

fortezza
QUARTZ SURFACES



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FORTEZZA QUARTZ SURFACES

Fortezza manufactures in two production facilities located in Manisa Organized Industrial Zone in a total of 63,724 m², 38,634 m² of which is closed area.

Since 2011, Fortezza produces natural quartz surfaces with state-of-the-art technology of Breton S.p.A, Italy based leader company of natural and composite stone technology machinery with 3 casting and 4 polishing lines.



FORTEZZA IS UNIQUE

Fortezza has demonstrated its R&D and Innovation vision since the first years of its establishment, naming the corporation: Peker Surface Designs Industry and Trace INC. showing that the design is the driving force for the company.

This vision, combined with strong investment policies, has given Fortezza the privilege of being the “first” in various fields:

2011 - After its establishment, Fortezza quickly became the country's most prominent exporter and fashion leader in its sector, **2014** - Became the first producer and exporter of ready to be processed quartz surface category with its Fortezza Plus investment, **2015** – Increased the capacity by 100% with the help of second line investment, and **2016** - Partnered with USA-based investment firm Darby Overseas,

2017 - Produced Turkey's first ever long vein quartz surfaces following Robotic Arm investment,

2018 - Received the title of being the first R&D Center approved by the Ministry of Science, Industry and Technology in its sector,

2019 - Partnership was established with Lotte Chemical Group (South Korea), **2020** - During the year, the new factory area of 27 thousand 534 square meters was completed and the 3rd line production started. With the addition of the second facility, Fortezza has reached a production capacity of 2 million square meters in a total facility area of 63,724 m²; taking its place among the world's leading quartz surface producers.



FORTEZZA INDOOR APPLICATION TECHNIQUES

Fortezza slabs can be sized precisely to the dimensions required by the projects for indoor floor or wall applications. This technical application manual is a guide that describes the most appropriate bonding technique for sized Fortezza Quartz Surfaces in indoor floor and wall applications and the main application techniques of the products used in bonding works.

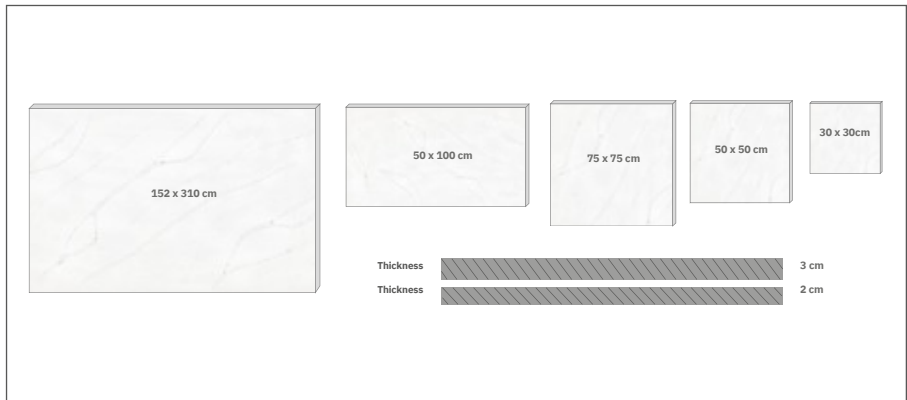
TECHNICAL SPECIFICATIONS

Table-1. Fortezza Technical Specifications

Standards	Specifications	Units	Values
EN-14617-1	Water Absorption	%	W4≤ 0,05
EN-14617-1	Apparent Density	(g/cm3)	Ort. 2,3
EN-14617-2	Flexural Strength	(MPa)	F4 ≥ 40
EN-14617-9	Impact Resistance	(Joule)	≥3
EN-14617-4	Abrasion Resistance	(mm)	A4 ≤ 29
EN-14617-5	Freeze and Thaw Resistance	(%)	KMf25= 98
EN-14617-10	Chemical Strength		C4
EN-14617-11	Linear Thermal Expansion Coefficient	(10-6/	20-35
EN 12664	Thermal Conductivity Coefficient	°C)	0,777
EN-14617-6	Thermal Shock Resistance	(W/mK) (%)	Δm = 0,48 ΔRf,20= 5 class A
EN-14617-12	Dimensional Stability		
EN-13501-1	Reaction to Fire Class		A2 s1 d0
EN-14617-13	Electrical Resistance	(Ω)	*R: s3x10 ¹² *R: v2x10 ¹² Wet 4,5
EN-14231	Slip Resistance	(SRV)	Dry 41
EN-14617-8		(N)	Avg.
EN-1348	Resistance to Fixing (Pim) Initial Adhesion Strength (C2 S1/S2 Adhesive)	(MPa)	2500 > 1
EN-1348	Initial Adhesion Strength (R2 Adhesive)	(MPa)	> 2

