

STONE
ITALIANA

DOSSIER

INSTRUCTIONS FOR
SLABS FABRICATORS

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INSTRUCTIONS FOR SLABS FABRICATORS

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INSTRUCTIONS FOR SLABS FABRICATORS

1 - LOADING THE SLABS

Stone Italiana slabs should be loaded vertically on suitable wooden or metal supports.

When handling slabs with the Rocface 2.0, Rocplan 2.0 or Grain 2.0 finishes, the surfaces with the finishes should be provided with adequate protection.

2 - LIFTING THE SLABS

The slabs should be lifted using lifting machinery equipped with neutral grips.

If using cables, avoid bringing the metal cables into direct contact with the slabs so as not to cause damage to them.

Store the slabs inside, away from direct exposure to sun. Store with finished face turned toward finished face.

3 - PROCESSING THE SLABS

Use discs, tools and abrasives specially designed for use on engineered quartz.

4 - CUTTING THE SLABS

When cutting the slabs, there must be a constant flow of cold water over them to avoid overheating.

The cutting disc used must be approved for use on engineered quartz and of a suitable diameter for the machine being used.

The rotation speed should be between 22-28 m/sec. This figure has been calculated assuming the use of a 350mm-diameter disc, using the following formula:

- diameter (expressed in metres) x 3.14 x 1400/60 (1400 being the number of revs/min).

The feed speed should be adjusted to the type of machine and disc being used, but we generally advise that it is between 2-4 m/sec.

For 45° cuts, use a specific disc for diagonal cutting.

5 - INSTRUCTIONS FOR CUTTING "L"-SHAPED PIECES

In order to cut the material correctly, first of all make a horizontal cut of the required length, and immediately afterwards make another cut parallel to the first (at a distance of 4-5 cm) so as to relieve any tension in the slab.

Next, make a third cut running vertically down from the end of the second horizontal cut. Finally, make a fourth cut of the required length parallel to the second (vertical), again at a distance of 4-5cm.

6 - INSTRUCTIONS FOR ROUGH CORE DRILLING

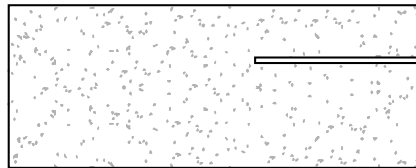
Use only tools which are approved for use on engineered quartz.

Place the piece to be drilled on the workbench, with the surface facing upwards.

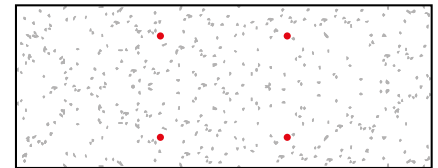
Mark the corners of the piece to be removed and then drill through to the other side using a bit with a diameter of approx. 30mm.

Make a continuous cut from one hole to the next until the section to be removed comes loose.

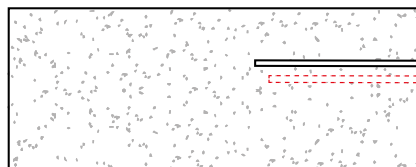
We recommended always rounding off corners and not leaving sharp edges.



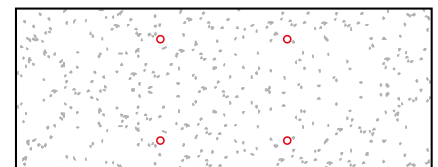
1st CUT



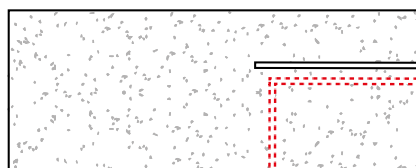
1) MARK THE CORNERS



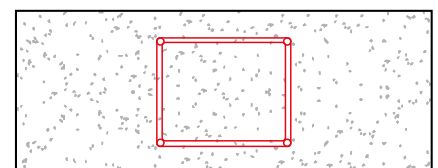
2nd CUT



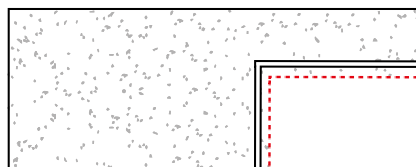
2) DRILL THROUGH THE CORNERS



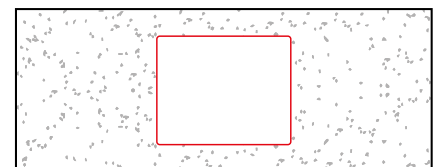
3rd CUT



3) CUT FROM ONE CORNER TO THE NEXT



4th CUT



4) CLEAN HOLE WITH ROUNDED CORNERS

7 - EDGE POLISHING AND/OR BRUSHING

Traditional edge polishers can be used to polish and/or brush the edges.

Keep the piece perpendicular to the workbench and ensure that the water supply is clean and flows constantly.

