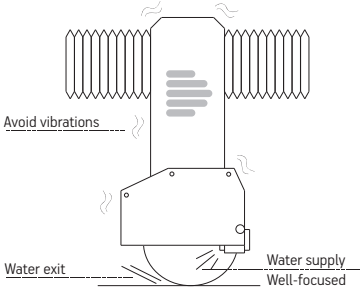


1. BRIDGE SAW

PRIOR TO FABRICATION



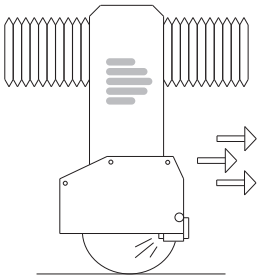
BLADE	ROTATION
12"	2400 rpm
14"	2200 rpm
16"	2000 rpm



CUTTING TABLE
Flat and leveled. Max. Possible support
Sandstone, wood, quartz.

PROCESSING

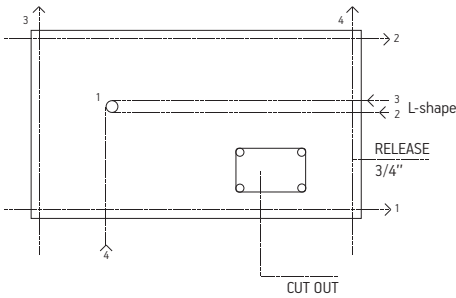
FEED RATE



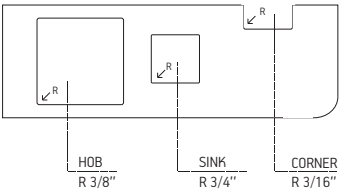
COLOURS	WHITES	OTHER COLOURS
Straight speed	20"/min	40-45"/min
45° cutting speed	20"/min	20-27"/min
Lowering speed of the plunge	5"/min	5"/min
Depth	1/8"	1/8"

NOTES:

RELEASE TENSION

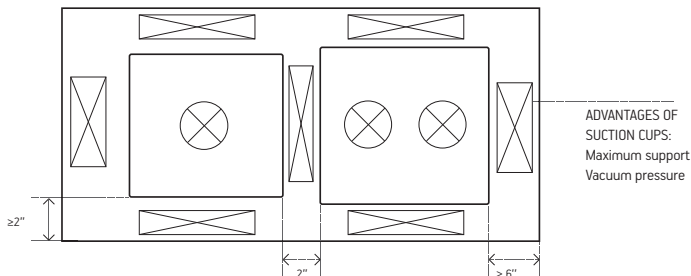


RECOMMENDED RADIUS
 $R \geq 3/16"$

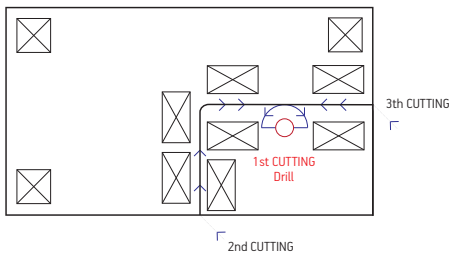
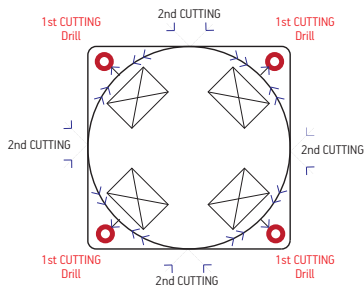
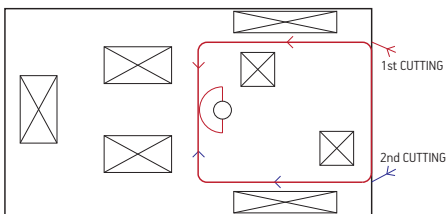
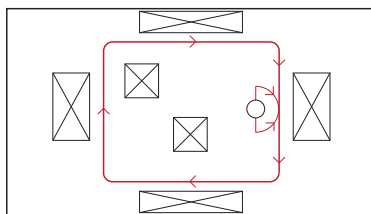