Table-2. Weights of Fortezza Quartz Surface Products (tile) sized in different sizes and thicknesses

Sizes	Weight (kg)	
	2 cm	3 cm
30*30 cm	4	6
50*50 cm	11	16
75*75 cm	25	37
50*100 cm	22	33
75*100 cm	33	50
75*150 cm	50	75



SURFACE PREPARATION

Application areas and sized Fortezza surfaces must be clean, dry and dust-free. When necessary, surfaces must be cleaned and prepared for application.

Cement Based Floors

The defects on the application surfaces should be corrected with repair mortar or leveling screed. The surface on which the screed will be applied must be cured and dry, otherwise shrinkage in the screed may cause the tiles to separate from the surface. Moisture on the surface must not exceed 5%. If quick-setting cement is not used in the screed content, the setting time is approximately 1 week for each cm of screed under normal weather conditions.

If the surface is too absorbent, it must be moistened before the application or lining must be applied to the surface. If there is no other definition in the project, the surface must have the recommended thickness and compressive strength according to the application area.

Table-3. Recommended minimum screed amount and compressive strength according to usage area

Usage Area	Thickness	Compressive Strength
Normal Traffic	3.5 cm	20-25 MPa
Heavy Traffic*	5 cm	30-40 MPa

*Airport, Shopping Malls, Industrial Areas, etc.

Ceramic Floors

If the ceramics on the floor are strongly adhered, the floor is made ready by using suitable rammed lining. If defects are seen on the ceramic surfaces (cracks, deformation, surface defects, etc.), the faulty ceramics must be removed from the floor and the tile application must be started after the floor is made suitable

Plaster Floors If a cementitious adhesive will be used on the floor, the floor must be dry (moisture <0.5%) and covered with a suitable lining for plaster surfaces. Otherwise, cement and lining react and expansion occurs and floor and tile surfaces are separated. **Tough Surfaces (Metal, Wood)** There must be no rust or residue preventing adhesion on the floor. If the floor is rusted, the rust must be removed from the floor surface by cleaning through mechanical methods such as grinding and sanding. Residues that will prevent adhesion should be cleaned with acetone. Wooden floors must be solid, if not, they must be repaired.

IMPORTANT INFORMATION FOR APPLICATION

Tiles (quartz surface, ceramic, marble) expand and deform due to the moisture coming from the floor, adhesive or screed. Therefore, the tile to be selected must be resistant to moisture. Otherwise, the tile will be deformed and may be removed from the application surface. Composite stone surfaces are divided into three classes as A, B and C according to the EN-14617-12: 2008 standard in terms of their deformation behavior against moisture.

Tiles in class A exhibit a stable behavior against moisture.

Table-4. Classification of tiles according to the amount of deformation against moisture All Fortezza Quartz Surfaces are classified as A.

Class	Description	Deformation Amount
A	Stable and moisture insensitive materials	< 0.3 mm
B	Moisture sensitive materials	>0.3 mm < 0.6 mm
C	Unstable and highly moisture sensitive materials	>0.6 mm

Tiles expand and elongate when in contact with heat. Therefore, the adhesive suitable for the behavior of the tile against heat must be selected and the system must be installed. The elongation amount of the stones can be calculated from the following formula by using the linear thermal expansion coefficients of the products. While adjusting the minimum joint space to be left between the tiles, the elongation amount of the products must be taken into consideration. Thermal expansion coefficients of Fortezza Quartz Surfaces vary between $20 \times 10^{-6} / ^\circ \text{C}$ and $35 \times 10^{-6} / ^\circ \text{C}$ according to their contents

Table-5. Elongation amount according to the thermal expansion coefficient of the products

