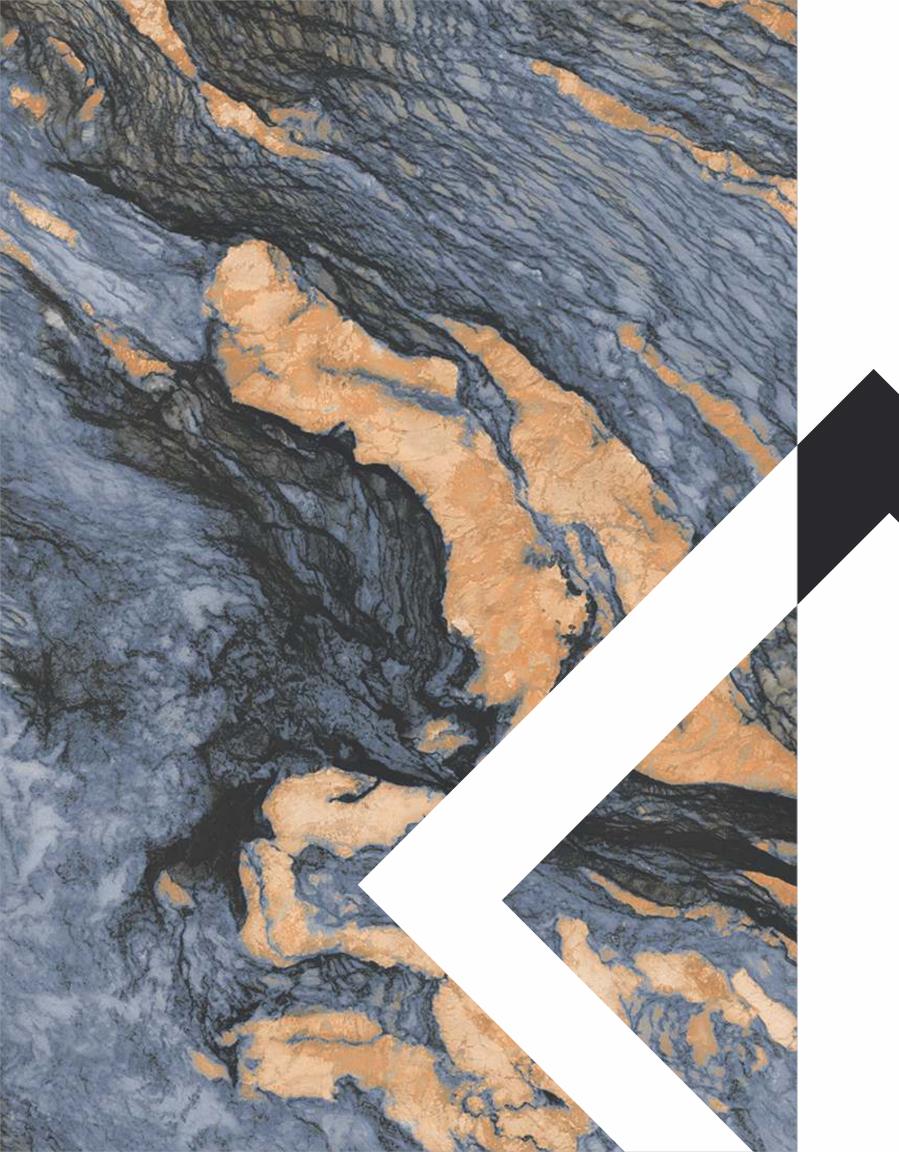
MOST POWERFUL COLLECTIONS EVER

60x120cm

PRODUCT BOOKY E A R \ 2 0 1 9 - 2 0 2 0



Defination of dimension

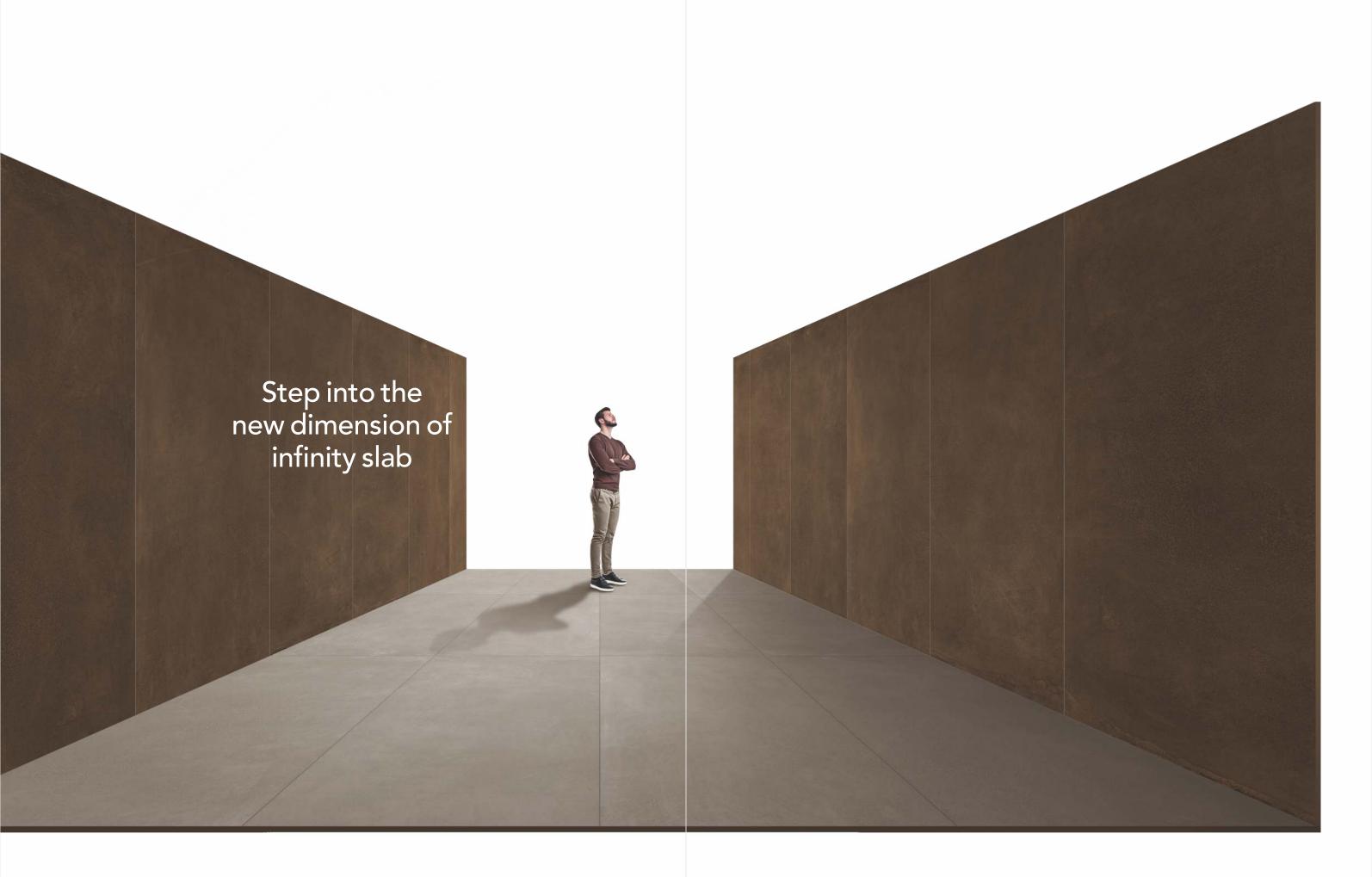
AN ASPECT OR FEATURE OF A THING.

A MEASURABLE EXTENT OF

SOME KIND,

SUCH AS LENGTH, BREADTH,

DEPTH OR HEIGHT.





Choose your sizes with infinity slab



COMPREHENSIVE RANGE OF PRODUCTS ALLOWS IT TO EFFECTIVELY MEET ALL DESIGN AND COMMERCIAL REQUIREMENTS.





Infinite design & size format





Easy to install & maintain



120 x 240cm 120 x 120cm 90 x 180cm 80 x 160cm 60 x 120cm



Choose your surfaces with infinity slab



HIGH GLOSS

Super gloss finishing and a touch of glorified glamour is what make these tiles an exception. Their sophisticated outlook and trendy colors shimmer and brighten up the mood & spaces.

POLISHED

Fine finishing and smoothness of tile surface make this collection another beautiful heaven of possibilities. Smart choice of tiles goes hand in hand with any interior decors.

GLINT

Classy yet contemporary is the appeal of this fabulous collection of vitrified tiles. Originality and diverse shades of colourful tiles has made this collection a worthy possession of all times.

CARVING

The surface of the tiles are given an extra cosy effect by carving out surface of the tile in a creative way, which adds glamour and attraction to your interiors.

METALLIC

Trendy and appealing designs of these tiles are total hit and dearly favorable. Bring home a new kind of interior designing and watch these tiles transforming your boring gloomy spaces into fun and functionality.

SILK

Textural smoothness combined with fascinating colour schemes open a vast range of possibilities for your space. It becomes very difficult for the onlookers to stay away from the tempting impulse to touch those tiles.

MATT

Sobriety of surface quality and boldness of this collection is something as unique as your personality. Not so loud yet full of creative surprises are much welcomed for an extraordinary surrounding.

Get advantage of technical characteristics with infinity slab



LIGHT WEIGHT



FLEXIBLE STRENGTH



CHEMICAL RESISTANCE



FLEXURAL STRENGTH



WEAR RESISTANCE



WATERPROOF SURFACE



RESISTANCE TO FIRE



FROST RESISTANCE



IMPACT RESISTENCE



HYGIENIC SURFACE



SCRATCH RESISTANCE



ECO FRIENDLY



RECTIFIED BODY



SLIP RESISTANT



STAIN RESISTANT



DIMENSIONAL STABILITY



Our creation has been categorized and sorted in cool trendy ways. It is easier to pick and decorate your own surroundings just the way you want. More options and better judgments about our various tiles will conquer your heart once and for all.

