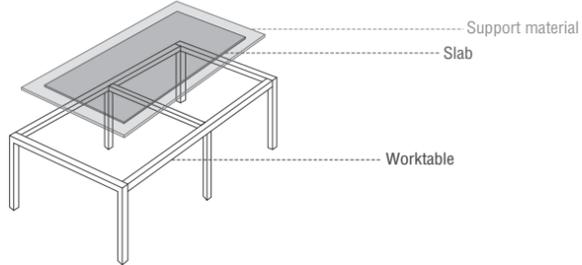


ATTENTION

- Worktable must be larger than the slab and have the solid structure to fully support the entire slab's length and width.
- The support material for cutting should be flat and straight e.g. cement board with at least 15 mm (5/8 in) thickness.



- Use the recommended cutting blade and core drill bit for Porcelain only, all in good and ready to use conditions.



- Use enough cooling water during cutting and drilling (wet method only).
- Check the proper condition of all equipment and tools especially the electric ones and follow the guidelines of use according to suppliers' instruction manuals.

DRILLING PARAMETER

CORE DRILL DIAMETER	RPM
30 mm (1-3/16 in)	3,000-5,000
32 mm (1-1/4 in)	
35 mm (1-3/8 in)	

CUTTING PARAMETER

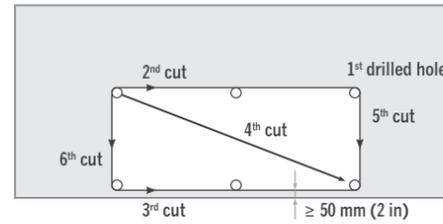
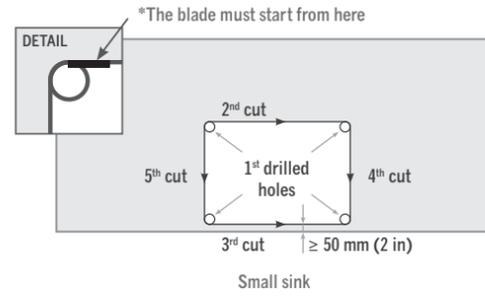
CUTTING BLADE DIAMETER	RPM
100 mm (4 in)	8,000-12,000
115 mm (4-1/2 in)	
125 mm (5 in)	

EDGE POLISHING PARAMETER

GRIT NO.	RPM
50-100*	3,000-4,000
200-300*	
400-500*	
800-1,000*	
1,500-2,000*	
3,000	

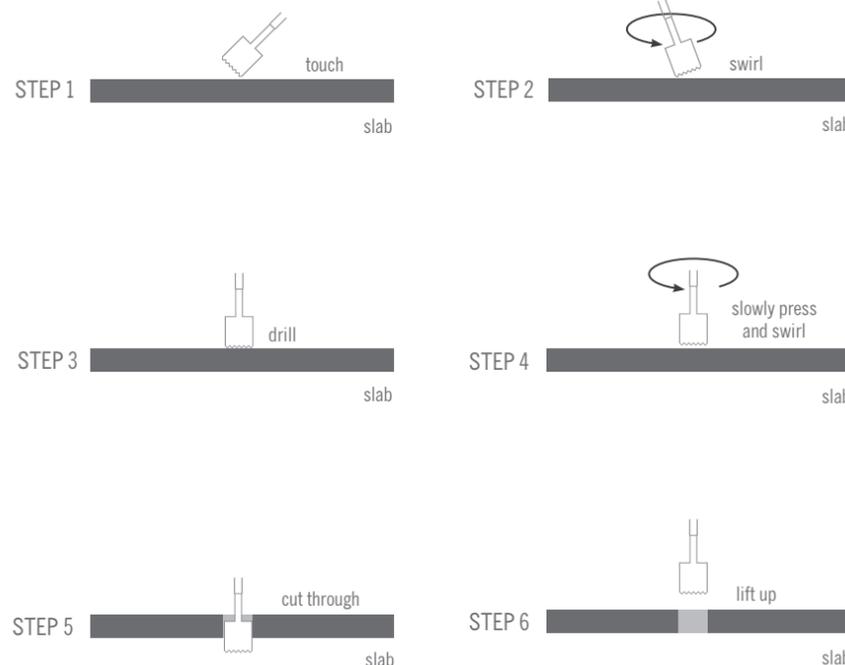
Remark: * select one number in such range for use.

SINK CUT-OUT

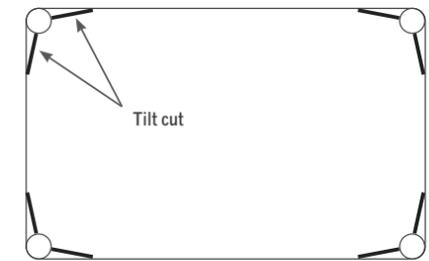


More drilled holes and diagonal cut are necessary for large sink 400x560 mm (19x 22 in)

1. Indicate the dimension of the sink hole to be cut and mark the precise cutting line on masking tape (do not write directly on slab).
2. Before starting to work, try the drill bit on a small piece of GEOLUXE® first to check the quality of outcome (for example chipping).
3. Use core drill bit diameter 30-35 mm. (1 3/16-1 3/8 in) with guide to lock the hand grinder from slipping and prevent any chipping of work piece. Rock the drill bit slowly while drilling as shown in the diagram below.



4. Use wet type hand grinder with Porcelain blade diameter 100-125 mm. (4-5 in) to cut according to the pre-determined lines. The incomplete cuts around drilled holes must be done in tilted direction from the holes toward the edges.

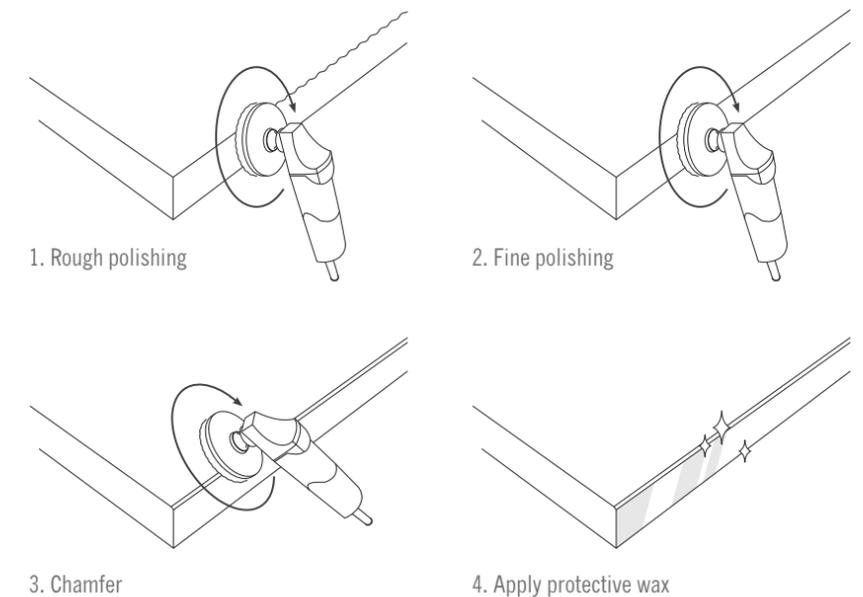


5. Use diamond polishing pads to finish the edges properly.

EDGE POLISHING

The edge of countertop can be polished by using the wet diamond polishing pads for porcelain. Please refer to the technical parameters provided by the producers before use.

