

A large, dark grey, stylized letter 'S' is the central focus. Inside the horizontal bar of the 'S', the word 'meld' is written in a lowercase, white, sans-serif font. The background is a light grey color with a repeating pattern of small, interconnected geometric shapes, possibly hexagons or diamonds, creating a textured effect.

meld

Fabrication Guidelines  
for ecoX, Xposed and micro slabs

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## Meld USA ecoX, Xposed and micro - Eco-Sensitive Surfacing

Meld is a design focused manufacturer of eco-sensitive products, materials and surfaces. Our manufacturing facility is located in Raleigh, North Carolina. Meld's mission is to deliver smart, American made and design savvy products for high impact living, working and entertaining environments. EcoX, Xposed and micro converts post-industrial and post-consumer recycled waste materials into beautiful, distinctive and never duplicated surfaces.

## Disclaimer

Due to the nature of ecoX, Xposed and micro products and the sourcing of recycled and natural materials differences in color, surface texture, porosity, gauge, dimensional tolerance, aggregate size & distribution, and finish will vary and are inherent valued qualities of Meld products.

All slabs should be inspected as soon as they are received. Problems should be reported to your Distributor immediately along with the Slab ID #, non-conformity details and digital photos. If the preceding conditions are not followed fabricators automatically waive their right to exchange any product.

This manual shall serve as general guidelines only. The content in this manual is subject to change at any time and without notice.

## Marble Institute of America Standards

Fabrication and installation of ecoX, Xposed and micro slabs is similar to that of most natural stone, engineered quartz and other cement based recycled glass materials. Meld USA recommends following the Fabrication and Installation Guidelines of the Marble Institute of America. These guidelines can be found at [www.marble-institute.com](http://www.marble-institute.com). For clean and accurate fabrication of ecoX, Xposed and micro slabs we recommend that fabricators use diamond cutting and polishing abrasives as well as wet fabrication techniques. Always wear your Personal Protection Equipment (PPE) while working with ecoX, Xposed and micro and follow current OSHA rules and regulations.

## Procurement

In the District of Columbia and the States of Florida, Georgia, South Carolina, North Carolina, Tennessee, Virginia, Maryland, New Jersey, Pennsylvania, New York, Maine, New Hampshire, Vermont, Connecticut, Rhode Island, Massachusetts, Michigan, Ohio, Illinois, Indiana, Kentucky, Louisiana and Alabama all EcoX, Xposed and micro slabs should be ordered through Meld's exclusive distributor, Caragreen, LLC in Carrboro, North Carolina. 919-929-3009.

For sales outside of the aforementioned geographic areas please contact Meld USA directly at 919.790.1749.

Slabs measure 96" X 30" X 1.5" thick (approximately 4cm), with each slab weighing approximately 340 LB. Custom sizes and colors are available up request.

For larger projects it is highly recommended to purchase slabs from the same color batch.

## Storage & Handling

Minimum 72" (or longer) long forks should be used on all fork lifts to move slab crates/pallets around the fabricator's shop.

Always allow the slabs to "breathe" freely. Keep plastic, foam and other non-permeable materials from coming in contact with slabs (especially if wet) for any extended period of time. Contact from non-permeable materials i.e. plastic, foam, etc. may leave a very splotchy, undesirable look on the surface. Meld USA is not responsible for mishandling and improper storage of ecoX, Xposed and micro slabs.

When storing ecoX, Xposed and micro slabs, make sure to store them vertically on edge and on a soft surface to minimize broken and chipped edges. Slabs must be kept completely dry and stored indoors. If slabs have to be stored face to face make sure slabs are totally dry and free of any debris. Clean 100% recycled, dye free, corrugated cardboard should be placed in between each slab to protect the slab face. The cardboard should be the same size or larger than the slab. Clamp slabs together at 4 equidistant areas to prohibit movement and warping. Never store ecoX, Xposed and micro slabs outdoors, in direct sunlight or in areas of high temperature fluctuations.

When handling ecoX, Xposed and micro slabs, always carry on edge like glass whenever possible. Carrying the slabs flat could cause hairline fracturing and possible catastrophic failure. Inspect all slabs upon receipt.

## Fabrication

Due to variations in fabrication techniques and equipment it is recommended to experiment with tooling and equipment speeds as well as abrasive types and sizes to determine what works best for the fabrication of ecoX, Xposed and micro slabs. It is recommended to start slower and increase tooling speeds as necessary to avoid excessive dislocation and chipping along the cut edge. Diamond cutting tools are recommended and advised as they produce the best results.

When grinding and polishing, diamond pads are recommended for their superior results. 50 grit pads should be used to remove deep scratches, cutting marks, and for minor shaping. Continue to the next grit levels of 100, 200, 400, 800 then end with 1500. If a higher polish is desired, you can polish with 3000 grit and then buff.

Meld USA strongly recommends radius corners on all cutouts such as sinks and stove tops. All inside corners must be shaped to at least 1/4 inch and all outside radii must be shaped to at least 1/8 inch.

For edge polishing, Meld recommends a slow progression from coarser to finer grits utilizing 100, 200, 400, and ending with 800. If a higher polish is desired, you can polish up to 3000 grit and then buff.

We do not recommend straight edges. This may lead to pop-outs and excessive chipping. At minimum we suggest profiling all edges with a standard eased edge to soften up the corners.

## Rod Supports and Cutouts

All cutouts must have a front/back support of at least 4 inches. All rails must be fortified with minimum 1/4" steel rods and epoxy at least 20 inches to the left/right of the cutout. Fiberglass mesh and resin can also be used to fortify the slab. All under mount sink cutouts should have the inside edges polished to match the finished edges we recommend GE II 100% silicone or comparable product for sealing the sinks to the slab. Sinks should be secured with either clips to the underside of the counter, into a flush mounted subtop or using special sink supports (i.e. Sink Undermounter) that mount directly to the cabinets or supporting structure. Mechanical or pressure fit inserts should not be used.