ARCIII TECUI RAL

Finish \ POLISHED

60x120cm

\ STATUARIO ELEGANT

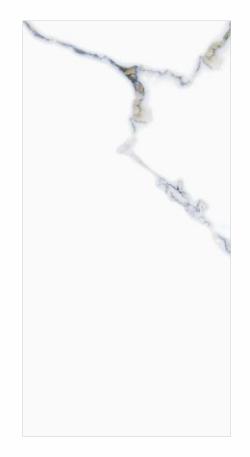




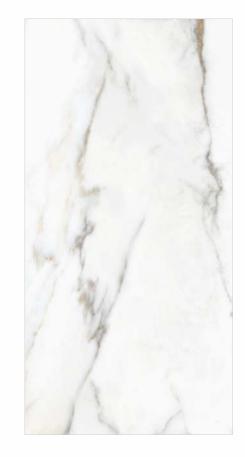


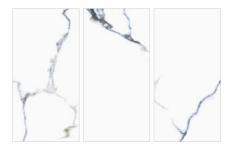






\ STATUARIO EXTRA







Finish \ POLISHED



























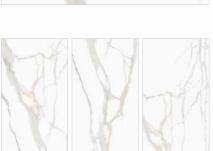






\ STATUARIO PEARL





\ STATURIO SELECT





\ STATUARIO TAJ









BOOK MATCH - A+B

BOOK MATCH - A+B

Finish \
POLISHED



MIN. 3MM 9M

9MM HICKNESS













60x 120cm

















\ MOROCCO WHITE











Finish \ POLISHED

Technical features

AIN. 3MM 9M

9MM THICKNESS









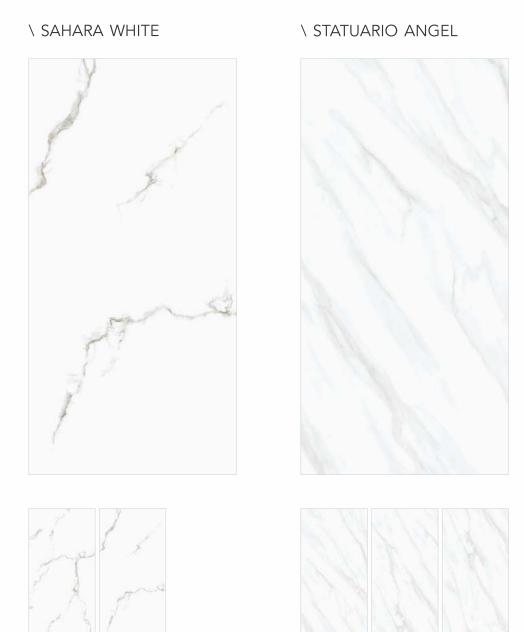








\ ROBINSON WHITE \ STRING WHITE































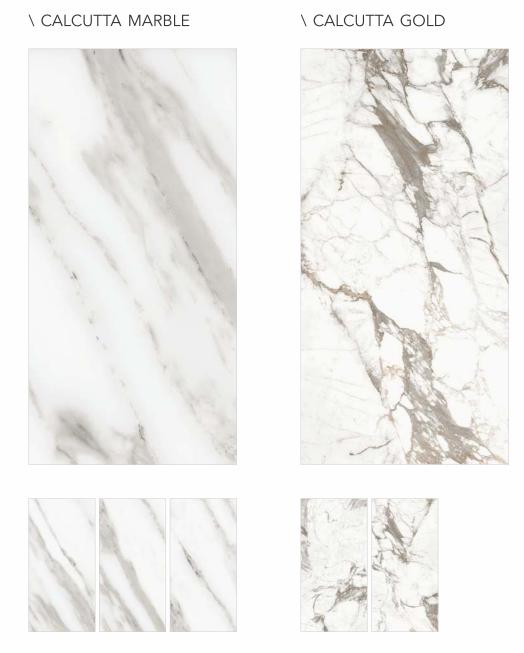








\ STATUARIO YORK \ STATUARIO ONE



Finish \ POLISHED























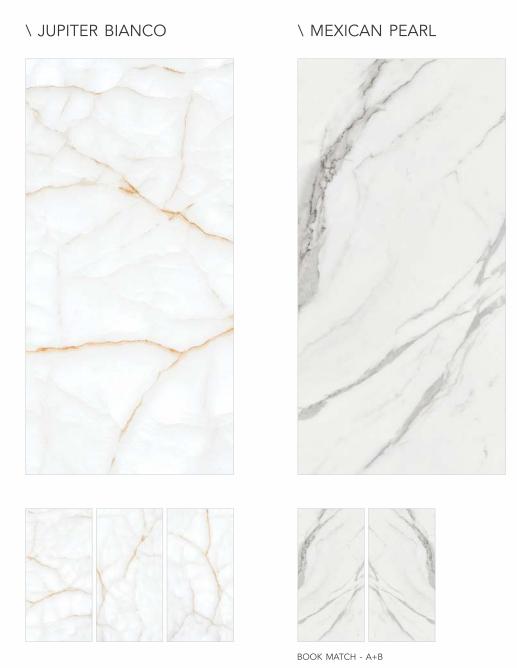








\ ATHENA WHITE \ BIANCO MARMO





































\ JORDAN BEIGE \ JORDAN WHITE



\ ONYX AMBER



















Finish \ POLISHED

\ ONYX YELLOW















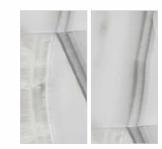


\ ONYX ICE

\ ONYX OCEAN







\ 1041 ONYX



\ ONYX TRAVO





Finish \ POLISHED

Technical features \

NIN. 3MM 9MM 9MM SPACER THICKNESS SPACE COUNTER TOPS CLADDING FACADE































\ ONYX CRYSTAL











Finish \ POLISHED

Technical features \

MIN. 3MM 9MM 2MM LIVING COMMERCIAL SPACE

THICKNESS SPACE COMMERCIAL SPACE





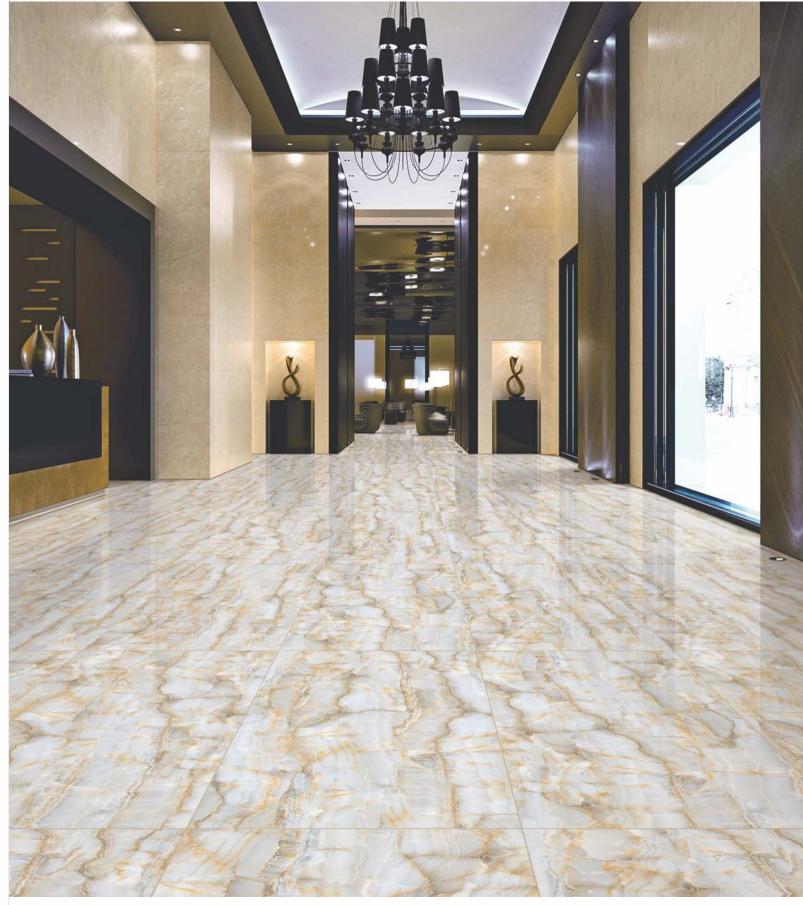












\ CREMA BELLINI











Finish \
POLISHED

Technical features

MIN. 3MM SPACER TH

9MM THICKNESS









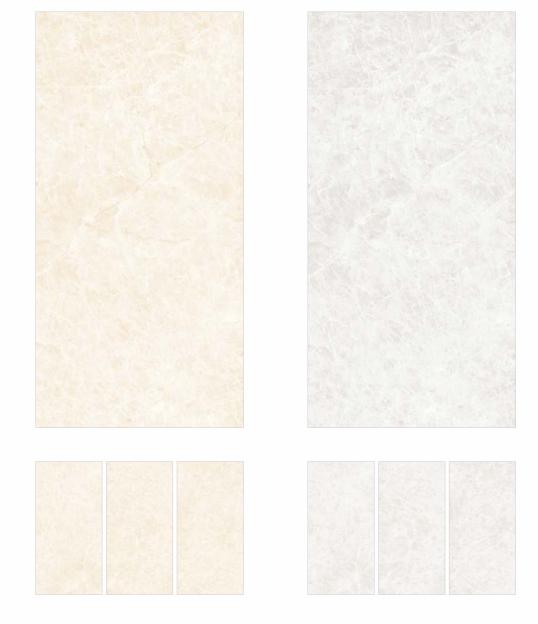












\ SWISS BIANCO

Finish \ POLISHED

Technical features \

| Image: Application of the control of the c















\ SWISS CREMA



















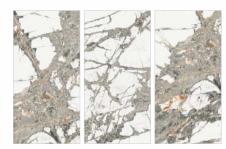
\ ESPANOL PILLAR











Finish \ POLISHED













60x 120cm





\ IRIS BIANCO











Finish \ POLISHED















\ KASHMIR ONICE











Finish \
POLISHED

Technical features

MIN. 3MM SPACER THI

9MM THICKNESS





















Finish \ POLISHED

