

BASIC RECOMMENDATIONS FOR FABRICATING WALKER ZANGER'S SECOLO PORCELAIN SLABS

CNC Bridge Saw Cutting Parameters:

- Make certain the porcelain slab is completely supported on the flat, level, stable, and thoroughly cleaned bridge saw cutting table.
- Use a Segmented Blade - Diameter 400 mm @ 1600 RPM @ 36" /min.
We recommend an ADI MTJ64002 - Suitable for straight and 45-degree cuts.
- Adjust the water feed directly to where the blade contacts the slab.
- Before the fabrication starts, it is important to trim 3/4" from the slab's four edges to remove any possible stress tension that may be within the slab. (See *Figure 1 on next page*)
- Reduce feed rate to 18"/min for the first and last 7" for starting and finishing the cut over the full length of the slab being fabricated. (See *Figure 2 on next page*)
- For 45-degree edge cuts reduce feed rate to 24" /min.
- Drill sink corners with a 5/8" core bit at 4500 RPM and depth 3/4" /min.
- Cut a secondary center sink cut 3" inside the finish cut & remove that center piece first, followed by removing the four 3" strips just inside the new sink edge. (See *Figure 3 on next page*)
- Keep at least 2" of distance between the perimeter of the cut-out and the edge of the countertop.
- For Statuary Fine, Calacata Gold, and Calacata Classic, bond mitered edge detail with Tenax Multibond in the color Vicenza. For exterior edge detail bonds, use Tenax Powerbond also in Vicenza (Two-week lead time).
- Some applications may require a supporting backer board material to be adhered to the backs of the slabs. WEDI-BOARD and Schluter-KERDI-BOARD are suitable backer materials. Exterior grade plywood may be considered for slabs that won't be exposed to moisture.
- In bonding porcelain slabs to the substrate structure be certain you have a 100% bond and there are no air pockets or voids in the setting adhesive that could allow breakage.
- If you have questions, please call: 818.280.8292.

Figure 1. Trim Edges before Fabrication.

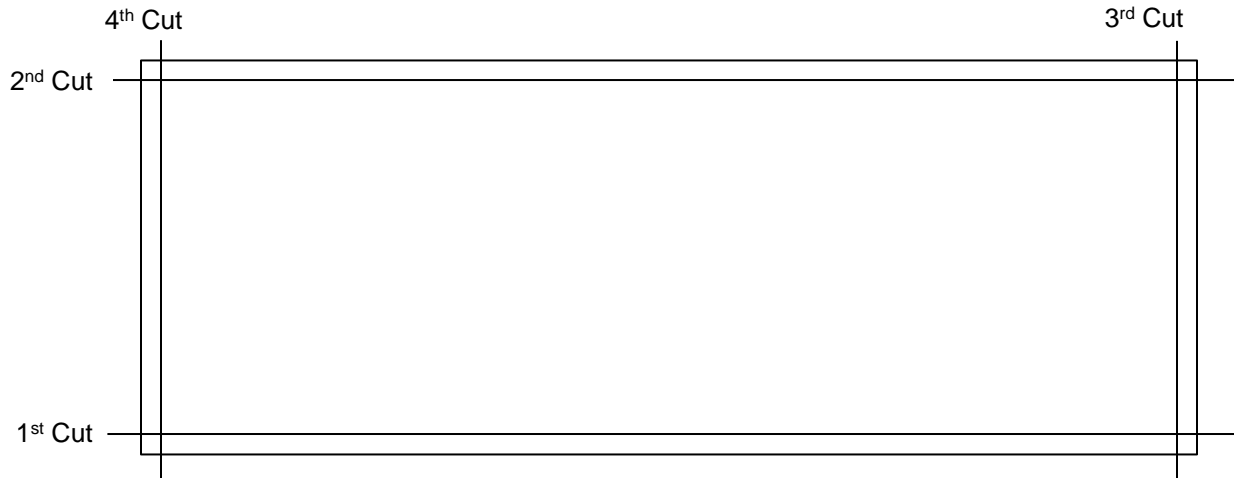
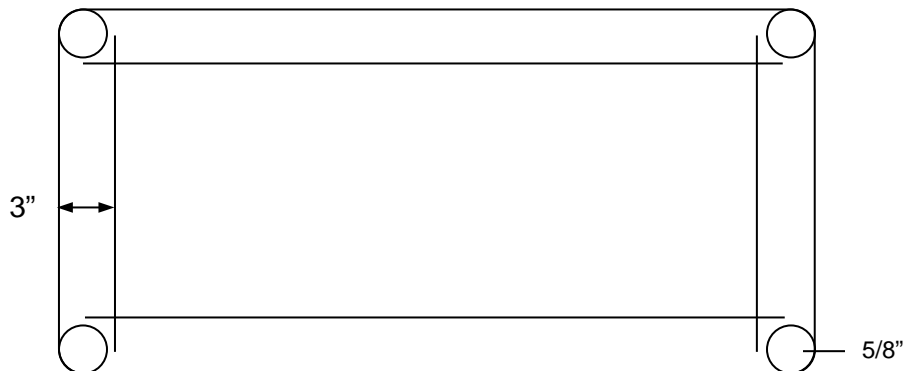