Initial Length (L 0) (mm)	Elongation Amounts (L _{uzama}) (mm)			
	Thermal Expansion Coefficient (α L) 20 (10-6/°C)		Thermal Expansion Coefficient (α L) 35 (10-6/°C)	
	ΔT 10 °C	ΔT 50 °C	ΔT 10 °C	ΔT 50 °C
300	0,06	0,3	0,105	0,525
400	0,08	0,4	0,14	0,7
600	0,12	0,6	0,21	1,05
1200	0,24	1,2	0,42	2,1

ΔT : Temperature difference

$$\text{Lelongation} = L_0 \times (\alpha L \times \Delta T)$$

ADHESIVE MATERIAL

Adhesive classes deemed appropriate according to the floor features and product sizes on which Fortezza Quartz Surfaces will be applied are given in Table 6. For more detailed information about adhesives, it is recommended to consult the technical documentation of the product selected as the adhesive and to contact the adhesive manufacturer.

Recommended Adhesives

The technical specifications of adhesives are divided into different classes in the TS EN 12004 standard according to the type, adhesion level and performance of the adhesive. The main specifications to be considered when choosing the right adhesive are, in short, the type and size of the material to be adhered, the type of floor to be applied (Cement, Ceramic, Plaster, Metal or Wood) and its features, purpose of use, application limitations and application requirements. For Fortezza tiles, it is recommended to use cementitious

flexible (C2S1 or S2 class) or polyurethane resin based (R2) adhesives. However, some special conditions require additional specifications

in the adhesive. For example; When adhering in very windy, high temperature and low humidity weather conditions, it is recommended to use adhesives with extended open time (E).

It is recommended to use vertical non-slip adhesives (T) when adhering on walls.

It is recommended to use fast setting adhesives (F) in areas where the waiting time required before being put into service, such as airports, shopping malls and industrial areas, must be reduced

Type	C	Cementitious adhesive
	D	Dispersion adhesive
	R	Reaction resin adhesive
Adhesion Level	1	Normal adhesive
	2	Improved adhesive
Additional Specifications	F	Fast setting adhesive
	T	Adhesive with reduced slip
	E	Adhesive with extended open time
	S1	Deformable adhesive
	S2	Highly deformable adhesive

Table-6. Recommended adhesive types based on product sizes

Floors to which the adhesive can be applied	Adhesive Type		
	<0,20 m2 (Long sides≤30 cm)	0,20-0,36 m2 (long sides≤60 cm)	≥ 0,36 m2 (long side>60 cm)
Cement or Parget	C2S1	C2 S2	C2 S2
Metal	R2 (PU)	R2 (PU)	R2 (PU)
Plaster Screed or Parget*	C2S1	C2S2	C2S2
Underfloor Heating	C2S1	C2 S2	R2 (PU)
Ceramic	C2S1	C2 S2	C2 S2
Wood	R2 (PU)	R2 (PU)	R2 (PU)

* A suitable lining must be used. PU: Polyurethane It is recommended to use only R2 class polyurethane adhesive in areas exposed to sunlight directly. Company based recommendations are given in ANNEX-1.

Preparation and Application of the Adhesive

The floor and ambient temperature where the adhesive is applied must not be below 5 °C. The moisture of the floor must be at most 5%. For more information, it is recommended to consult the technical documentation of the product selected as the adhesive

Preparation of the Adhesive

Cementitious Adhesive

The powder component is slowly poured into the required amount of liquid component / water and mixed with a low-speed mixer until a homogeneous mixture is obtained.

Powder and liquid components must be used in the proportions specified by the adhesive company and one set of adhesives must be prepared at a time. Water must not be added to the liquid component.

The prepared adhesive is left to rest for 5-10 minutes and is mixed again for another 1-2 minutes just before the application.

Resin Based Adhesive:

Polyurethane-based flexible resin-based adhesives are recommended.

The hardener is slowly added into the resin. The obtained mixture is mixed with a low speed mixer until it gains a homogeneous color. Tiles must be adhered to the surface before the adhesive cures (before the pot life specified in the technical information of the adhesive is expired).

Application of the Adhesive

The floor on which the application will be made must be cleared of all kinds of residues (dust, oil, etc.) that prevent the adhesion and the dusty surfaces behind the tiles must be wiped clean.