Technical features \

| Image: Application of the control of the c

































\ CREMA FLURRY











Finish \ POLISHED

























Technical features \

| Image: Application of the control of the c

































\ EXOTIC BEIGE











Finish \
POLISHED

Technical features

MIN. 3MM 9







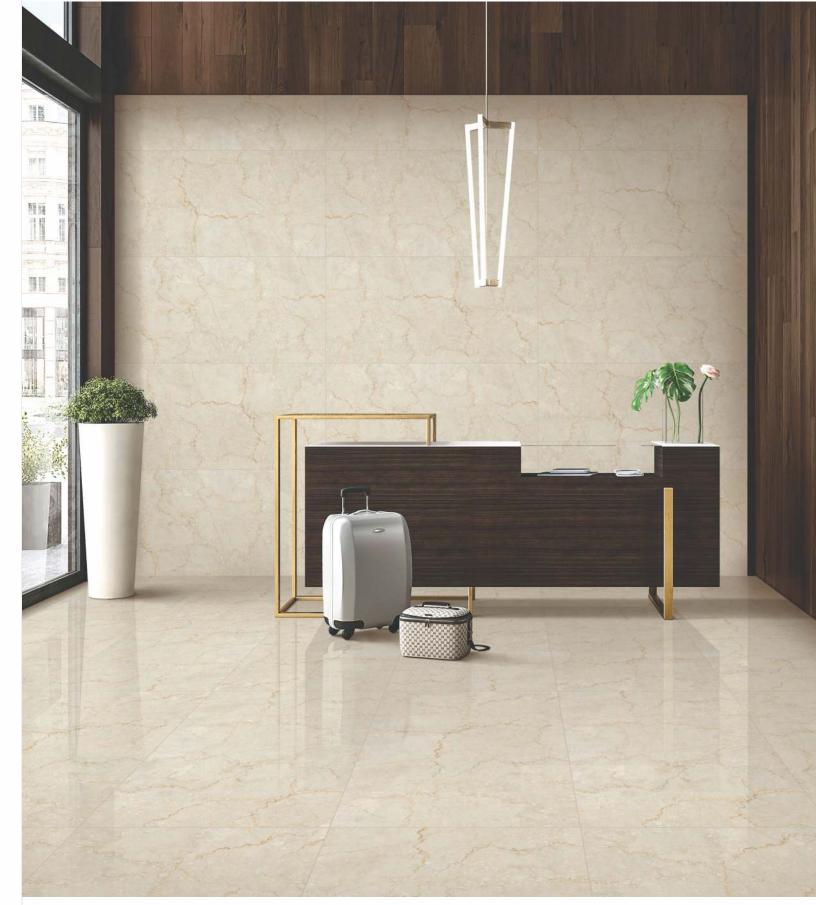




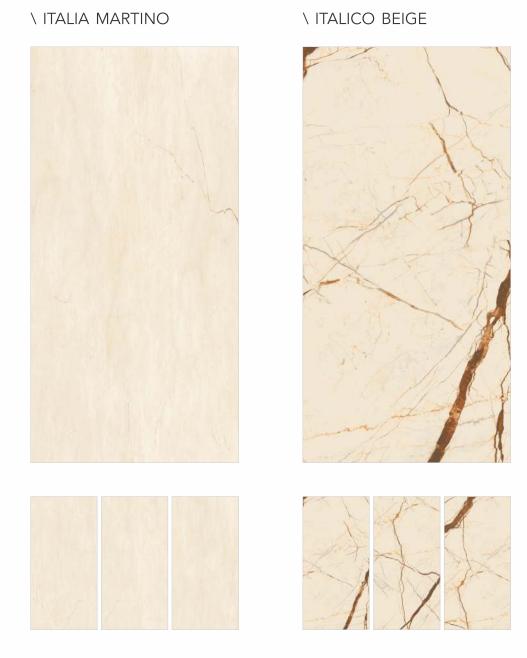








\ COUNTER QUARTZ \ ROYAL BEIGE















































Technical features \

| Image: Application of the control of the c



































\ ARTIC WHITE \ CANVAS LIGHT





Technical features \

| Image: Application of the control of the c



































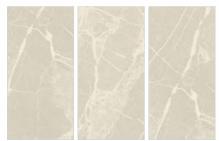


\ THUNDER BEIGE











Finish \
POLISHED

Technical features `

MIN. 3MM SPACER TH

9MM THICKNES







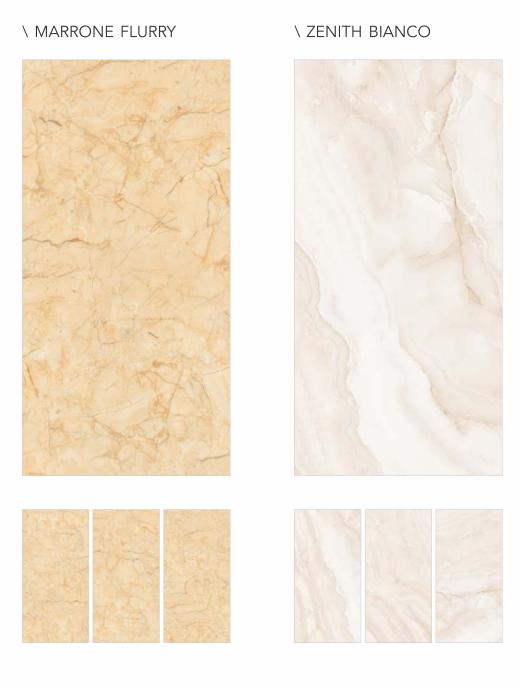
















Technical features \

| Image: Application of the control of the c

































\ EMPERADOR LIGHT \ EMPERADOR GREY





Technical features \

| Image: Application of the control of the c















































































\ BRESCIA BEIGE











Finish \
POLISHED

Technical features

MIN. 3MM

9MM THICKNESS















\ BRESCIA IVORY \ BRESCIA ANTRECITE





Technical features \

| Image: Application of the control of the c





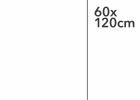
































































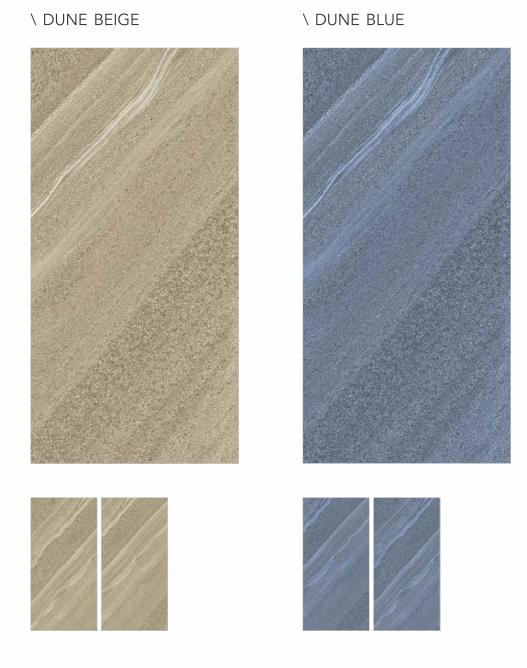








\ DUNE WHITE \ DUNE GREY





POLISHED

Finish \

Technical features \

NIN. 3MM 9MM 9MM SPACER THICKNESS SPACE COUNTER TOPS CLADDING FACADE































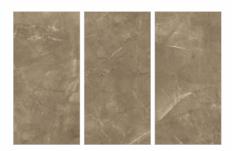
\ TERA BROWN











Finish \ POLISHED

















\ TERRANO MULTI \ AVORIO FLURRY





































\ HIMALIYA ONYX \ MONT SKY





































\ TEXAS BROWN





























Preview of \ ASTEROID LIGHT

\ GREECE BEIGE \ GREECE GREY





