



THE BEAUTY OF STONE. THE BRILLIANCE OF PORCELAIN.

FABRICATION & INSTALLATION GUIDE

Calacatta Marbella - Porcelain

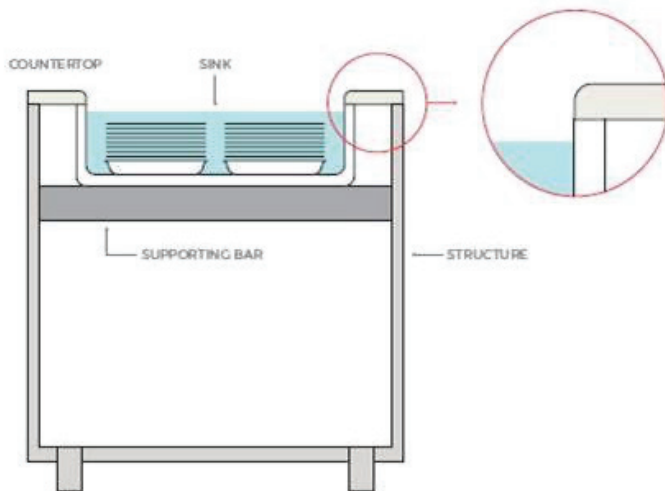
FABRICATION & INSTALLATION

> 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

➤ 2CM porcelain slabs must have 3/8" – 3/4" tension relief cuts made on all 4 sides. Long edges should cut first followed by the short ends.

➤ Fabricated counter tops can be installed without a backer board or sub top directly over open cabinet tops.

➤ Fabricated counter tops can be installed with a suitable adhesive such as 100% silicone adhesive or epoxy such as the two listed here.

TENAX GLAXS FAST or AKEMI AKEPURE 230/240.

➤ Seams and joints at counter top and backsplash (if same material is used for backsplash) have color matched epoxy available for each color from Tenax as listed below.

- POLAR WHITE – P is used for the Calacatta Marbella
- NEWPORT is used for the Calacatta Isla
- BASALT is used for the Marquina Noir.

➤ 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 matched products listed above can also be used for these applications as well as any and all the trade tricks are utilized for other counter top 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 are a few that we have had good success with:

ItalDiamant

Terminator DK3

Cyclone by Diamax

Diatex Gres Cut

➤ 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 60 - 70 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 depend on the desired finish. As far as feedrate, 24 IPM 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.

➤ Edges and cutouts can and should be finished with a polished (semi polished for Nero Marquina color since it has a silk finish) similar to natural stone counter tops. 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 2cm porcelain slabs need to have tension released by making relief cuts on all 4 sides?

A. Yes.

Q. Can the 2cm Stile porcelain slabs be installed over open cabinet tops without use of a substrate or backer?

A. Yes

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.

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 2CM 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 porcelain 2cm counter tops be installed using an adhesive other than thin set?

A. Yes, 100% silicone adhesive works very well but all points of contact should have 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. As far as impact durability, what is the Stile 2 cm porcelain breaking strength?

A. Impact durability is very high. The 2CM slabs have a breaking strength over 2250 LBF or 1.46PSI.

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

A. Epoxy works just fine and there are color matched options available from Tenax. 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.