2. CNC

PRIOR TO FABRICATION



PROCESSING



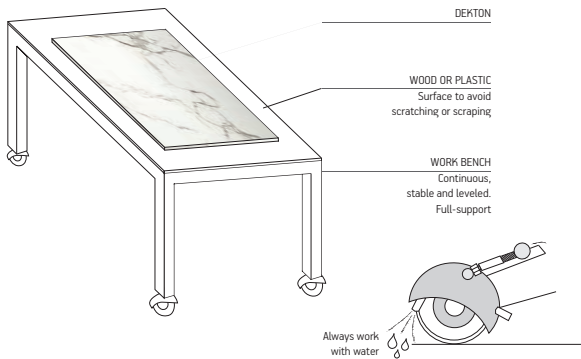
TOOLS	PARAMETERS	OBSERVATIONS
Drills	3/8"/min	Sharpen every 4 holes
Finger bit	6"/min (whites) 8"/min (rest)	Reduce to 3"/min for the last 4". No oscilation
Milling tool- countersinking	Use manufacturer recommended revolutions For countersinking, make the cut-out first, and then the recess.	Complete in one pass at the recommended depth (e.g. 1/4") at 2"/min.
Polishing	Use tools and parameters used on granite and quartz.	Check the tool wear

Use tools recommended by Cosentino.

NOTES:

3. MANUAL WORK

PRIOR TO FABRICATION



WHILE WORKING

1. FITTINGS

1 Drill the 4 corners

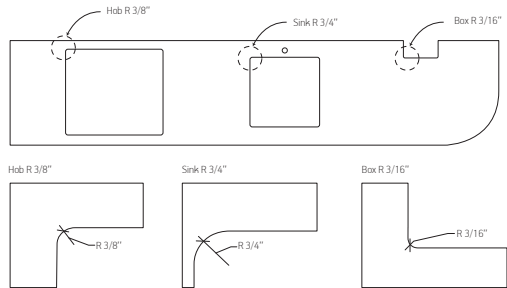
2 Remove cut edges using the hand blade

3 Case of rounded holes

RECOMMENDED RADIUS:
≥ 3/16" (Corner)
≥ 3/8" (Hob)

Concave blade and diamond cups

* Sharpen the tool every 4 drills



2. POLISHING

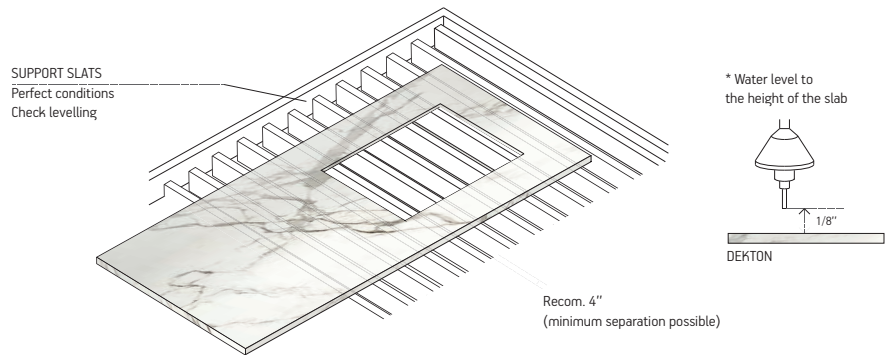
FINISHES	SEQUENCE	
	PADS	BRUSHES
Suede		46 - 60 - 120 - 220 - 400
Pumiced	50 - 120 - 220	+ 220 - 400
Matt	50 - 120 - 220 - 400	
Shine	50 - 120 - 220 - 400 - 800 - 1500	

NOTES:

Polishing pads or brushes for Silestone can be used. Always use tools recommended by Cosentino.

4. WATER JET

PRIOR TO FABRICATION



PROCESSING

CUTTING PRESSURE

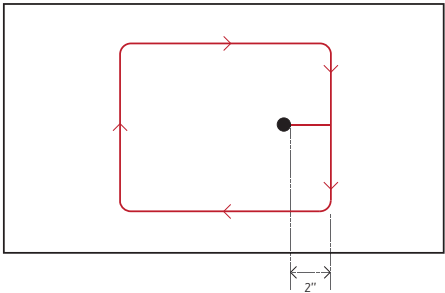
Low pressure (piercing): 15000 PSI
High pressure (cutting): 50000 PSI

ENTRANCE PIERCING

Out of the slab except for cut-outs. 10 sec.

