



THE BEAUTY OF STONE. THE BRILLIANCE OF PORCELAIN.

FABRICATION & INSTALLATION GUIDE



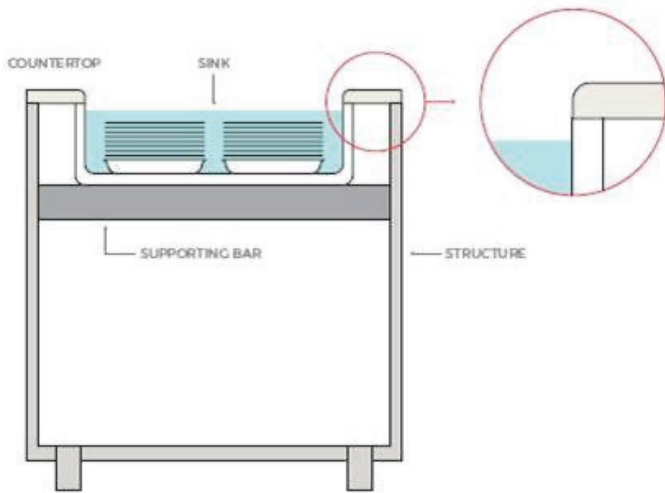
FABRICATION & INSTALLATION

> PREREQUISITES

- Almost any counter top configuration can be fabricated.
 - No overhangs over 8"
 - All walls and cabinets must be reasonably clean, square, and plumb. All cabinets must be permanently secured to the walls and/or floors.
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> SINK SUPPORT

It is advisable to add a support bar for large sinks to be fixed on the structure where the top will be installed. The weight of the water, when completely full, or the addition of the daily used material weight, could cause the detaching of the sink and/or the counter top breakage.



Stile® Fabrication and Installation Guidelines

- > Stile 12mm porcelain slabs come rectified from factory ready to install on floor or walls or fabricated for countertop applications.
- > Fabricated countertops can be installed without a backer board or sub top directly over open cabinet tops. The use of a backer board is recommended however especially if a mitered edge will be used to build up the edge to clear drawer and door fronts.
- > Fabricated countertops should be installed with an LFT (Large Format Tile) thin set such as Customs Building products Pro Lite. The tops must have 100% coverage of thin set material and CANNOT be installed using the spot technique.
- > Seams and joints at countertop and backsplash (if same material is used for backsplash) can be filled with either an epoxy or grout. We currently do not have premixed epoxies for our 12mm colors.
- > Seams are recommended at all 90 degree returns inside and out with a minimum 3/16" (5mm) radius on inside corners.
- > Chip and seam repairs can be performed similar to natural stone and quartz materials. The same color epoxy mixed for seams can be used for these applications as well as any and all the trade tricks are utilized for other countertop product repairs.
- > Cutting speed and efficiency will be maximized when using blades specific to porcelain and ultra-compact materials. There are several good blades available from different manufacturers and here a few that we have had good success with:
ItalDiamant
Terminator DK3
Cyclone by Diamax
Diatex Gres Cut
- > We have found that using a foam or cement board on top of the saw table can minimize vibration and chipping while cutting and help the panel from moving during cutting procedures.
- > Cutting speeds and blade rpm will vary by machine being used but for starting points, the following can be used as your guidelines:
 - 1900 – 2200 rpm (depending on equipment and blade diameter)
 - Always reduce feed rate by 50% for at least first 6" and last 9" of every cut. The plunge rate for straight cuts should be about 7" per minute.
 - For longer straight cuts, speeds up to and exceeding 90 - 100 inches per minute can be achieved.
 - For shorter cuts or when cutting smaller pieces, these speeds may need to be reduced by up to 40%.
 - For miter cuts, we have found that the above mentioned rpms may be maintained while feed rates will drop to between 25 – 40 inches per minute again depending on size of material and length of miters as well as machinery being used. The plunge rate when cutting miters is about 6" per minute.
- > Water jet cutting can yield very high quality cuts and sustain very high cut rates. Cutting parameters depends on the desired finish. As far as feedrate, 24IPM should be fine at 60,000 psi. Pierce pressure should be lowered to 20,000 psi with an increase of pierce time to allow the lower pressure to create that initial hole. When jetting it is always best to start inside of an already made hole like a blade cut. If that is not possible, then we say to start the initial hole at least 1 inch away from the finished piece being cut.
- > Under mount sinks should always be braced or supported to the cabinet sides whenever possible.
- > Edges and cutouts can and should be finished with a polished edge similar to natural stone countertops. The white marble colors should be polished using white polishing pads to avoid color transfer during the process.
- > While shades should be very close, it is always recommended to never mix shades without inspecting material before fabricating to ensure that they will be a cohesive blend.

Q. Do the Stile 12mm porcelain slabs need to have tension released by making relief cuts on all 4 sides?

A. No. These slabs come rectified and ready to install or fabricate.

Q. Can the 12mm Stile slabs be installed over open cabinet tops without use of a substrate or backer?

A. Yes, however we recommend using a backer board especially when a buildup is needed to accommodate the depth of the mitered drop down edge.

Q. Does the vein go all the way through the body (edge?)

A. No, these are ink jet printed with high definition graphics that is only on the surface over a full body porcelain slab.

Q. Can we use the same blades we use for cutting granite or quartz?

A. No, porcelain slabs are denser and therefore the use of blades made specifically for cutting porcelain should be used to minimize chipping and maximize cutting speeds.

Q. Can these 12MM porcelain slabs be cut using a water jet?

A. Yes they can and they cut like butter. We found that the feed rate should be around 24 IPM at 60k PSI. Pierce pressure should be reduced to 20k PSI with an increase of pierce time to allow the lower pressure to create the initial hole. When jetting, it is always best to start inside of an already made hole like a blade cut. If this is not possible, then we suggest to start the initial hole at least 1 inch away from the finished piece being cut.

Q. Can the Stile 12mm countertops be installed using an adhesive other than thin set?

A. It is not recommended since they need complete coverage, no spot setting.

Q. Does there need to be a seam at all inside returns?

A. Yes, we do require a seam at all inside 90 degree corners and a minimum 3/16" (5mm) radius.

Q. When having two slabs being installed together, what is recommended for seams?

A. Epoxy works just fine but we do not have any premixed colors available as of now. Grout can be used but most likely you will already have the color matched epoxy for the job.

Q. Can a fabricator use a remnant slab on a new job or are they required to buy all new slabs for every job?

A. While shades should be very close, it is always recommended to use the same shades. There is a chance that a customer may accept the variation between two different shades but this should always be approved first.