1. Use pad no.50 or 100 to finish the edges before gloss polishing to eliminate the tiny chips.
2. The gloss polishing is by wet method only.
 - Polished surface: Use polishing pads no.200-300, 400-500, 800-1000, 1500-2000 and 3000.
 - Honed surface: Use polishing pads no. 200-300, 400-500 and 800.
3. Once done with all pads, check the gloss and see if any hairline is noticeable then clean it thoroughly.
4. Use clean cloth and air to dry the piece then use another clean cloth to apply wax for protection of edge from stains and enhancing its shine. (Bellinzoni special preparation paste wax or equivalent)



■ FABRICATION ADHESIVES

ADHESIVES FOR SEAM, JOINT, MITERING AND LAMINATION

- TENAX GlaxS/GlaxS Fast for both Indoors and Outdoors
- INTEGRA Surface Bonder (Indoors), Surface Bonder Ultra (Outdoors)

■ MITERING

1. Check well the design (e.g.veins) and tonality before mitering.
2. Use the wet type hand grinder with recommended Porcelain blade to cut the piece 46°.
3. Try the mitered piece to check whether it's straight and fits well. Adjust where necessary.
4. Use pad no.100 to finish the mitered edge properly.
5. Use the Porcelain blade to make grooves on both mitered piece and slab's mitered edge for better adhesion.
6. Mix and check the tonality of adhesive to be as close to the workpiece as possible before putting the hardener. Then apply the adhesive on the pieces.
7. Use the masking tape to support the mitered pieces to achieve the 90° and use the trowel to remove the excessive glue and leave it for proper setting at least 30 minutes or as specified by the adhesive producer.
8. Once the glue has reached its complete setting, use cutter to remove any excessive at the mitered joint. If any void is found, refill it with glue and wait until completely cured.
9. Use the pads step by step as per recommended sequence. Do not skip any number to do the final finishing of the mitered edge.
10. After the polishing stage, check the final shine and see if any hairline is noticeable then clean up properly.
11. Use dry cloth and air to dry the piece completely then use another clean cloth to apply the protective wax (Bellinzoni is recommended) and rub the edge for shine enhancement and stain protection.

■ LAMINATION

1. Check the design of veins and overall tonality before proceeding with lamination.
2. Place the back side of slab upward and set the area where to polish, making it a bit larger than the dimension of the stack piece.
3. Do the back polishing of both the slab's back side and the stack piece, using the polishing pads no.50-100 or grinding cup wheel.
4. Couple the pieces to check and ensure the straight and tight lamination outcome.
5. Use the recommended Porcelain blade to make grooves along the stack piece and the back side of the slab for good adhesion.

6. Mix the colored adhesive with hardener in proper ratio as recommended by producer. Check the overall tonality of the glue with the workpiece and fully apply the glue "back butter" on both the slab's back side and stack piece.

7. Put the stack in lamination and clamp the workpiece appropriately tight every 10 cm.(4 in). It is best to support the clamp with protective material to prevent any possible scratch on the surface.

8. Use a trowel to remove the excessive glue and leave it for at least 30 minutes or until reaching its complete setting.

9. After the complete setting, use cutter to remove any excessive glue on the laminated edge. If any void is found, refill it with the glue and wait until fully cured.