Technical features \

| Image: Application of the control of the c















Finish \ POLISHED











Technical features \

NIN. 3MM 9MM 9MM LIVING COMMERCIAL PUBLIC COUNTER WALL SPACE SPACE COUNTER TOPS CLADDING FACADE

\ DYNA FANTA































































\ TRAVERTINO MUSTARD LIGHT \ TRAVERTINO MUSTARD BROWN

























\ TRAVERTINE PEARL \ TRAVERTINE NATURAL





Technical features \

| Image: Application of the control of the c





































\ FRAPPUCCINO LIGHT \ COLUMBIA NATURAL





\ TACO LAVA



















\ CROWN BEIGE



























\ WOODDIC CREMA





Finish \ POLISHED

Technical features \

| Image: Application of the control of the c





























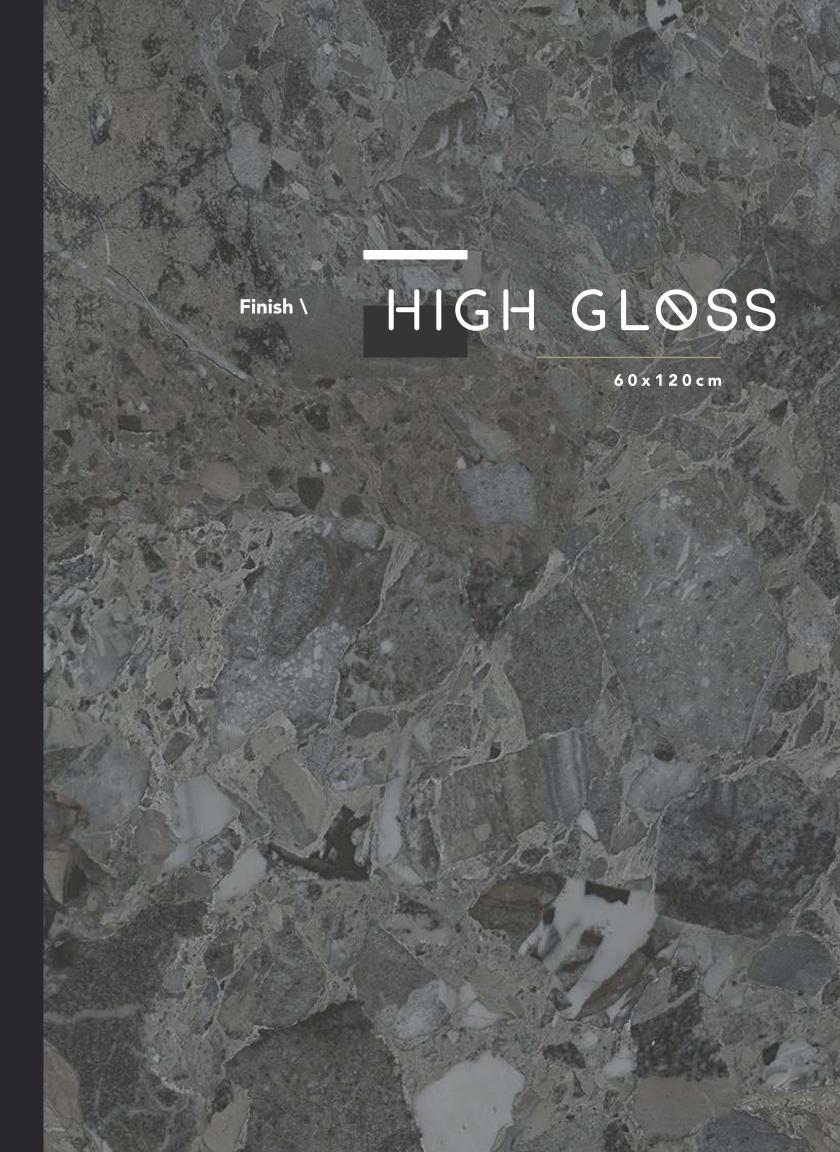




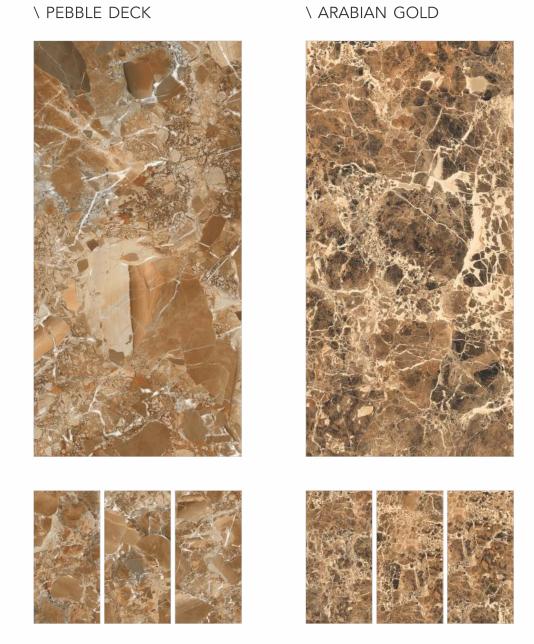




GLA R SLABS



\ ARMANI ORO \ APEN BRONZE



































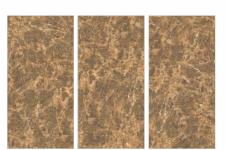


\ EMPERADOR SPARKLE











Finish \ HIGH GLOSS











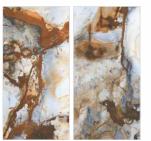




\ EMPERADOR CHOCO \ EMPERADOR CHARCOAL

































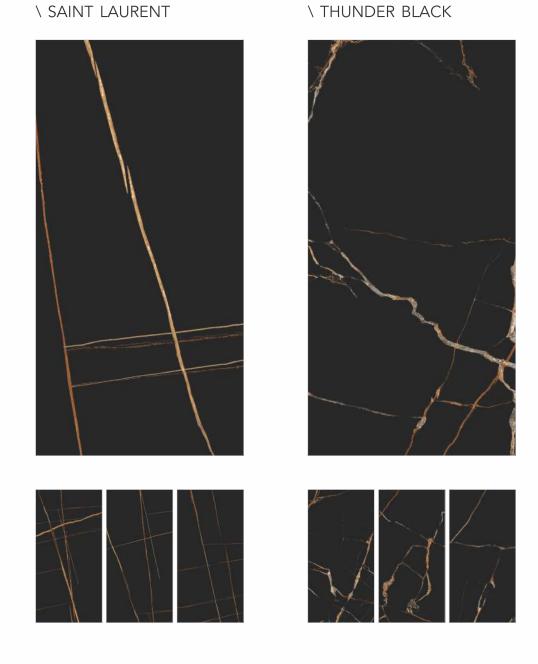








\ PIETRA NATURAL \ PORTORO GOLD





































\ ONYX SUPER \ RAINBOW WHITE

















Finish \ HIGH GLOSS















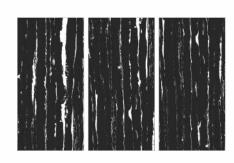
\ ATLAS BIANCO





\ ATLAS NERO





Finish \
HIGH GLOSS

Technical features

MIN. 3MM SPACER TH

9MM THICKNESS





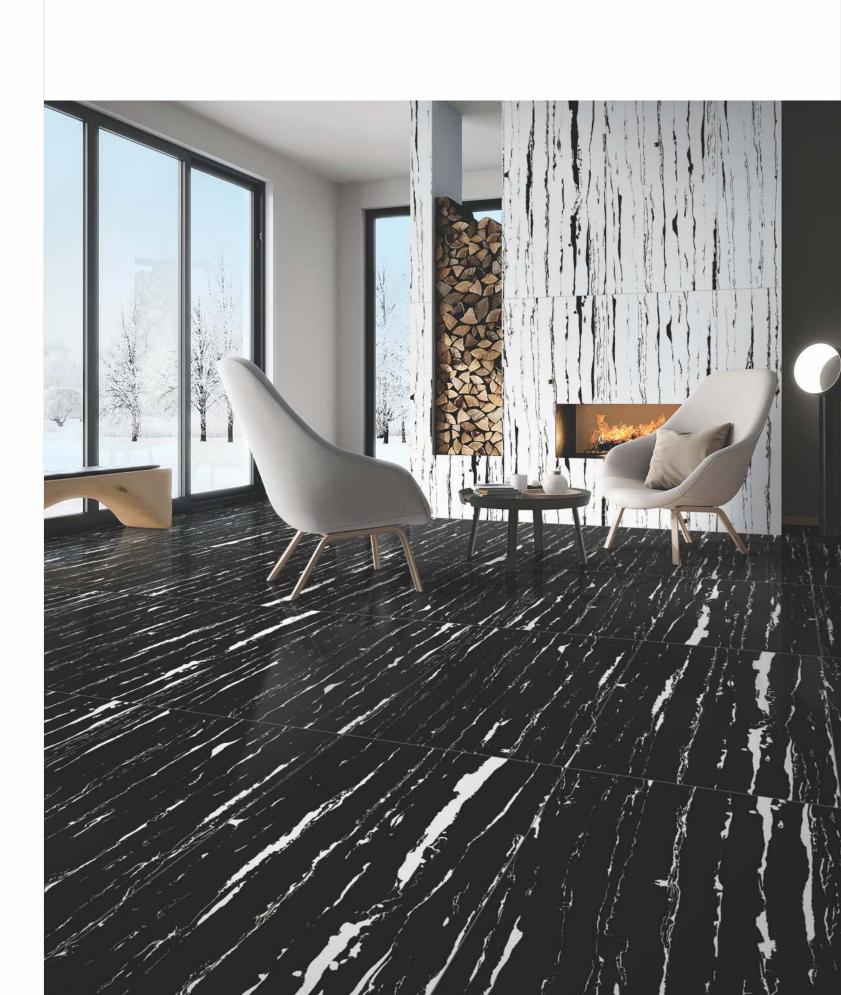




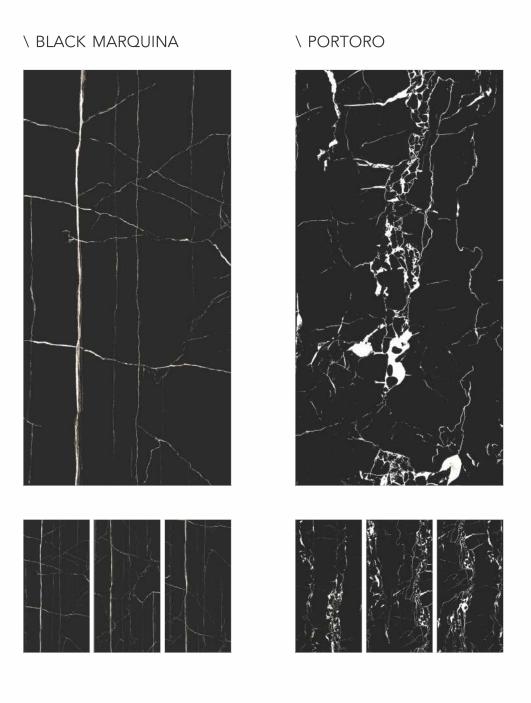


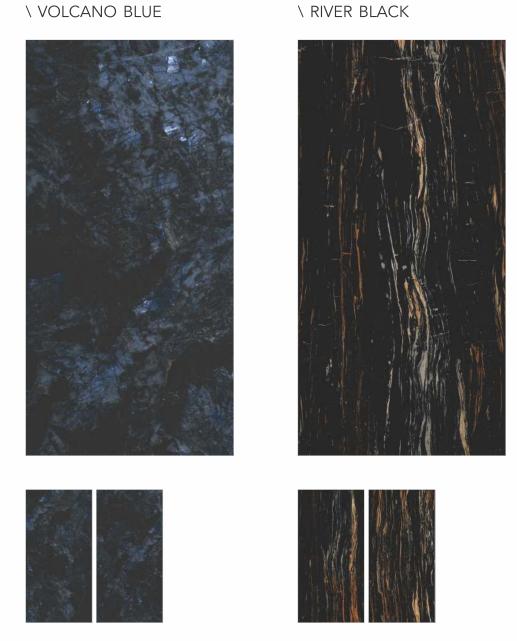






Preview of \ ATLAS NERO

































\ RAINBOW ROCK











Finish \ HIGH GLOSS

















\ COSMOS BLUE











Finish \
HIGH GLOSS

Technical features

MIN. 3MM 9

9MM HICKNESS













60x 120cm



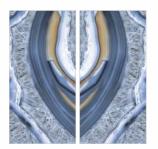


\ ONYX WAVE

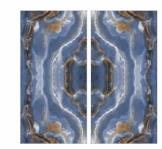


\ ARIZONA AZUL





BOOK MATCH - A+B



Finish \
HIGH GLOSS

Technical features

MIN. 3MM SPACER TH

9MM THICKNESS











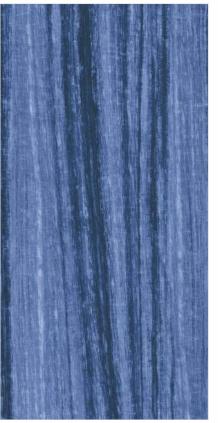