The belt advancement speed should be adapted to the thickness of the slab; generally, it should be between 0.75-1.5m/min. The abrasives used must be approved for use on engineered quartz.

For brushing, use diamond-filament brushes (yellow wire); the recommended series are 36-46-60-80-120.

8 - HOW TO GLUE THE SLABS

To glue the slabs, use products generally approved for use on natural stone materials, preferably mono-component products containing polyester resin (resin + hardener).

The pieces to be glued must be clean and only unfinished surfaces can come into contact with the adhesive. Before the paste hardens completely, scrape away any excess using a putty knife, then wipe with a cloth.

9 - C.N.C.

Use only tools approved for use on engineered quartz and follow the instructions in the CNC machine handbook.

STONE ITALIANA

INSTRUCTIONS FOR COLLECTIONS WITH GLOSS AND GRAIN 2.0 FINISH

10 - POST CUTTING WASHING IN THE WORKSHOP

Wash the slabs using a diluted, slightly acidic detergent (e.g. Faber-brand "*Stone Tile Cleaner*" or "*Deterdek*" by Fila) to remove any grease or scale residue left by the water used for the cutting operations. Where necessary, delicately rub with the rough (green) side of a household sponge.

Avoid leaving the water used during the cutting and polishing operations on the slab surface – always rinse thoroughly using running water.

Leave to dry naturally or use an air blower.

11 - POST INSTALLATION CLEANING

Any silicone residues need to be fully removed as soon as the slabs have been laid, using products designed to dissolve hardened silicone (e.g. Faber-brand "*Solvent Stripper*").

Once this operation has been completed, the surface should be cleaned using a diluted, slightly acidic detergent (e.g. Faber-brand "*Stone Tile Cleaner*" or "*Deterdek*" by Fila), then rinsed thoroughly.

12 - DO NOT USE THE FOLLOWING PRODUCTS

- Alkaline detergents
- Detergents containing sodium hypochlorite as the active principle (e.g. "*Clorox*")
- Detergents containing Marseille soap or silicone-based components
- "Wash & Wax" floor cleaners

INSTRUCTIONS FOR MARMOREA COLLECTION WITH GLOSS OR NATURAL FINISH

13 - POST CUTTING WASHING IN THE WORKSHOP

Wash the slabs using a diluted, slightly acidic detergent (e.g. Faber-brand "*Stone Tile Cleaner*" or "*Deterdek*" by Fila) to remove any grease or scale residue left by the water used for the cutting operations. Where necessary, delicately rub with the rough (green) side of a household sponge.

Avoid leaving the water used during the cutting and polishing operations on the slab surface – always rinse thoroughly using running water.

Leave to dry naturally or use an air blower.

14 - POST INSTALLATION CLEANING

Any silicone residues need to be fully removed as soon as the slabs have been laid, using products designed to dissolve hardened silicone (e.g. silicone-remover wipes).

Once this operation has been completed, the surface should be cleaned using a neutral detergent (e.g. Faber-brand "*Stone Cleaner*" or "*FilaCleaner*" by Fila), then rinsed thoroughly.

15 - DO NOT USE THE FOLLOWING PRODUCTS

- Alkaline detergents
- Detergents containing sodium hypochlorite as the active principle (e.g. "*Clorox*")
- Detergents containing Marseille soap or silicone-based components
- "Wash & Wax" floor cleaners

INSTRUCTIONS FOR COLLECTIONS WITH ROCFACE 2.0 AND ROCPLAN 2.0 FINISH

16 - POST CUTTING WASHING IN THE WORKSHOP

Wash the slabs using a diluted, slightly acidic detergent (e.g. Faber-brand "*Stone Tile Cleaner*" or "*Deterdek*" by Fila) to remove any grease or scale residue left by the water used for the cutting operations. Where necessary, delicately rub with the rough (green) side of a household sponge.

Avoid leaving the water used during the cutting and polishing operations on the slab surface – always rinse thoroughly using running water.

Leave to dry naturally or use an air blower.

17 - POST INSTALLATION CLEANING

Any silicone residues need to be fully removed as soon as the slabs have been laid, using products designed to dissolve hardened silicone (e.g. silicone-remover wipes).

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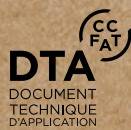
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ISO 9001 Certificato n° 30700767 QM15
ISO 14001 Certificato n° 30700767 UM15
OHSAS 18001 Certificato n° 30700767 BS OH



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DOCUMENT
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D'APPLICATION

• STONIT QUARTZ
• STONIT QUARTZ
AVEC INCRUSTATIONS
• STONIT QUARTZ AVEC
INCRUSTATIONS CALCAIRES
• STONIT MARBRE.
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DAL 1979 TECNOLOGIA E DESIGN DEL QUARZO

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