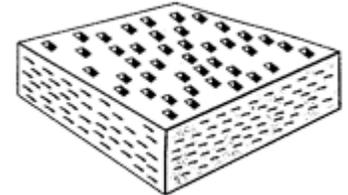


This bulletin summarizes the quality and design standards that must be met when fabricating and installing the Lustra Collection of colors from DuPont Corian®.
CTDC-142 (Issued 11/98)

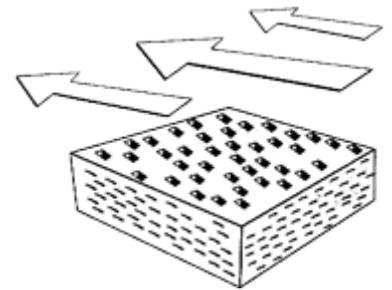
DuPont Corian® Technical Bulletin CTDC-142 Fabricating with Colors of the Lustra Collection

Lustra is a totally new aesthetic for Corian®.

The secret of the Lustra aesthetic is millions of mirror-like, micro-thin flakes that are oriented within translucent acrylic polymer. As a result, when viewed from different angles there is a perceived color change even under a consistent light source. And when viewed from the edge of the sheet, the flakes tend to "disappear." This creates exciting new possibilities for tone-on-tone effects.



While these features can add a wonderful look to an installation, they can present some areas to consider when fabricating this material. Realizing the full potential of Lustra requires some special considerations in design and assembly. A new adhesive for each color has been developed for joining this material. However, no special fabrication methods are needed for sink or lavatory mounting, thermoforming, or finishing.



(Illustrations shown here are not completely representative of proper fabrication procedure. **All inside corners must be radiused.** Reference Corian® Technical Bulletin [CTDC-117.](#))

DECK SEAMS

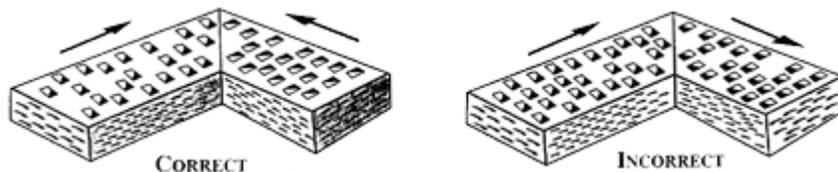
Light reflection varies as Lustra is viewed from different angles, which can appear as a color difference when sheets are joined. This is especially evident when making seams in "L" or "U" shaped tops. This is a natural feature of the aesthetic and is more evident in some Lustra colors than others. It should not be considered a defect, but should be explained to consumers before fabrication begins.

Always lay up the pieces before making seams to see if there is any difference in color appearance. If there is, the following techniques will help minimize the difference.

Diagonally Seamed Inside Corners

Diagonal seams in corners of "L" or "U" shaped tops will give the best look for Lustra. They give a subtle, neatly tailored change in the directionality of the light reflection, so the pieces blend very nicely.

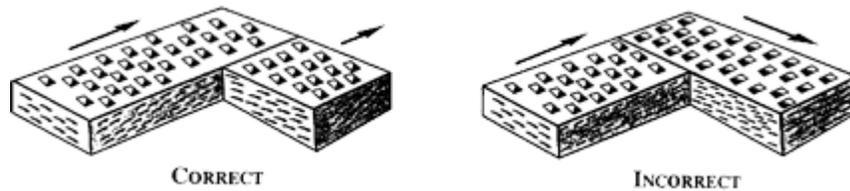
Important note: Cuts should be made so that the printing on the underside of the sheets runs in opposite directions at the corner.



Butt-Seamed Inside Corners

If the return leg of the "L" or "U" is less than 60 inches (1,524 mm), a typical butt seam can be used at corners.

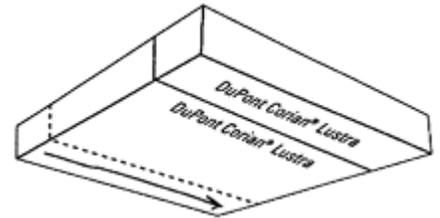
Important note: To minimize the difference in color appearance, the printing on the underside of the pieces must run parallel and in the same direction.



Butt Seams on Islands or Peninsulas

Important note: When making an island or peninsula wider than 30 inches (762 mm), the printing on the underside of the sheets must run parallel and in the same direction.

[**Helpful hint:** Put an arrow showing the direction of printing on the bottom of any strips that do not have printing on them.]