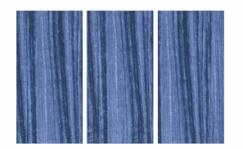


\ AZUL ERA

\ WAVE BLUE









Finish \ HIGH GLOSS

















\ GEM GREY \ FRAPPUCCINO NATURAL



Technical features \

NIN. 3MM 9MM 9MM SPACER THICKNESS SPACE COUNTER WALL SPACE SPACE TOPS CLADDING FACADE



































\ BLACK GOLD

\ ASHIDA BLUE





\ ANGEL BLUE



\ ANGEL NERO



Finish \ HIGH GLOSS

































\ CITY BLUE

\ CITY NERO









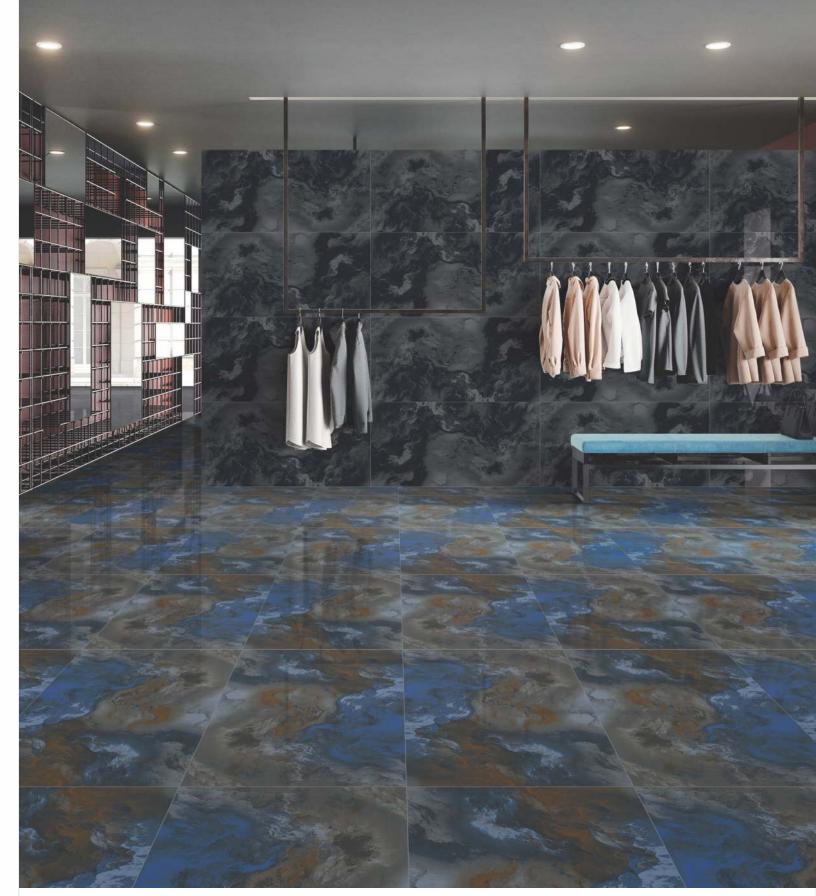












METRO COL ITAN



\ GLINT BOTTOCINO











Finish \ GLINT



















\ GLINT STATUARIO SPIDER \ GLINT STONA



\ GLINT WOOD

Finish \ GLINT

Technical features \

MIN. 3MM 9MM 9MM SPACER THICKNESS SPACE SPACE SPACE COUNTER WALL BUILDING FACADE



















Finish \ GLINT





\ GLINT TRAVERTINE BEIGE



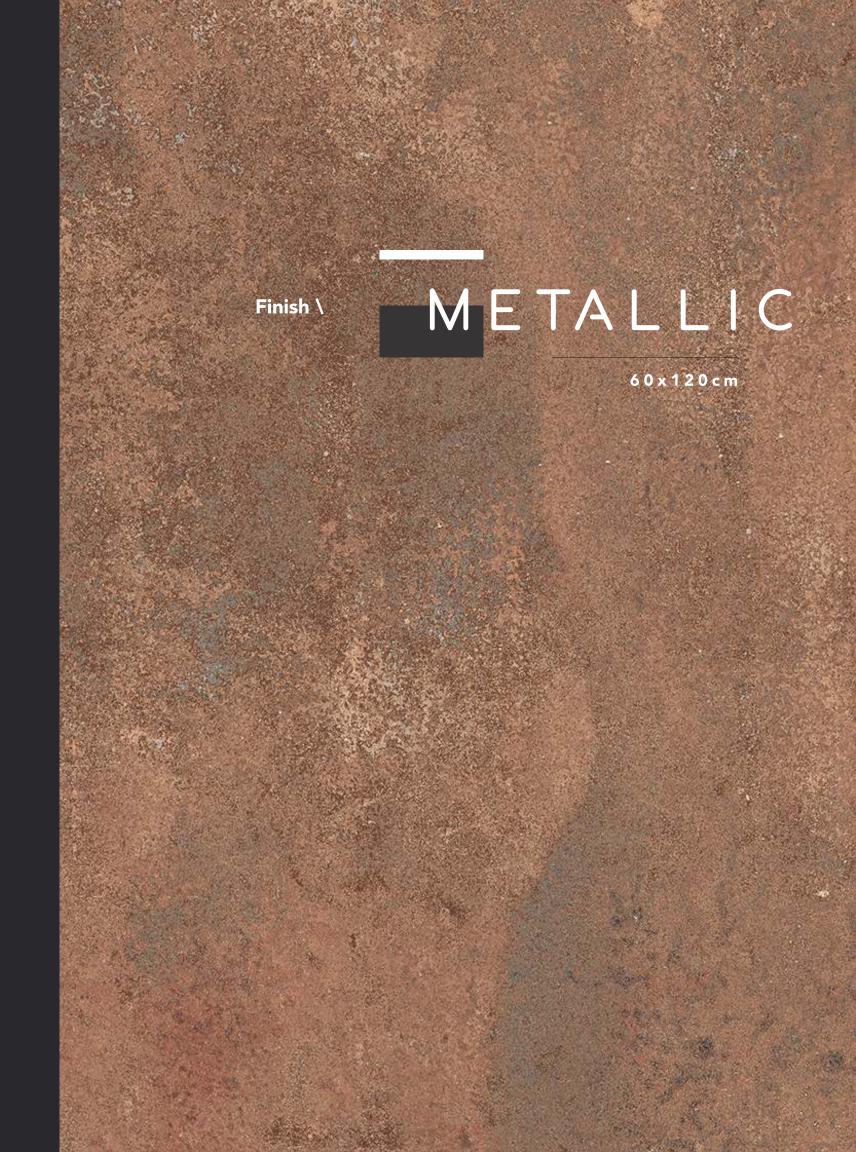




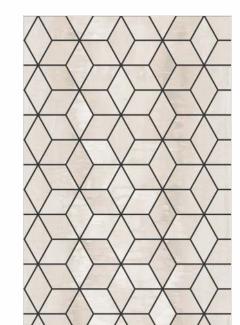




NA TU SLABS



\ FOSSIL BROWN



\ HEXA METAL





Finish \ METALLIC

















\ RUGGINE ALLOY



\ LITHIUM BLUE

















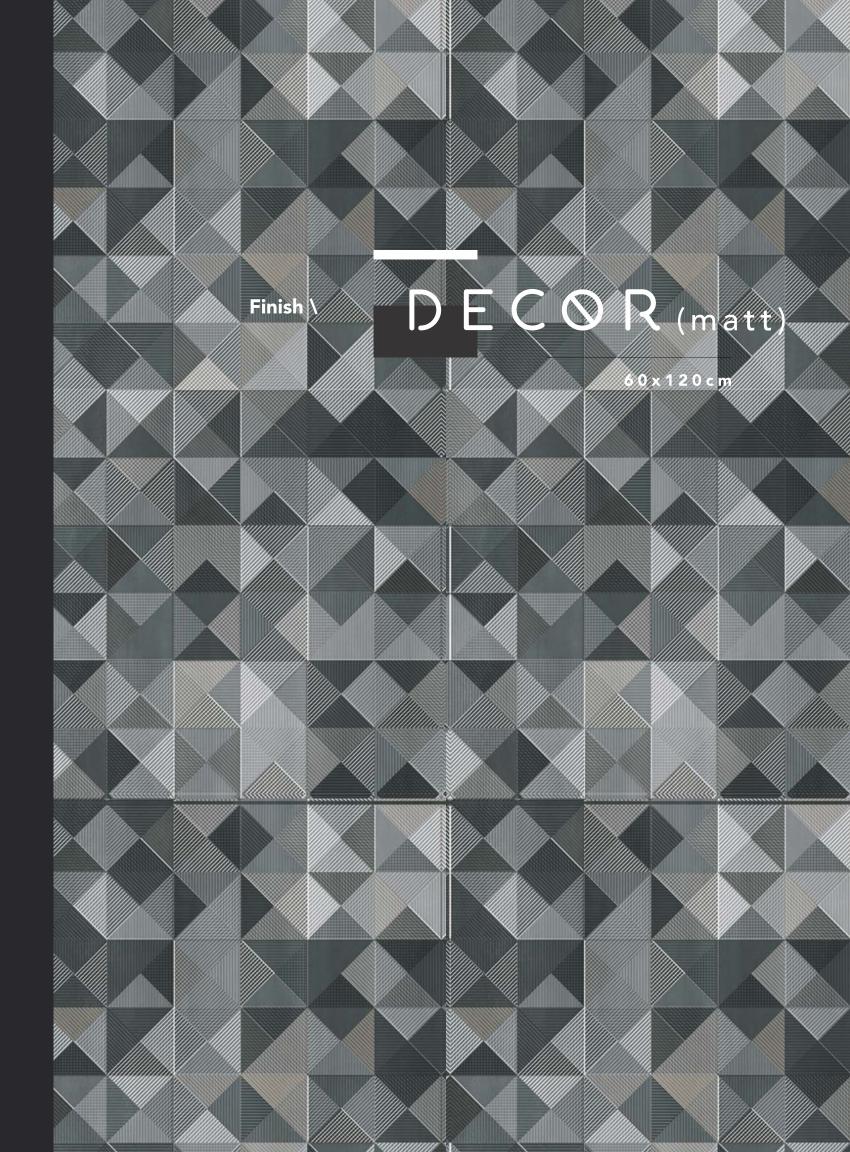






Preview of \ RUGGINE ALLOY

CRE ATI SLABS



\ MOLTO PIXEL



\ MOLTO WAVE















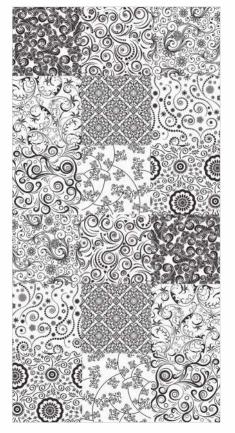






\ VOLANTE

\ EPOQUE





\ ARIA

\ MEZZO





Finish \ MATT

























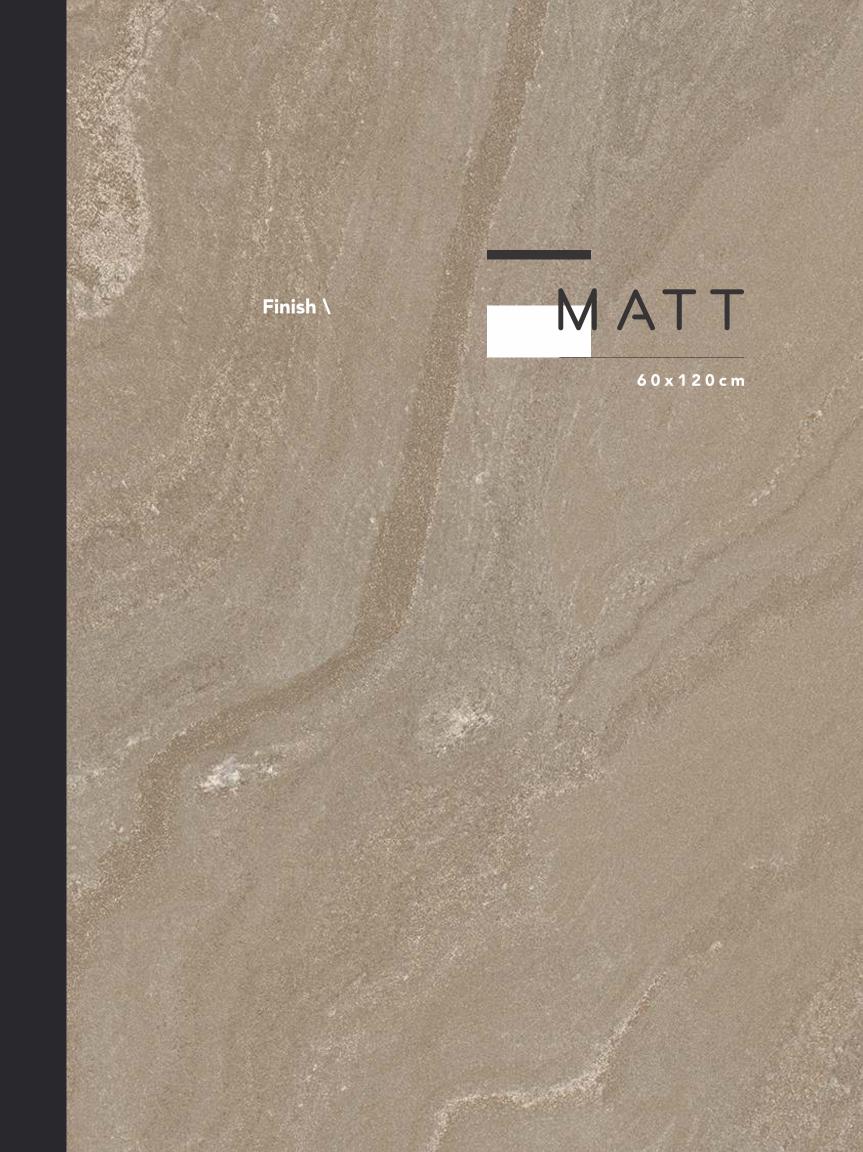








SIM
PLI
CITY
SLABS



\ STATUARIO ONE - SM \ REGAL CARRARA - SM





































\ SILK LIGHT \ SILK BROWN

Finish \

Technical features

MIN. 3MM

9MM THICKNESS















\ MISTY LIGHT \ MISTY BROWN



































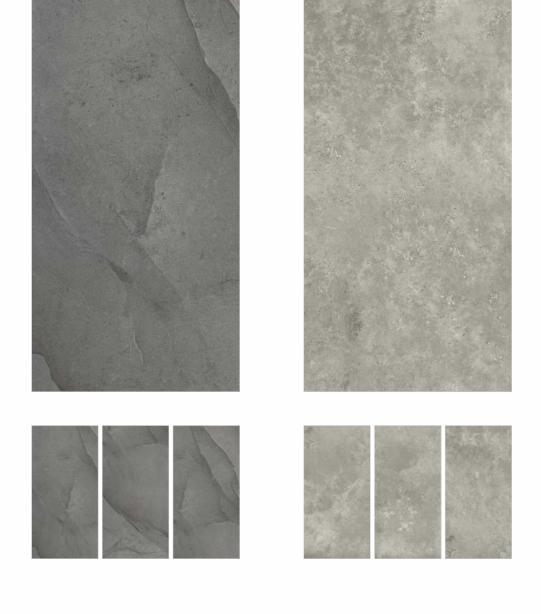




60x 120cm

Finish \

MATT



\ BRAZILIA GREY

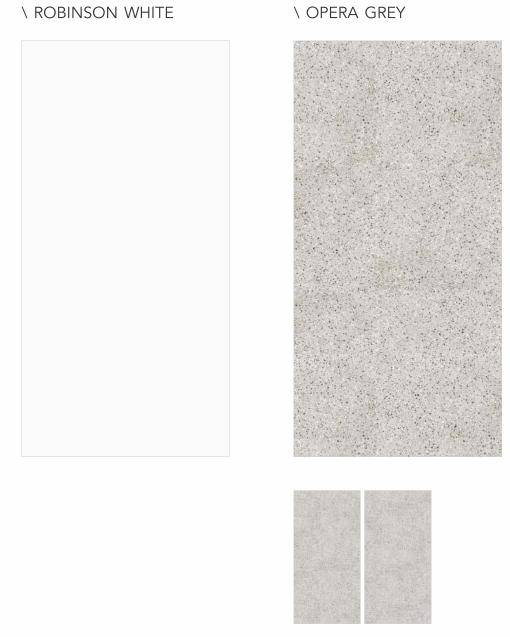
60x 120cm

\ LEVIS GREY

Finish \

MATT





Technical features \

| Image: Application of the control of the c

























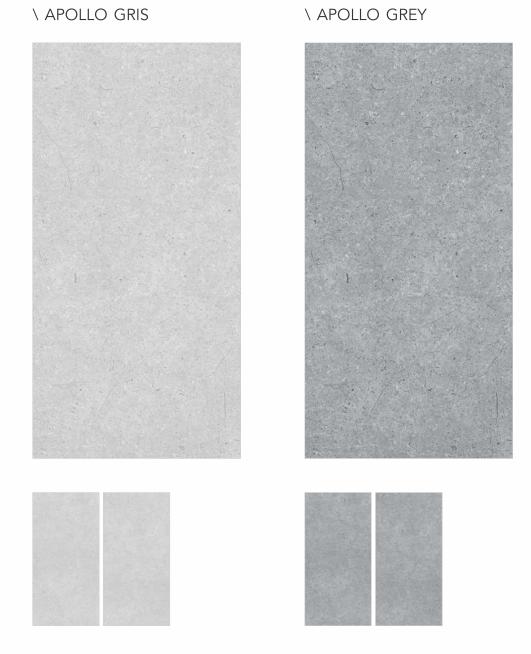












Technical features \

| Image: Application of the control of the c





















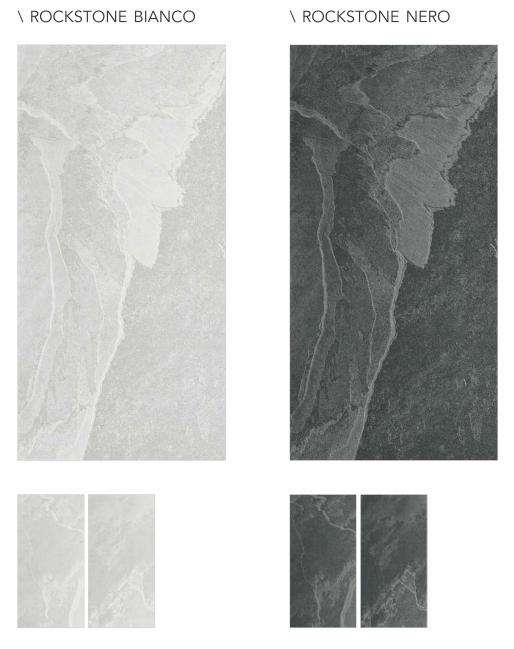








\ ROCKSTONE BEIGE \ ROCKSTONE BROWN





















