aesthetic. The deck seam, however, is located right at the corner and may be susceptible to additional stresses. Therefore, take steps to be sure the cabinets and deck are flat and well supported. The inside corner radius must be at least 1/2" (12.7 mm).



Mitered Corner

Tips for Seams

- Be sure seams are 100% filled with seam adhesive. Voids in joints can be severe stress risers. A crack can start in the joint and migrate up into the deck.
- Support corner areas properly. Be sure the cabinetry and support pieces can prevent flexing of the countertop at the corner.
- Be sure that both sides of the countertop at an inside corner are level and flat.
- Use flexible adhesives to adhere the countertop to supports and cabinetry.
- Be sure to leave room for expansion and contraction between the support components and the countertop.



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