## Cantilevers & Spans

Cantilevers greater than 10" should be additionally supported by corbels, angle brackets, metal plates, wood substrates or other acceptable means. Unsupported spans greater than 24" require metal rodding. Dishwashers should be attached to ancillary wood strips or metal brackets and not directly to the ecoX, Xposed and micro surface.

## Repairs

Clear knife grade polyester, acrylic or epoxy resins should be used to repair cracks, dings, chips and glass/aggregate "pop-outs." To repair damages it is best to use the "chipped" piece or popped-out glass in conjunction with a repair resin. Compatible pigments should be used to tint the resin when necessary.

Meld USA recommends using low VOC, color enhancing sealers for all ecoX, Xposed and Micro surfaces. (refer to the list of recommended sealers below.) The use of color enhancing sealers are critical in creating a uniform finish and in blending all differential colored areas found on each and every slab.

Countertop fabricators should carefully read and follow the sealer manufacturers' instructions, warnings, and all safety information prior to the sealer application process.

### Recommended Sealers:

#### Counter-Hard /First Sealz by ICT (distributed by BlueConcrete)

Phone: 770.464.2515  
Where to purchase: [www.blueconcrete.com](http://www.blueconcrete.com)  
Ease of Application: (6)  
Stain resistance: (8)  
Finish: Satin to semi-gloss finish with color enhancement

#### EAP by Kinloch USA (distributed by Surface 519)

Phone: 800-475-1975  
Where to purchase: [www.surface519.com](http://www.surface519.com)  
Ease of Application: (6)  
Stain resistance: (8)  
Finish: Satin to high-gloss finish with color enhancement

#### Enrich N Seal by Aqua Mix

Phone: 877.278.2311  
Where to purchase: [www.aquamix.com](http://www.aquamix.com)  
Ease of Application: (9)  
Stain resistance: (4)  
Finish: Satin finish with color enhancement

#### Nano1000 by Kinloch USA (distributed by Surface 519)

Phone: 800.475.1975  
Where to purchase: [www.surface519.com](http://www.surface519.com)  
Ease of Application: (10)  
Stain resistance: (4)  
Finish: Natural look without color enhancement

\*Ratings are based on a scale of (1) – (10) with (10) being the "easiest" or "most recommended".

The sealers above are recognized as some of the best sealers on the market for concrete countertop surfaces. Surface preparation and application instructions will vary for each and every sealer used. Final slab color will vary depending on the sealer used. There are many other sealers that can be used on concrete countertop surfaces. Tests should be performed prior to sealing the actual counters. Whatever sealer used fabricators should select a sealer that meets or exceeds the intended performance characteristics and client/project expectations.

## Installation Basics

Meld USA recommends following the Installation Guidelines of the Marble Institute of America. These guidelines can be found at [www.marble-institute.com](http://www.marble-institute.com). ecoX, Xposed and micro surfaces should be shimmed as necessary and installed with a flexible siliconized adhesive. A minimum 1/16th inch gap should be maintained around all edges to allow for expansion/contraction.

## Care & Maintenance

EcoX, Xposed and micro products are entirely hand made, from natural and recycled materials. Variation in color, surface texture, porosity, gauge, dimensional tolerance, aggregate size & distribution and finish will occur and are considered inherent valued qualities. Non-structural hairline cracks are possible and shall not be considered a manufacturing defect.

EcoX, Xposed and micro products should be cleaned with warm water and a clean, non-abrasive cloth or sponge. Meld recommends the use of a mild cleanser such as dish soap & water, neutral cleanser, or equal for daily cleaning of all ecoX, Xposed and micro surfaces. Heavy abrasive cleansers or cleansers containing ammonia, acid or bleach should be avoided.

Depending on the sealer used ecoX, Xposed and micro products are fairly stain, acid and chemical resistant. EcoX, Xposed and micro products are not stain-proof though. Like all naturally porous materials (i.e. granite, marble, limestone, slate, soapstone, etc.) there are no warranties against scratching, staining, etching or cracking. The same applies to all ecoX, Xposed and micro products.

Spills should be cleaned up as soon as possible as to avoid the risk of permanent staining or etching. Spills from certain products such as red wine, lemons, vinegar, coffee, etc. as well as various chemicals can permanently etch the concrete top if left to remain on the surface for an extended period of time. Etch marks appear lighter in color and cannot be wiped off with any cleaning product. In many cases this can be repaired by sanding and resealing the affected area. Unglazed ceramics and terracotta pots should not be used on ecoX, Xposed and micro surfaces and can cause permanent discoloration. Expect occasional rings to appear from unknown liquids. Oils in particular can penetrate the surface if forced in from the weight of a container. Wiping up oil spills as soon as possible can minimize the risk of staining. Keep water from pooling on the surface as certain minerals in the water may permanently stain the surface.

In the event that a stain forms and is unable to be removed with soap and water, we recommend the use of a stain removing poultice/paste (StoneTech Extract [www.stonetechpro.com](http://www.stonetechpro.com) or equal). Once stain is removed reapply sealer for added protection.

You should expect your new countertop to show wear, develop a patina and improve with time. Again remember ecoX, Xposed and micro products are stain resistant and not stain-proof. Common sense good housekeeping and regular cleaning techniques should be practiced.

Meld recommends that all newly installed surfaces should be treated delicately for a minimum of thirty (30) days following the sealing process and installation. Avoid heavy usage and cleaning during this time period.