

SLABS

INSTRUCTIONS
FOR SLABS
FABRICATORS



INDEX

INSTRUCTIONS FOR SLABS FABRICATORS

- 1 Loading the slabs
- 2 Transporting the slabs
- 3 Processing the slabs
- 4 Cutting the slabs
- 5 Instructions for cutting "L"-shaped pieces
- 6 Instructions for rough core drilling
- 7 Edge polishing and/or brushing
- 8 Sticking slabs together
- 9 C.N.C.

INSTRUCTIONS FOR COLLECTIONS WITH GLOSS AND GRAIN 2.0 FINISH

- 10 Post-processing washing in the workshop
- 11 Cleaning after installation
- 12 Products to avoid

INSTRUCTIONS FOR MARMOREA COLLECTION WITH GLOSS OR NATURAL FINISH

- 13 Post-processing washing in the workshop
- 14 Cleaning after installation
- 15 Products to avoid

INSTRUCTIONS FOR COLLECTIONS WITH ROCPLAN 2.0 FINISH

- 16 Post cutting washing in the workshop
- 17 Post installation cleaning
- 18 Do not use the following products

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 Rocplan 2.0 or Grain 2.0 finishes, the finished surfaces should be provided with adequate protection.

2 - TRANSPORTING THE SLABS

The slabs should be moved by using lifting machinery equipped with neutral grippers. 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. In case of outdoor storage, cover the slabs with a dark tarpaulin.

3 - PROCESSING THE SLABS

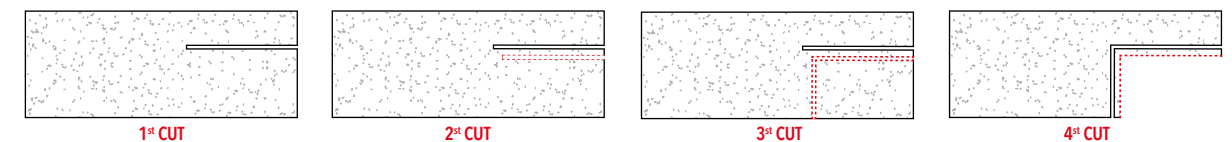
Use discs, tools and abrasives specially designed for use on engineered quartz.

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 used. The rotation speed should be between 22- 28 lm/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 used, but we generally advise that it is between 2-4 lm/sec. For 45° cuts, use a specific disc for diagonal cutting.

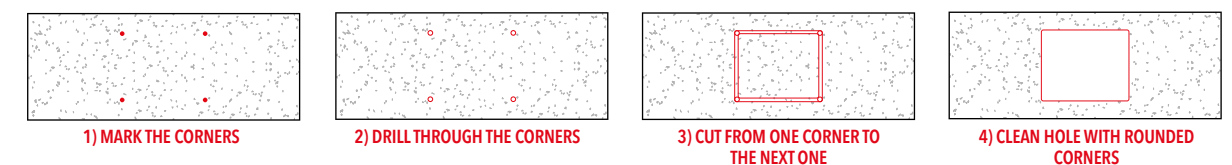
5 - INSTRUCTIONS FOR CUTTING "L"-SHAPED PIECES

In order to cut the material correctly, first of all make an horizontal cut of the required length, and immediately afterwards make another cut parallel to the first one (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 one (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 one until the section to be removed comes loose. We always recommend rounding off corners, not leaving sharp edges.



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 0.75-1.5 lm/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 - STICKING SLABS TOGETHER

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.

INSTRUCTIONS FOR COLLECTIONS WITH GLOSS AND GRAIN 2.0 FINISH**10 - POST-PROCESSING 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 - CLEANING AFTER INSTALLATION

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 rinse thoroughly.

12 - PRODUCTS TO AVOID

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

INSTRUCTIONS FOR MARMOREA COLLECTION WITH GLOSS OR NATURAL FINISH**10.a - POST-PROCESSING 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.a - CLEANING AFTER INSTALLATION

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 thoroughly rinse.

12.a - PRODUCTS TO AVOID

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

INSTRUCTIONS FOR COLLECTIONS WITH ROCPLAN 2.0 FINISH**10.b - POST-PROCESSING 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.b - CLEANING AFTER INSTALLATION

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 rinse thoroughly.

12.b - PRODUCTS TO AVOID

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



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