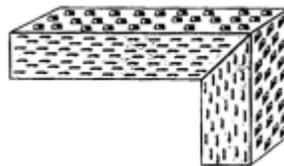


EDGES

The flakes tend to "disappear" when viewed from the edge of a sheet of Lustra. This is accentuated by making a thick edge in which the pieces are layered. The following techniques are recommended for fabricating edges with Lustra.

V-Grooved Edges

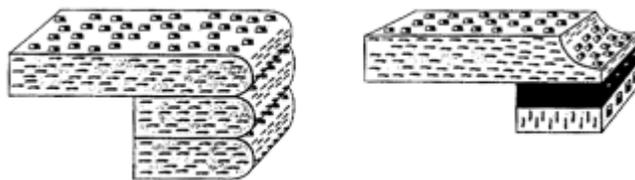
V-grooved edges look best because the flakes can be easily seen over the entire edge surface.



[**Helpful hint:** Smaller router profiles are recommended for V-grooved edges. Larger router profiles take away too much material, causing flakes to "disappear."]

Stack (Layered) Edges

Stack edges have a different look in Lustra because the flakes tend to "disappear" when viewed from the edge of the deck.



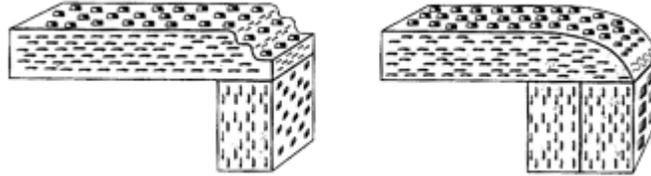
Important note: Larger-profile router bits expose more flakes and can enhance the look of a layered edge. Adding an alternate color strip as a "sandwich" breaks up the edge and draws attention away from the

"disappearing " flakes.

Stand-up Edges

Important note: Stand-up edges (made by standing up the edge strip) require large or very detailed edge profiles to expose flakes.

This edge style requires that strips be mitered at the outside corners for a uniform appearance.

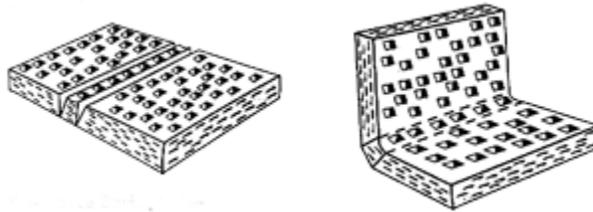


BACKSPLASHES

A conventional loose backsplash works well with Lustra colors. Clear silicone gives the best look. However, feel free to use the color of silicone you think looks best with the project.

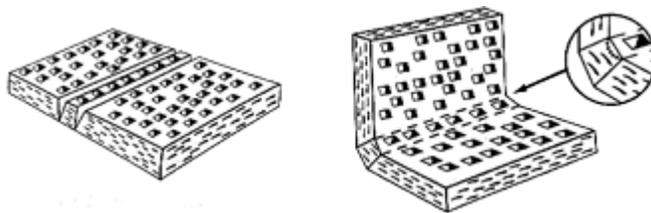
V-Grooved Backsplashes

The best-looking backsplash for Lustra is made by V-grooving, because the flakes can be easily seen over the entire edge surface.



Simulated V-Grooved Backsplashes

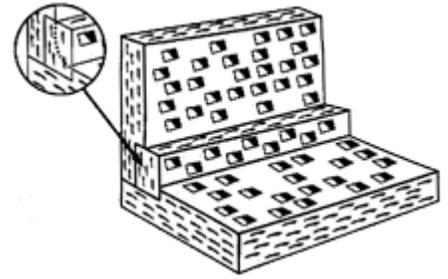
If a V-grooving machine is not available, this look can be simulated by making the pieces by hand, using a 22-1/2° router bit or a table saw set to 22-1/2°. Lay up the pieces, tape, and glue together with joint adhesive. After the adhesive sets, the cove is cut with a coving router.



Conventionally Coved Backsplashes

Conventional coved backsplash methods will work well for Lustra, but only if the following special procedures are strictly followed. Follow this assembly method whether using a shaper, router table or coving router to make the cove radius.

- Cut the backsplash piece so that it will go down into the rabbet on the back of the deck. Cut a rabbet 1/8 inch x 1/2 inch (3 mm x 13 mm) in the bottom of the face of the backsplash piece.
- Cut a strip 1/2 inch x 1/2 inch (13mm x 13mm) x the length of the backsplash. Glue into the rabbet on the backsplash piece with joint adhesive.
 - **Important note:** *The top surface of this strip must be facing in the same direction as the backsplash piece.*
- After the adhesive sets, trim excess from the bottom of the splash piece. Glue splash assembly into the deck as usual.
 - **Important note:** *Miter all inside and outside corners.*



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