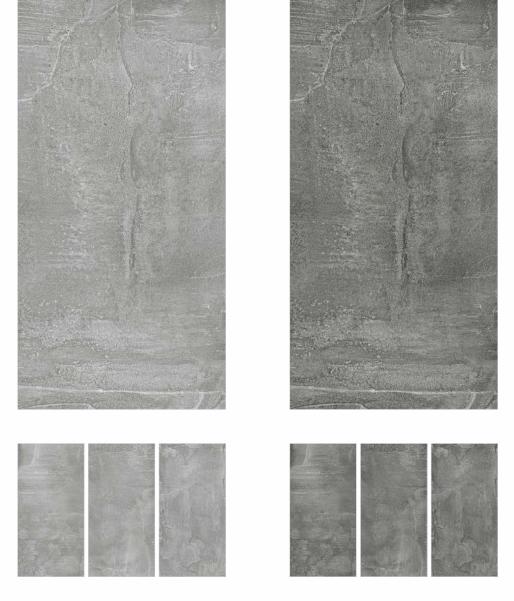








\ AMAZON BROWN \ AMAZON OLIVE



\ AMAZON GRIS

Finish \ MATT

















Finish \ MATT

\ AMAZON GREY





















Technical features

IIN. 3MM 9MM

PMM LIV













Technical feature







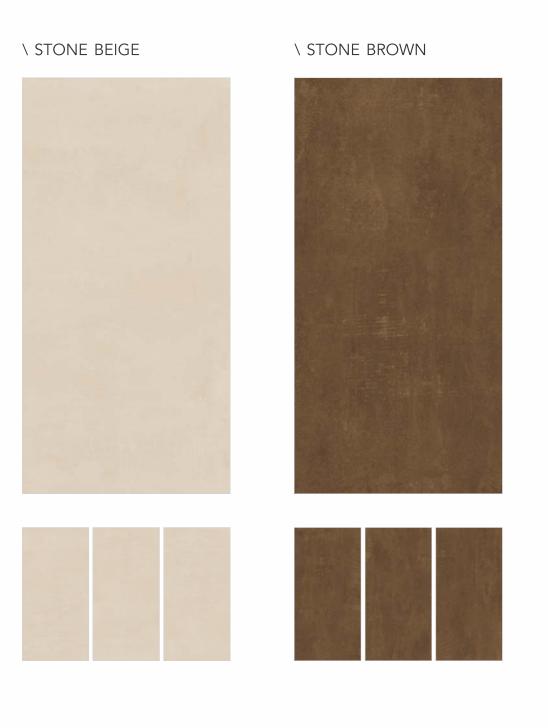


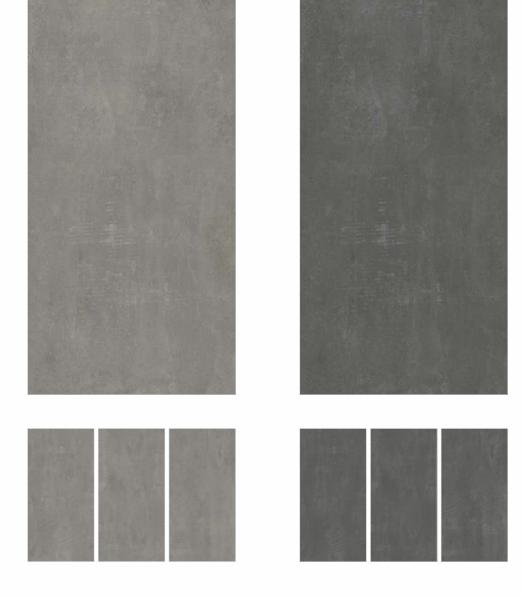












\ STONE GREY

Finish \ MATT

Technical features \

| Image: Application of the control of the c























\ STONE CEMENTO











\ STONE WHITE \ PINE WOOD





Technical features \

MIN. 3MM 9MM 9MM SPACER THICKNESS SPACE SPACE SPACE COUNTER WALL BUILDING FACADE































\ ROSEWOOD \ HABITAT OCRE

Finish \ MATT Technical features \

| Image: Application of the control of the c















\ MAPLEWOOD BEIGE \ MAPLEWOOD CHOCO



\ SAFARI LIGHT

MATT

Finish \

Technical features \

| Image: Application of the control of the c

















Finish \ MATT





\ MAPLEWOOD GREY













TECHNICAL SPECIFICATIONS

CHARACTERISTICS	STANDARD AS PER ISO-13006/EN14411 GROUP BIA	MEAN VALUE OF OUR PGVT	MEAN VALUE OF OUR GVT	TEST METHOD			
REGULATORY PROPERTIES							
Deviation in length & width	±0.5 %	±0.1 %	±0.1 %	ISO-10545-2			
Deviation in thickness	±5.0 %	±4.0 %	±4.0 %	ISO-10545-2			
Straightness in side	±0.5 %	±0.1 %	±0.1 %	ISO-10545-2			
Rectangularity	±0.6 %	±0.1 %	±0.1 %	ISO-10545-2			
Surface flatness	±0.5 %	±0.2 %	±0.2 %	ISO-10545-2			
Color difference	Unaltered	No change	No change	ISO-10545-16			
Glossiness	As per mfg.	Min. 90%	Min. 4%	GLOSSOMETER			
SURFACE MECHANICAL PROPERTIES							
Water absorption	< 0.50 %	< 0.05 %	< 0.05 %	ISO-10545-3			
Apparent density	> 2.0 g/cc	> 2.10 g/cc	> 2.10 g/cc	DIN 51082			
MASSIVE MECHANICAL PROPERTIES							
Modulus of rupture	Min. 35 N/mm²	Min. 40 N/mm²	Min. 40 N/mm²	ISO-10545-4			
Breaking strength	Min. 1300 N	Min. 2000 N	Min. 2000 N	ISO-10545-4			
Impact resistance	as per mfg.	Min. 0.55	Min. 0.55	ISO-10545-5			
SURFACE MECHANICAL PROPERTIES							
Surface abrasion resistance	as per mfg	Min. Class-3	Min. Class-4	ISO-10545-7			
MOH's hardness	as per mfg	Min. 4	Min. 5	EN 101			