ABRASIVE FLOW

600 g/min (recommended grain 80 micras)



CUTTING SPEED

COLORS	Whites	Rest of colors
Straight cutting speed	15"/min	24"/min
Miter cutting speed	12"/min	12"/min

CUTTING QUALITY

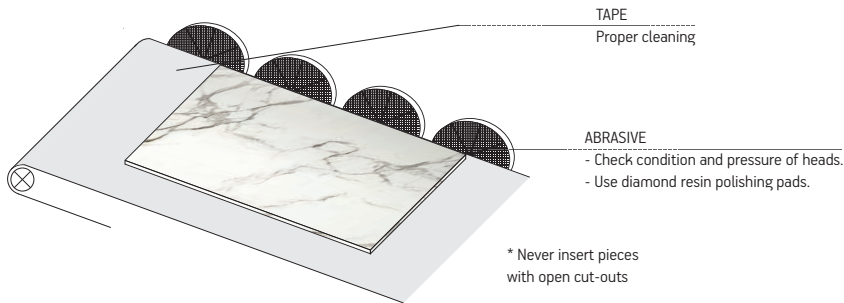
Depends on feed rate / flow of abrasive.

If
good quality
not achieved, reduce
speed or increase
amount of sand per
minute.

NOTES:

5. EDGE POLISHER

PRIOR TO FABRICATION



PROCESSING

1. POLISHED

FINISHES	SEQUENCE
Matt (Stones)	50 - 120 - 220 - 400 - 800 (Abrasive)
Shine (Xgloss)	400 - 800 - 1500 - 3000 (Abrasive)
Texture (Oscillating)	46 - 60 - 120 - 220 - 400 (Brushes)

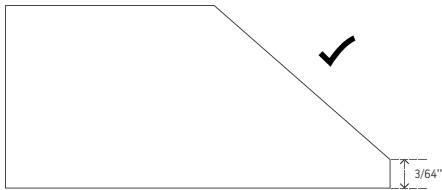
SPEED: 24"/min

PRESUURE: 1,8 bar - 2,2 bar
(Depends on condition of machine and manufacturer)

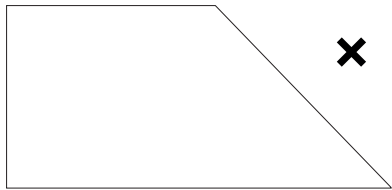
BLADE:
Ø 10"

SPEED:
8"/min

2. MITERED JOINT CUTTING



(Better quality cut)



NOTES:

6. INSTALLATION

HANDLING AND PACKAGING

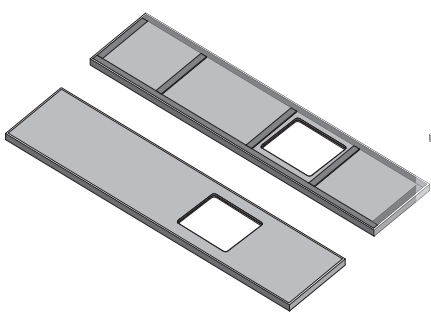
- Check the countertop measures
- Protect edges and corners.
- Reinforce big pieces.

LOADING AND UNLOADING

- Adapt the A-frame protecting it with foam/plastic
- Place the load in a balanced way or vertically
- Place the pieces faced and separated with a protective element (cork/cardboard)
- Secure the pieces with straps/belts or clamps.

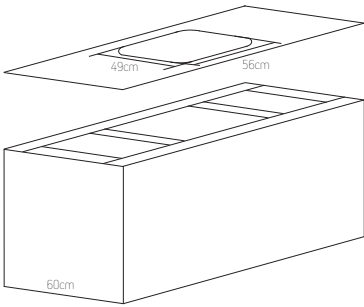
MOUNTS AND REINFORCEMENTS

EDGE FINISHES	REINFORCEMENT WITH STRIPS	MATERIAL	CONTINUOUS REINFORCEMENT	MATERIAL
STRAIGHT EDGES	Hidden in cabinets	Wood	Entire surface	MDF
MITRE EDGE	Hidden underneath	Dekton/Granite	Entire surface	MDF



DISTANCE BETWEEN SUPPORTS (IN)

COUNTERTOP WITH CUT OUT (GLASS-CERAMIC COOKTOP, SINK, ETC)	DISTANCE BETWEEN SUPPORTS (in)
12 mm	22in
20 mm	
COUNTERTOP WITHOUT CUT OUT	47in
12 mm	
20 mm	

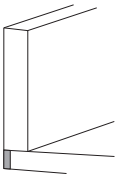
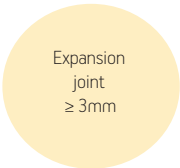


UNIT PREPARATIONS

- Clear and Clean the Surface.
- Level the cabinets adjusting the legs.
- Avoid the use of wedges.

SEAMS

- Calibrate the pieces on the edge polisher machine.
- Make a micro bevel if there are chips.
- Clean and dry the area.
- Use the Perfect Seam® tool in order to improve the finish.
- Remove the excess silicone and Mastidek with Clean-colorsil and a cutter.



NOTES: