
SENSA PREMIUM TECHNICAL GUIDE

For use by: Marble masons, professional installers and architects.

SENSA
by COSENTINO®

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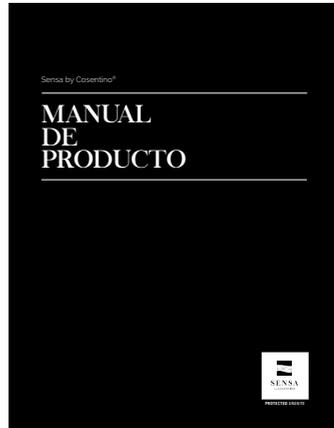
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THE PURPOSE OF THIS MANUAL IS TO PROVIDE GUIDELINES FOR PRODUCING
AND INSTALLING SENA BY COSENTINO WORKTOPS.

SAFETY

As a minimum, producers and installers of SILESTONE®, DEKTON®, ECO, SENSA, SCALEA, INTEGRITY Y PREXURY BY COSENTINO® must comply with all laws and regulations relating to workplace health and safety as well as the information contained in this Guide. During the transportation and handling of natural stone materials, risks such as

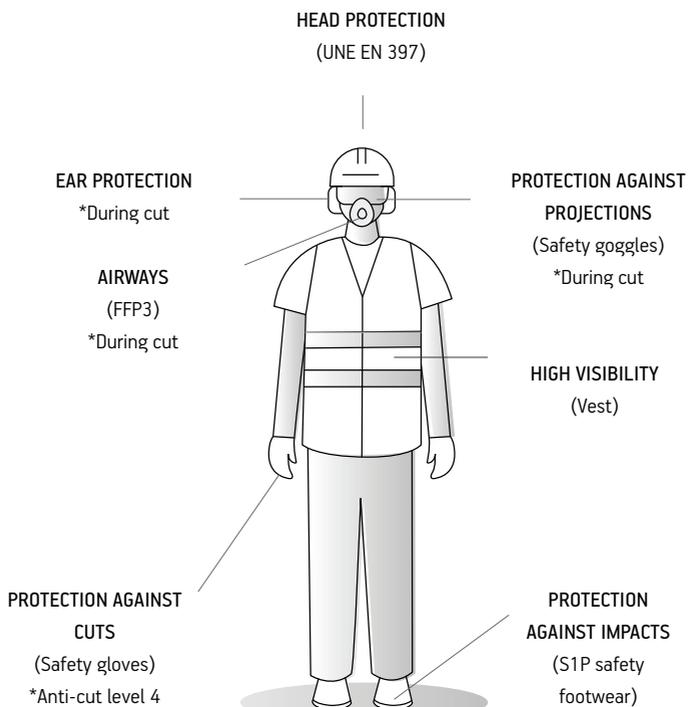
impacts, cuts, skeletal-muscular strains, or crush or projection injuries can occur due to incorrect handling. Please follow the safety instructions detailed in this guide.



PERSONAL PROTECTION EQUIPMENT

Always use adequate and certified protection equipment. The production process can involve the risk of cuts, crush or projection injuries, exposure to high noise levels or chemical substances such as free crystalline silica dust.

For more information about these risks and measure to prevent them, please consult the Safety Information Sheet as well as the Best Practice Guide that Cosentino has published. If you do not have this information, please ask your supplier.



PRODUCTION

DISC-BRIDGE

The cutting table should be solid and resistant. It should be perfectly flat and levelled. Check that the table surface on which you will lay the slab is in good condition. Tables with worn-down surfaces may cause the material to move during the production process. The disc should be in good condition (no teeth missing, not worn-down, etc.). In the case of quartzite, tools

meant for porcelain and high-strength materials should be used. These are usually soft-bond, high-quality diamond discs, e.g., DiamantBoart (ref: 543176300)

Parameters

Progress in one stroke 2 m/min

Down motion

RPM with Φ 300mm disc	3000
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RPM with Φ 350mm disc	2500
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RPM with Φ 400mm disc	2100
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Flow: Supply a generous amount of water to the area where the disc comes into contact with the material.

Note: make sure to cut mesh material.

POLISHING MACHINE

Abrasive and diamond generators should be in good condition and without any distortion to produce a correct profile. Use diamond abrasives meant for granite or quart agglomerate.



Settings

Progress, straight edge 0.8 m/min

Progress, round edge 0.4 m/min

Pressure Between 2 and 3 bars

Abrasive grains 50- 100-200-400-800-1500-3000



WATERJET

The bed planks should be in perfect condition, with a maximum distance of 10 cm between each plank in order to provide the best support possible to the piece.



The water level should be at the planks' level. Begin with a real cutting distance of 3 cm from the hole and with radius, in the area with the most material.