THERMO HYDROMETRIC PROPERTIES							
Frost resistance	No damage	No damage	No damage	ISO-10545-12			
Thermal shock resistance	No damage	No damage	No damage	ISO-10545-9			
Moisture expansion	Nil	Nil	Nil	ISO-10545-10			
Thermal expansion (COE)	Max. 9.0x10 ⁻⁶	Max. 6.5x10 ⁻⁶	Max. 6.5x10 ⁻⁶	ISO-10545-8			
Crazing resistance	^a s per mfg.	Min. 10 Cycle	Min. 10 Cycle	ISO-10545-11			
CHEMICAL PROPERTIES							
Chemical resistance	No damage	No damage	No damage	ISO-10545-13			
Stain resistance	Resistant	Resistant	Resistant	ISO-10545-14			
SAFETY PROPERTIES							
Slip resistance	^a s per mfg.	> 0.40	> 0.40	ISO-10545-17			
Fire resistance	^a s per mfg.	Fireproof	Fireproof	N. A.			
Lead & Cadmium given off by glazed tiles	as per mfg.	Doesn't yield Pb & Cd	Doesn't yield Pb & Cd	ISO-10545-15			

PACKING DETAILS

Sr. No.	Size	Thickness (approx*)	Pieces / Box	Area (app	/ Box rox*)	Packing
1	60x120cm	9 to 9.5 mm	2 pcs.	1.44 sq. mtr.	15.50 sq. ft.	Вох

EXCLUSIVE FEATURES OF OUR TILES

AS FLOOR TILES FOR CONTINUOUS SURFACES WITH ALL THE GUARANTEED SAFETY THAT OF 9mm THICKNESS PROVIDES.

AS WALL TILES TO DRESS PRESTIGIOUS SPACES AND SCENIC WALLS WITH A SINGLE SLAB AND VERTICAL INSTALLATION.

AS FOR OUTDOORS FOR VENTILATES FACADES THAT ARE LARGE AND ENDURING.

AS DESIGN APPLICATIONS AS A BACKSPLASH, KITCHEN TOPS, COUNTER TOPS AND SPECTACULAR EXPANSES.

UNALTERABLE OVER TIME:

Colour and brightness does not change over time.

STAIN, DETERGENT AND SCRATCH RESISTANT:

Resistant to chemicals: it is non-porous and resistant to acids.

HIGH BREAKING LOAD STRENGTH:

Resistant to loads, compression and bending.

EASY TO HANDLE AND TO MAINTAIN:

Doesn't require special water proofing treatments after installation.

CONSISTENCY OF SURFACE IN SUBSEQUENT PRODUCT RUNS:

Shades and graphics remain the same and are completely reproducible in every subsequent production run.

THE EXCELLENCE OF PORCELAIN STONEWARE:

The expressive aesthetics of large slabs combined with the properties and advantages of Vitrified stoneware in 9mm thickness, offering the same technical performance as more traditional formats, actually surpassing those of the natural material.