In order to obtain a good adhesion surface, after the adhesive is spread on the surface with the flat part of the trowel, it should be notched with the threaded part of the trowel selected in accordance with the tile size.

The adhesive must be applied on the back of the tile in a thin layer. If the size of the tile is large or the floor to be applied is not smooth, the adhesive must be applied by notch to the back of the tile to leave a thicker layer.

The tiles must be adhered by applying force to the floor, leaving the necessary joint and expansion joint spaces before the service life of the adhesive expires and the crust forms on the surface. The application time may increase or decrease depending on the ambient conditions (moisture, temperature, wind, etc.) and the curing time of the adhesive.

After the tile is placed on the adhesive, it is made to settle on the floor by hitting the surface of the tile with a mallet.

During wall covering, large size covering materials must be adhered in the horizontal direction. It must not be passed on the next row until the finished row gets its first strength. Supports must be applied in a way that prevents the tiles from sliding. Adhering can be applied up to a wall height of 3 m. Mechanical assembly must be made for tiles exceeding the limit of 50x75 cm or 45 kg / m². For mechanical assembly application, please check Fortezza Facade Application Manual. Larger sized stones can be adhered in narrow and sun-free areas such as

bathrooms. However, if there is a substructure concrete or parget application, the adhesion strength must be 1MPa and the compressive strength must be higher than 10 MPa. Tile surfaces must be cleaned with a damp cloth after cement based adhesive application.

Polyurethane based adhesive must be cleaned from tools and the surface using a polyurethane cleaner. Direct contact of tiles with water for at least 24 hours must be avoided.

Adjusting the Appropriate Adhesive Amount:

The amount of adhesive required for the tiles to adhere properly to the surface to be applied varies according to the area of the application surface, its roughness, the size of the tiles and the content of the adhesive. The consumption amounts given in Table 7 may vary according to these factors. In addition, it must be used with a

notched trowel suitable for the adhesive during the application.

Table-7. Recommended adhesive consumption based on product sizes

Adhesive Type	Consumption Amount According to Sizes (kg / m ²)		
	<0,20 m ² > 0,36 m ²	0,20m ² - 0,36 m ²	
Cementitious	5-8 10-15	7-10	
Resin Based	2,5-3 3,5-5	3-4	

PREPARATION AND APPLICATION OF THE JOINT FILLER

Unless otherwise specified by the adhesive manufacturer, grouting process must be commenced after 24 hours.

Considering the joint widths given in Table 8 according to Fortezza Quartz Surface sizes, it is recommended to use CG2WA class (High abrasion resistance (A) and reduced water absorption (W)) joint filler or polyurethane sealant according to TS EN 13888 standard. When smaller joint gaps are preferred than these joint gaps, it is recommended to use only polyurethane sealant (with 25% movement capability, Shore A hardness of at least 35).

If polyurethane sealant is used, masking tape must be applied to the stone curbs to prevent the mastic from contaminating the stone.

In stair applications, a polyurethane or silicone sealant with a movement capability of 25% and a Shore A hardness of at least 25 must be used at the joints of horizontal and vertical stones.

Company based recommendations are given in ANNEX-1

Table-8. Recommended joint widths according to the size of the products (for 2 cm thickness)

Tile Sizes	Derz Geniřlięi (mm)	Average Consumption of Joint Filler (kg/(kg/m2))
30*30	2	0,32
40*40	3	0,36
50*50	3	0,29
60*60	4	0,32
75*75	5	0,32
50*100	5	0,36
75*100	5	0,28
60*120	6	0,36
75*150	6	0,29

$$\text{Joint filler consumption amount} = \frac{(A+B)}{(A \times B)} \times C \times D \times (d_{\text{joint filler}})$$

A = Tile length (mm)

C = Tile thickness (mm)

B = Tile width (mm)

D = Joint width (mm)

(d_{joint filler}) = Density of the joint filler

$$\text{Density of the joint filler} = \text{Density of the grout (g/ml)} \times \frac{100}{(100 + \text{Water rate})}$$

EXPANSION JOINTS Expansion joints divide the flooring of tiles into certain areas and prevent stretching

caused by all expansion

and shrinkage movements on the floor. In large areas such as airports, shopping malls, industrial areas, etc., a polyurethane or silicone-based sealant (with a movement capability of 25%, Shore A hardness of at least 25) expansion joint must be applied in the width specified in Table-8. 5-10 mm of perimeter joint is left in the areas where the wall and floor meet. If the joint widths smaller than the ones suggested in Table 8 will be used, the perimeter joint must be at least 10 mm.

Table-8. The minimum widths of the expansion joints according to the flooring density of the stones

Density of Expansion Joints (m)	Width of Expansion Joint (mm)
3	5
4	7
5	8
6	10

$$\text{Width of Expansion Joint} = \frac{(L \times \Delta T \times \alpha)}{\left(\frac{S}{100}\right)}$$

L = Distance between expansion joints (mm)

ΔT = Temperature difference (C°)

α = thermal coefficient of expansion ($\frac{1 \text{ mm}}{C^{\circ} \times 1000}$)

S = movement capability of the expansion joint

MAINTENANCE AND CLEANING RECOMMENDATIONS Post-Application Maintenance Recommendations

After the application, the residual substances that adhere to the surface such as paint and polish must be scraped off with the help of a plastic spatula. If the joint filler or floor adhesive smeared on the surface, it is necessary to clean these residues with water and a sponge during application before they dry. If the residues are hardened, the stain that will adhere to these areas will make it difficult to clean the surface.

Fortezza gets its shine from the quartz it contains. Therefore, polishing chemicals must not be applied to the surfaces. Fortezza Quartz Surfaces can only be polished under factory conditions. Polishing or varnishing processes to be made late may damage your Fortezza Quartz Surface in a way that cannot be recovered.

It should not be dragged by pulling heavy materials on the surface and in areas where construction works are undergoing, a protective material should be laid on the surface.

Cleaning Recommendations in Daily Use

Strong bases whose pH value is above 8.5 and acids with very low pH, such as hydrochloric acid cause the surface to fade and the smooth texture to deteriorate. For this reason, it can be cleaned with cleaning materials with a pH value of 5-9. Bleach, paint remover, paint and varnish thinners (chemicals such as thinner, trichloroethane or methylene chloride) must not be used as they damage the texture of the surfaces. Surface damage varies depending on the strength of the chemical, ambient temperature and exposure time. In cases where it should be used, it must be applied directly on the stain and rinsed with plenty of water as soon as possible.

All cleaning agents must be used at the proportions recommended by the manufacturer and the surfaces must be rinsed with water after use. Otherwise, residual cleaning agents on the surface may chemically affect the surface in the long term and over time may turn into permanent stain. Powder and cream cleaning agents with abrasive grains must not be used and gel products must be preferred. Stiff cleaning tools (wire scrubbers, pads with abrasive surfaces, etc.) must not be used.

Soft pads are used in areas where industrial cleaning machines are used daily and periodically. Black or brown pads are not suitable for these surfaces. It is recommended to use vacuum machines for daily cleaning.

RESPONSIBILITY LIMITATION

This document is prepared to describe how Fortezza products can be used in floor and wall applications and is based on our best knowledge and experience. However, the information written here may vary for the preferred adhesive and grouting in each project and must be evaluated by authorized project managers and approved after trials when necessary. Our company cannot be held responsible for these variations

It is recommended for you to review the "Fortezza Usage, Maintenance and Warranty Guide" in order to have information about the warranty conditions. Fortezza provides optional and limited warranty only for the A quality slabs used in the production of kitchen and bathroom countertops to be used indoors under the terms and conditions specified in the "Usage, Maintenance and Warranty Guide".



