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THE PURPOSE OF THIS MANUAL IS TO PROVIDE GENERAL GUIDELINES FOR THE DEKTON BBQ’S FABRICATION AND OUTDOORS INSTALLATION.

It is important to make all cuts at the shop facility avoiding to cut at the job site. We recommend to follow these next steps:
Follow the Fabrication Manual. Some of the most important points are:

- Once the slab has been trimmed 1” off each side to release its internal stress, it’s ready to be cut the designed BBQ counter top.

- Use a continuous support underneath the material to make the cook top cutout in order to prevent the piece from falling down.

- Drill all cutout corners before cutting. Then, from outside to inside make the side cuts. For the drills connected cut plunging the blade slowly. To avoid chips or breakages, the tools must be cooled with a lot of water.

- It’s important to keep the radius in both corners to avoid any possible breakage during and after the fabrication.

Use a 1.35mm core bit to leave a 16 mm radius minimum. For smaller BBQ flange use a 1” core bit to leave a minimum 10 mm radius. Never smaller.

<table>
<thead>
<tr>
<th>Recommended Radius</th>
<th>Minimum Radius</th>
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<td>20mm (façade hole)</td>
<td>10mm</td>
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- As usual, for lamination and joints we recommend an outdoor -- epoxy bonder like:

A) MASTIDEK OUTDOORS FOR DEKTON
B) EPOXY A-B ULTRAVIOLET, 24 HOURS.

C) AKEPOX 5010

D) INTEGRA BONDER ULTRA

**Surface Bonder Ultra**

For INDOOR / OUTDOOR applications.

A premium, Modified Hybrid Polyurethane resin for today’s surfacing needs.

Surface Bonder Ultra is a premium, UV stable, Modified Hybrid Polyurethane surfacing adhesive for indoor and outdoor applications. This unique adhesive will not yellow, stain or bleed, making it perfect for white marble. Surface Bonder Ultra contains almost no VOCs and is not classified as a hazardous material.
- In order to avoid any breakage in the future, it is mandatory to have full support under the material. We recommend to use concrete board (10 mm Hardy Baker). Never use plywood or marine plywood, because it swells (expands/contracts) in outdoor environments.

- To achieve full support and flatness, drill the cement board to the cement block.
HOW TO LAMINATE DEKTON TO THE CONCRETE BOARD?

- Must use Thin Set (254 Platinum from Laticrete, ProLite from Custom or similar). Never use Silicone, Caulking, Liquid Nail or similar glue.

HOW TO APPLY THE THIN SET?

- Clean both surfaces that will be in contact with the thin set and wet in order to increase the bonding force.

- With the method of double bonding, apply adhesive to both sides Dekton and substrate, using a Notched Trowel 10 mm, in perpendicular.
To avoid chipping on the joint edges at the moment of the installation, it is recommended to protect each joint edge with masking tape, cardboard, shims or masking tape in the border before placing the top on the base.
BEST PRACTICES

1. If there is a wall behind the countertop it is suggested to make the seams following the cooktop edges:

2. If there is a big flange in the BBQ, it is recommended to do radius over the cut.

3. Extra support behind the hardy backer as depicted on the picture, the red lines indicate a support (of metal bars, wood, concrete etc.) this is required so the hardy backer will not fall down, bow or fail in the future.
IF THE HARDY BACKER IS NOT LEVELED USE SHIMS BETWEEN THE BASE AND THE HARDY BACKER.

- Never do:
  
- A 90° sharp inside radius on an “L” shape top corner

- L miter edge in one piece:

- L miter edge 120°:
- The BBQ SHOULD NOT rest on the edge of the Dekton top cutout. It must be supported by the structure itself or frame specifically designed to hold the BBQ Grill. Never stand up or use Dekton tops as a standing platform.

We recommend heat tape for inside the BBQ Grill cutout.

- You must leave around 2 mm between the grill and the counter top.