Figure 2. Reduce Feed Rate.

- It is suggested to reduce the cutting speed at about 50% at the beginning and at the end of the cut for about 7".

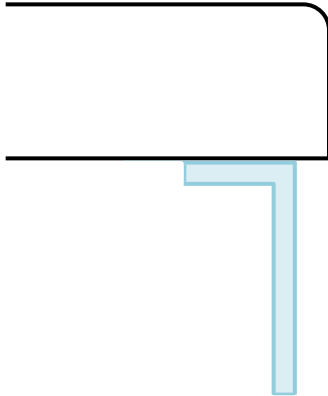


Figure 3. Diagram for Sink Cuts



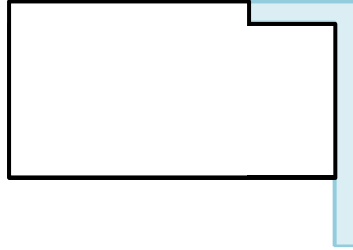
SINK INSTALLATIONS

UNDER MOUNT SINK



It is recommended to round the edge to make the slab stronger where it is more exposed to knocks.

FLUSH MOUNT SINK



It is recommended to not reduce the thickness of the slab more than 30% of the thickness of the slab. Use 1/16" silicone joint around the perimeter to ensure waterproofing.

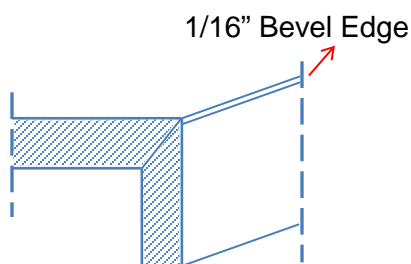
TOP MOUNT SINK



There is no particular recommendation because the edge is completely wrapped by the sink frame.

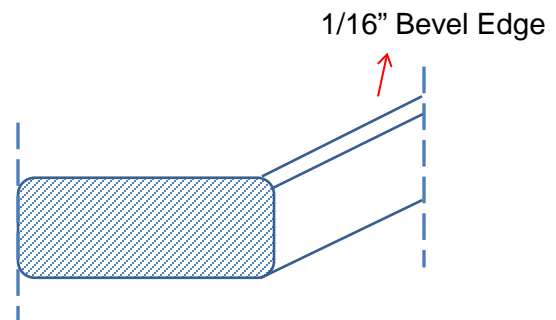
It is recommended to place supporting bars under the sink to hold the total weight.

EDGE SOLUTIONS



MITER EDGE

1. Miter the edges of both pieces
2. Clean each edge
3. Use epoxy to fix together the two pieces
4. The epoxy has to match the same color of the slab
5. Remove all excess epoxy



ROUND BEVEL

1. It is useful to improve the resistance of the edge of the slab against strong impacts
2. Use sandpaper recommended for porcelain
3. Start with the fine brushes and move to the thick filament brushes

Fabricating Using a Waterjet Machine

- The water level in the waterjet tank should be at the same level of the work table surface to improve the finish of the bottom of the slabs once fabricated.
- The pressure and the speed have to be adjusted according to the thickness of the slabs. For 12mm slabs the feed rate is 18"/min at 4,500 bar.

Sink and Slab Cuts with the Use of a Waterjet Machine

- For every rectangle shaped cut-out, it is suggested to keep at least 3/16" radius at each corner of the rectangle shape cut-out.
- Keep at least 2" of distance between the perimeter of the cut-out and the edge of the countertop.
- It is suggested to cut starting from outer side of the slab and in case of cut-outs, to do the entry hold outside the slab surface that will be used.