**SPECIAL RECOMMENDATIONS FROM ADHESIVE AND
JOINT MANUFACTURERS TO FORTEZZA**

KALEKİM ADHESIVE			
Floors	<0,20 m2 (long side≤30 cm)	0,20-0,36 m2 (long side≤60 cm)	≥ 0,36 m2 (long side>60 cm)
Cement Screed or Parget	Technoflex (C2TE S1) Ultratech (C2FTE S2) Technomax 30 (C2TE S2)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2)
Metal	Technopur (R2T)	Technopur (R2T)	Technopur (R2T)
Plaster Screed or Parget	Technoflex (C2TE S1) Ultratech (C2FTE S2) Technomax 30 (C2TE S2) (Gyps Lining must be applied beforehand)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2) (Gyps Lining must be applied beforehand)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2) (Gyps Lining must be applied beforehand)
Underfloor Heating	Technoflex (C2TE S1) Technomax 30 (C2TE S2)	Technomax30 (C2TE S2)	Technopur (R2T)
Ceramic	Technoflex (C2TE S1) Ultratech (C2FTE S2) Technomax 30 (C2TE S2)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2)	Ultratech (C2FTE S2) Technomax 30 (C2TE S2)
Wood	Technopur (R2T)	Technopur (R2T)	Technopur (R2T)
JOINT FILLER		Usage Area	
Ultrafugaflex (CG2WA)		In joint gaps between 2-20 mm	
Fugaflex (CG2WA)		In joint gaps between 1-6 mm	
Technobond (PU Sealant)			

MAPEI ADHESIVE

Floors	<0,20 m2 (long side≤30 cm)	0,20-0,36 m2 (long side≤60 cm)	≥ 0,36 m2 (long side>60 cm)
Cement Screed or Parget	Keraflex Maxi S1 (C2TES1) Keraflex Extra S1 (C2TES1) Granirapid (C2FS1) Kerabond T + Isolastic (%50) (C2ES1)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2)
Metal	Keralastic (R2) Keralastic T (R2T)	Keralastic (R2) Keralastic T (R2T)	Keralastic (R2) Keralastic T (R2T)
Plaster Screed or Parget	Keraflex Maxi S1 (C2TES1) Keraflex Extra S1 (C2TES1) Granirapid (C2FS1) Kerabond T + Isolastic (%50) (C2ES1) (Primer G or Eco Prim VG must be applied beforehand.)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2) (Primer G or Eco Prim VG must be applied beforehand.)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2) (Primer G or Eco Prim VG must be applied beforehand.)
Underfloor Heating	Keraflex Maxi S1 (C2TES1) Keraflex Extra S1 (C2TES1)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2)	Keralastic (R2) Keralastic T (R2T)
Ceramic	Keraflex Maxi S1 (C2TES1) Keraflex Extra S1 (C2TES1) Granirapid (C2FS1) Kerabond T + Isolastic (%50) (C2ES1) (Eco Prim Grip must be applied beforehand)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2) (Eco Prim Grip must be applied beforehand)	Elastorapid (C2FTES2) Kerabond T + Isolastic (C2ES2) (Eco Prim Grip must be applied before-
Wood	Keralastic (R2) Keralastic T (R2T)	Keralastic (R2) Keralastic T (R2T)	Keralastic (R2) Keralastic T (R2T)
Mixture for Kerabond T + Isolastic (50%) (C2ES1) = 4 kg Isolastic + 4 kg water + 25 kg Kerabond T			
Mixture for Kerabond T + Isolastic (C2ES2) = 8.5 kg Isolastic + 25 kg Kerabond T			
JOINT FILLER	Usage Area		
Keracolor FF (CG2WA)	In joint gaps up to 6 mm		
Ultracolor Plus (CG2WA)	In joint gaps between 2-20 mm		
Mapesil AC (Silicon Mastic)			



LATICRETE YAPIŞTIRICI			
Floors	<0,20 m2 (long side≤30 cm)	0,20-0,36 m2 (long side≤60 cm)	≥ 0,36 m2 (long side>60 cm)
Cement Screed or Parget	254 Platinum (C2TES1)	345 Super Flex (C2TES2)	345 Super Flex (C2TES2)
Metal	Latalastic (R2T)	Latalastic (R2T)	Latalastic (R2T)
Plaster Screed or Parget	254 Platinum (C2TES1) (Primer Superior must be applied beforehand)	345 Super Flex (C2TES2) (Primer Superior must be applied beforehand)	345 Super Flex (C2TES2) (Primer Superior must be applied beforehand)
Underfloor Heating	254 Platinum (C2TES1)	345 Super Flex (C2TES2)	Latalastic (R2T)
Ceramic	254 Platinum (C2TES1)	345 Super Flex (C2TES2)	345 Super Flex (C2TES2)
Wood	Latalastic (R2T)	Latalastic (R2T)	Latalastic (R2T)
JOINT FILLER			
Permacolor Fine (CG2WA)			
Permacolor Color Kit (CG2WA)			