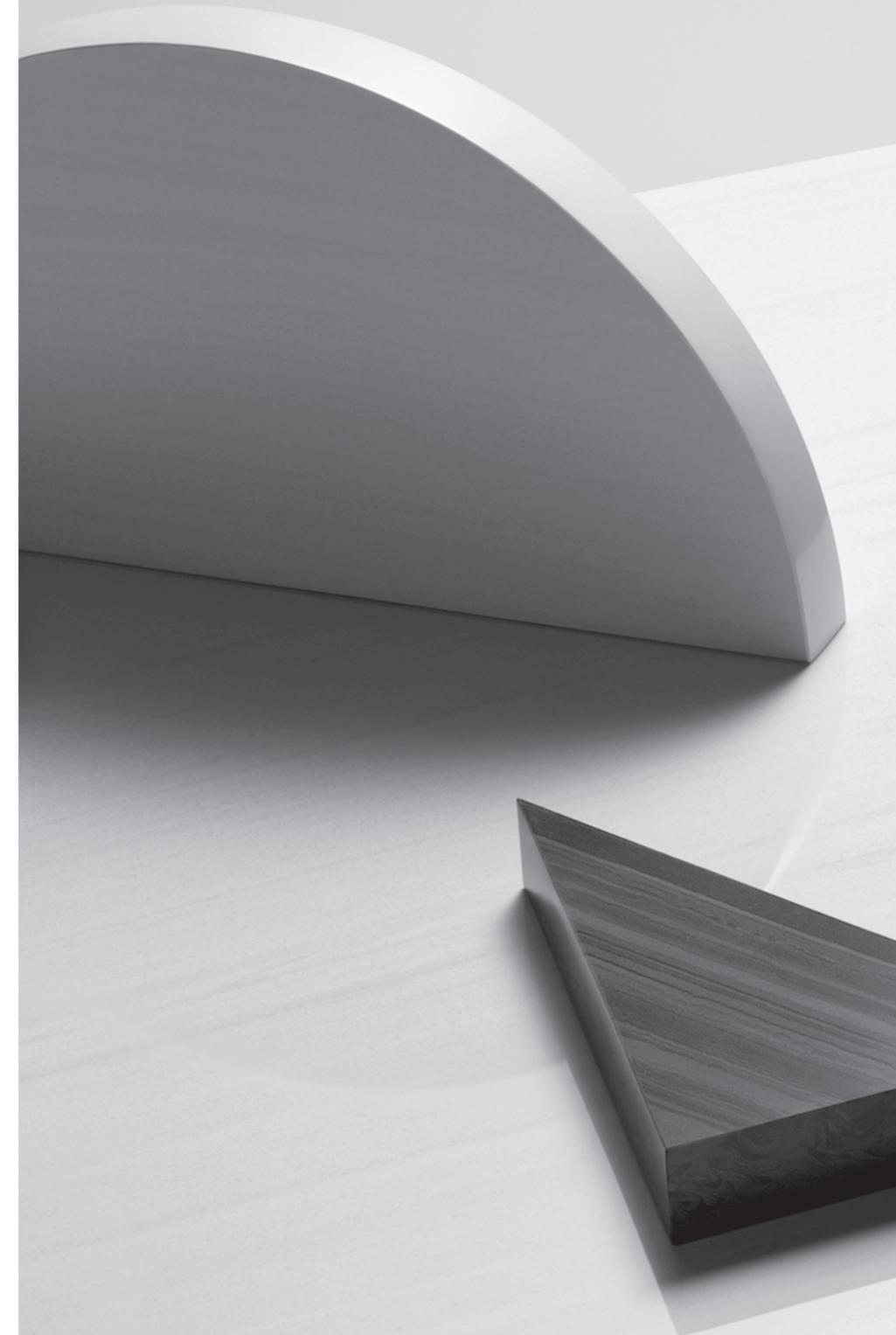
10. Use the pads step by step as per recommended sequence. Do not skip any number.

11. After the polishing stage, check the overall outcome such as its shine and whether any hairline can be seen. Then clean up properly.

12. Use dry cloth and air to dry it completely then use another clean cloth to apply the protective wax (Bellinzoni is recommended) and rub the edge for shine enhancement and stain protection.

■ POINTS TO BE WELL AWARE

1. For long lasting beauty and characteristics, avoid using any product and/or action that may create and leave stains on the surface, for example marker, foot print and rusty water.
2. Avoid using any hard and sharp material that may hit, scratch or heavily impact the workpiece, for example dragging heavy material, core drill bit or blade on the slab's surface is prohibited.
3. Do not put any equipment and tools on its surface while fabricating GEOLUXE® slab. Place them on a separate trolley or table.
4. For daily care and maintenance we recommend to simply use warm water or water with mild dish washing liquid to clean it.



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