



TRANQUIL[®]
ALTICOR

Method Statement – Tranquil Alticor

Product	Tranquil Alticor
Product Description	Modified Acrylic Solid Surface
Dimensions	12mm thick – 2440 x 760 mm 6mm thick - 2440 x 760 mm Can be ustomized.T
Accessories (Not included in product)	Alticor adhesive (different adhesives for different colors)
Additional products based on architect specifications	Ply backing wall - 6 to 19 mm Counter – 19 mm
Tranquil ALTICOR quantity in each sheet	12mm thick – 20 Sq. Ft. 6mm thick - 20 Sq. Ft.
Tools needed for Installation	Measuring tape, line marker, router machine, circular saw, sanding & buffing machine with different grating papers, blower, countertop cleaning agent, silicon sealant etc.



● Tranquil Alticor



● Adhesive



● Hand Buffing Machine

SURFACE PREPARATION

- > Clean the surface with wire brush or scrubber to remove hidden dirt, loose particles, laitance and dust.
- > Degrease the surface by using suitable solvents.
- > Solid Surface can be installed on ply surface only. In case of counter-top it can be installed on concrete or stone surface which is smooth.
- > Ensure no dampness or leakage on the wall or any substrate, so that product performance is not affected.
- > In case of ALTICOR application is on plywood, make sure that plywood is of marine grade and it is free from dirt grease or dampness.
- > The shelf life of adhesive is 2 years from the date of manufacture, so check the date of manufacturing before installation.
- > For best results, store the adhesive in cool and dry climate.
- > Check the batch number of the sheet before installing. Avoid using two batches of sheets in single location as each batch may have slight color variation.

PRODUCT PREPARATION

- > Alticor will be supplied in sheet form in 6/12 mm thickness.
- > Alticor requires ply backing to install.
- > Check for adequate quantity of Alticor adhesive (color based) and silicon glue for cladding as per installation requirements. Normally 75ml adhesive is required to install one sheet of Alticor.
- > In case of curved surfaces, Alticor can be bend to 8" radius minimum.

INSTALLATION

- > ALTICOR installation will always take place on ply backing (6-19 mm thick).
- > Ensure the ply backing is made firmly as per the design requirement so that Alticor can be installed perfectly over it.
- > Ensure to keep a gap of 5mm for every meter of installation to allow expansion and contraction of solid surface due to variation in temperatures.

PLAIN SURFACE

Cut the sheet into required sizes as per design requirement.

Note: Make sure to consider extra size of sheet for edge cladding based on the thickness of sheet and air gaps.

CURVED SURFACE

- > Make the template with flexible ply of desired shape.
- > Heat the Alticor with hot air gun to about 120 degrees or until it becomes flexible and take the shape of the template.
- > Place the heated Alticor over the ply template and fix the C clamps for curing. Curing time is 30-40 min.
- > Remove the clamps and fabrication to be done further as mentioned below.

FABRICATION

- > Use custom adhesive for custom colors of Altacor.
- > Use blocks for joining two sheets for firm adhesion and cure it for 15-20 min.
- > After curing, remove the blocks using chipping tool or any sharp tool.
- > Use buffing machine for surface sanding with different grit sizes of 80, 120, 220, 320, 400, 500, 600, 800, 1000, 1200 to 1500 max.
- > Surface sanding depends upon the type of finish required
Matte-600 | Semi Matte-800 | Glossy-1200 | High Glossy-1500