MORE IMPACT FOR INTERIOR & ARCHITECTURE:

Infinity Slab dictates the elegant and residential spaces where luxury and contemporary design meet. Perfect for creating floors and walls of tremendous impact in prestigious hospitality venues, in wiliness areas and in dining areas.

MAJESTIC SPLENDOUR:

The Infinity Slab 120x240mm, 120x120mm and 80x160mm Vitrified stoneware sizes make INFINITY SLAB a veritable furnishing and design element. The large slabs can be combined with the other marble effect surfaces of Ours for elegant chromatic compositions

POWERFUL BEAUTY:

Large vitrified stoneware slabs that reinterpret the luxury of marble can be used outdoors in extensive ventilated facades for total continuity with the indoor spaces, or for outdoor commercial spaces of the utmost visual impact.

SEDUCTIVE DESIGN:

The myriad of advantages of vitrified stoneware include resistance to slipping, resistance to stains and detergents, the visual potential of the large 120x240mm, 120x120mm and 80x160mm sizes and the precious look of marble, for contemporary spaces of tremendous aesthetic seduction.

MARVELLOUS MASTERPIECE:

The large size marble-inspired vitrified stoneware slabs reinterpret a selection of prestigious natural marble with absolute fidelity, creating planning harmony with the Marvel decor for residential and commercial ambiences of strong character.

EXCELLENT PRIVILEGE:

Veining and natural shading lend character to wide expanse of marble effect porcelain stoneware surfaces of high graphic variability and realistic aesthetics rich in detail. The honed surface exudes the luminosity and unevenness of the matter of inspiration, making floors, panels and expenses polished and mirror-like.

PACKAGING SYSTEM:

Specific types of packaging are used to store and transport slabs with the maximum safety. Slabs are packed in customised Pallet. They can also be placed in specially designed A-frames for transportation.

PACKAGING IN PALLET:

For orders of two or more articles in the same size or in multiple modular sizes - slabs must be placed in the same pallet, until full. Pallet should be shipped filled to capacity.

PACKAGING IN A-FRAMES:

A-frames are only used when requested by the customer.

For orders for two or more articles in the same size or in multiple modular sizes slabs must be placed in the same A-frame, until full.

A-frames should be shipped filled to capacity.

HANDLING:

Crates must be handled one at a time. Only if they are identical, they can be stacked in piles of up to 10.

Handling Crates by the Long Side

This is the recommended option. Crates must be handled using forks at least 1.2mtr. long extended to their maximum possible width to cover as much of the surface of the crate as possible.

Handling Crates by the Short Side (B)

Crates must be handled using forks at least 2.1mtr. long extended to their maximum possible width to cover as much of the surface of the crate as possible.

EQUIPMENT:

When handling slabs, it is essential always to use the equipment specifically designed for use with large ceramic slabs.

Suction cup handling bars

Applying this device to the slab increases its rigidity. This allows it to be moved, with the aid of special trolleys, in conditions of maximum safety.

Reinforced trolley

Use of these trolleys is strictly recommended when handling slabs with holes for the passage of wiring or pipes.

Workbench with aluminium profiles

A workbench with aluminium profiles should always be used.

ADVICE FOR LAYING AND MAINTENANCE:

Laying

Before laying on any surface, make sure that the material is appropriate and sufficient in terms of quantity, shade and work-size to suit the laying needs. All regulations and precautions concerning the correct execution of the works must be followed (preparing the bed, grout or adhesive composition, respect for drying times, position of the expansion joints, beating, etc...)

Laying with adhesives

Laying must be done by qualified staff using appropriate equipment. The surface to be laid (screed) must be perfectly level. Maximum recommended value no more than 3mm for an uneven surface measured with a 2mtr. ruler. The surface to be laid must be well seasoned, dust-free and with no visible cracks. During laying the use of appropriate lighting is strongly recommended. The choice of adhesive depends on the type of tile (type and size), the type of surface laid on and the type of foreseen use. Check that the tiles are laid correctly before the adhesive dries in order to facilitate any required corrections.

Laying with fresh mortar

Laying with fresh cement-based mortar or "thick layers" is not recommended for sizes more than 30 cm long and with non-absorbent supports

Joints

Joints are very important elements for maintaining a good tiled surface, it is recommended to make use of the collaboration and/or advice of a professional layer. The company declines all responsibility for laying without joints; minimum joint laying has a gap of 2 mm. The joints must be positioned:

on structural joints;

between the floor and the wall (perimeter joints);

between one tile and another (laying joints);

between the tiles and other materials (e.g. combinations of ceramics/linoleum/wood)

Grouting laid surfaces

Before grouting wait for the adhesive to dry completely and make sure that the laying joints are empty and free of all traces of adhesive and/or dust. Grout small areas at a time (4-5 sq. mtr.). This is particularly important for structured products, non-slip and polished surfaces. Remove excess grout from the tiles using diagonal movements when the product is still damp and remove all residues, particularly for external surfaces. Clean carefully using a sponge dampened in clean, limpid water and go over the whole surface, including the gaps, with a damp cloth. For grouting which has a strong colour contrast to the laid tiles, test the grout on a small, hidden area. When using epoxy grouts, clean with a sponge and plenty of water. The reaction and hardening times of these products make it impossible to remove any residues once they have hardened. The day after grouting, completely clean the surface with an alkaline detergent.

Consult the grout manufacturers to verify the correct choice of grout for the type of tile.

Cleaning and maintenance after laying

Work sites are deemed to be completely finished once they have been cleared of all tools and materials used during the operations. To reduce the risk of damaging tiled surfaces, protect them and avoid the presence of abrasive materials (dust and residues from operations carried out after laying) as far as possible.

Initial cleaning

Washing after laying is of fundamental importance to all operations carried out afterwards and to assure correct maintenance. Careful initial cleaning keeps floors beautiful and protected longer and is done once only before using the floor. Initial cleaning should be carried out 4-5 days after laying, and in any case no longer than 10 days after laying and grouting. The grouted and cleaned surface may have a concrete film which cannot be removed using water alone, and therefore an acid-based product, suitably diluted (from 1:10 to 1:4 in cold water) should be used, following the manufacturer's instructions.

The first operation is to wet the tiled surface and particularly the gaps (grout is not usually acid-resistant). Spread the prepared acid solution and leave for a short time (2 minutes). Do not allow the applied product to dry. Remove the solution using a brushing machine (with a non-abrasive disk), wet vac or other means and/or manually, then rinse well. It should be remembered that machine cleaning (which is particularly recommended for textured products and large surfaces) must always be completed by hand in tight corners, along walls and any spaces that the brushing machine cannot easily reach. It is always advisable to test the resistance of the product to acids on an unlaid tile or a small hidden surface; particularly for lapped or polished products. It is not recommended to use cleaning products containing hydrofluoric acid (HF) or its derivates.

Ordinary cleaning

Ordinary cleaning removes dirt and marks and restores the surface to its original appearance. Porcelain stoneware tiles do not require protective treatment, and a thorough, systematic clean is sufficient to maintain the surface. Careful cleaning must be done by washing normally using hot water, a cloth or soft sponge and, if required, neutral detergents. For large areas, industrial washing machines can be used, with completion by hand where required.

Recommendation

Do not rub the surfaces using abrasive tools, such as metallic sponges or hard brushes, which could scratch them or leave indelible marks; Grease and oil residues can be removed using detergents using organic or alkaline solvents (pH>9) followed by careful rinsing; Avoid the use of soap as this tends to leave a slimy layer, particularly when used with hard water:

Do not use products containing wax or shining agents;

Avoid the use of abrasive detergents on shiny and/or polished surfaces; they may be used on matt materials, checking first on a small hidden tiled area. Generally speaking, when using any non-neutral detergent, check first on an unlaid tile or a small hidden portion of the floor.

CUTTING SPECIFICATIONS

Cutting with disk

In order to do a correct cutting into one slab 12mm (1/2") it is recommended the use of segmented cutting disks and specifications as described below.

Disk diameter	RPM	Cutting speed (m/min)-(feet/min)
300 mm - 12"	2600 rpm	1/2 m/min - 4 feet/min
350 mm - 14"	2300 rpm	1/2 m/min - 4 feet/min
400 mm - 16"	1900 rpm	1/2 m/min - 4 feet/min

To ensure correct finishes, it is recommended lowering the speed at both ends to 25% 0.3m/min - 1 feet/min. If the cutting also requires beveling it is also recommend to slow the speed in the cutting path to 0.6 m/min - 2feet/min.

In order to avoid stress into the slab, it is imperative the use of cutting surfaces that are perfectly levelled and good disk refrigeration. The disk must have a direct application to the cutting edge with refrigeration liquid or water during all the operation.

For inner cutting, as it has been said before, is mandatory the prior drilling at the corners to ensure a 5mm - 3/16" radius. Therefore, the drill must have 10 mm - 6/16" diameter or more.

Water iet cutting

Before starting the waterjet cutting it is advisable to secure the surface and check the flatness of the slab on the support structure for cutting.

Unless necessary (Ex. to create a cavity), the cut must begin and finish outside the slab, always respecting 50 mm - 2" of perimeter during the cutting to avoid accumulation of stresses. The pressure should not exceed 4000 bar and the linear cutting speed should be around 0.6 m / min - 2 feet / min

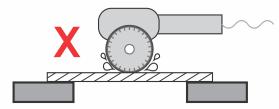
As long as the technical capacity of the cutting machine allows it, it is advisable to finish all the cuts towards the edge of the slab and avoid all the endings at the central area of the slab.

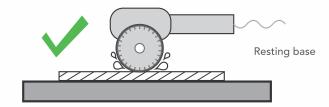
Cutting stresses

In order to minimize the residual stresses in a slab it is advisable, regardless of the cutting method employed, to remove 25~mm - 1" from the total perimeter of the slab.

This not only mitigates the future stresses but also eliminates all possible stress that the material has accumulated during its manufacture, handling or transport until is finally done any operation into the slab.

Cutting





Drilling