Settings

Piercing time 15s

Nozzle height 5 mm

Progress, straight cut 0.4 m/min

Pressure 500 bar

Abrasive-grain size 80 μm

Amount of abrasive 600 g/min



NUMERIC CONTROL - CNCT

Before you begin, the suction cups should be in perfect condition in order to ensure vacuum tightness.



Place the suction cups as to get the best grip on the piece. For inserts, place the suction cups on each side.



Settings

Drills 70 mm/min

RPM 2500

Cutting bit 225 mm/min in 2 steps

RPM 4500

Milling bit According to the manufacturer's recommendations

3-step straight-edge polishing: Medium paste, fine paste and polishing 450, 360 and 270 mm/min

RPM 4500



Begin with a drill at a real cutting distance of 5 cm from the hole. The bit should enter with radius, in the area with the most material. Cut in two steps.



Use electro-deposited and continuous tools for profiling, avoid segmented tools. CNC polishing leaves a fine, non-polished edge. Finish by manual polishing.

MANUAL WORK

Before you begin, the work bench should be continuous, stable and leveled. The table should be made of wood or plastic to avoid scrapes and

scratches.

Always work with water. Polishing discs and abrasives should be in good condition. Use tools meant for granite and high-strength materials, e.g., DiamantBoart.



Settings

Recommended radius ≥ 5 mm

Polishing sequence (gloss)

50 – 120 – 400 – 800 – 3000



FINISHING THE EDGES AFTER PRODUCTION

Once the worktop edges, the cut-outs edges and the beveled joints have been finished, they must all be protected in the same manner as the rest of the worktop.

Before applying a new coat of **SenGuard***, the edge's surface should be cleaned well in order to ensure that no impurities are left on the surface between the **SenGuard*** and the stone. We recommend using a cloth or moist towel with a few drops of liquid detergent.

Cleaning should be carried out in a clean environment to prevent impurities from landing on the clean surface. The product should be applied once the surface is completely dry to avoid trapping humidity in the interior when applying the **SenGuard***

Protection is applied by first pouring the product onto a cloth (never pour directly on the material). Then, the product is uniformly applied throughout the surface to be treated. The treated surface should have a glossy appearance for 3-5 seconds once the product has been applied. Contact to any nearby areas should be avoided.

Once the product has been applied, it should be left to fully dry for approximately 5 to 10 minutes. Reapply the product after this time has elapsed. Once the product has dried after the second application, any excess product should be removed with a dry cloth.

After the second coat has been applied, the worktop should not be handled for the next 24 hours.



* If the SenGuard product is not used, the countertop will not be covered by the guarantee.

INSTALLATION

HANDLING



Distribute the load evenly and vertically when handling.



The stand or support should be protected using cushions.



If the middle suction cup cannot be operated when handling material with holes using a suction-cup crane, we recommend you remove it or place it inside the hole (as illustrated in the picture), in order to prevent a "knee" effect.

Fastening pieces with straps and clamping tools.



LABELING

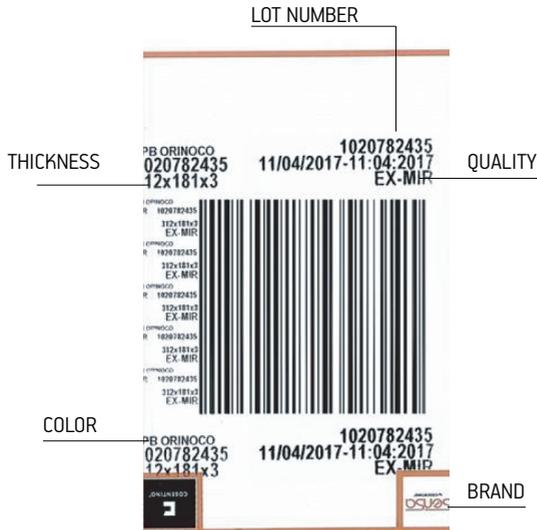
Slabs have a label containing all relevant information.

- **THICKNESS:** 2 and 3 cm
- **QUALITY:** All slabs belonging to the Sensa collection are of EXTRA QUALITY
- **SIZE:** The goal is to have an approximate size of 1.8 x 2.8 m. Depending on the block, this size may vary, reaching a minimum size of 1.5 x 2.5 m

LIABILITY DISCLAIMER

This manual has been prepared to provide informational guidelines for the production and handling of granite and quartzite. The information contained in this manual is provided for informative purposes only and should be previously verified by the customer.

Should you have any questions or doubts, please visit our website at www.sensa.com or contact Cosentino, SA



COSENTINO®

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** To obtain more information about NSF-certified colours please visit www.nsf.org