

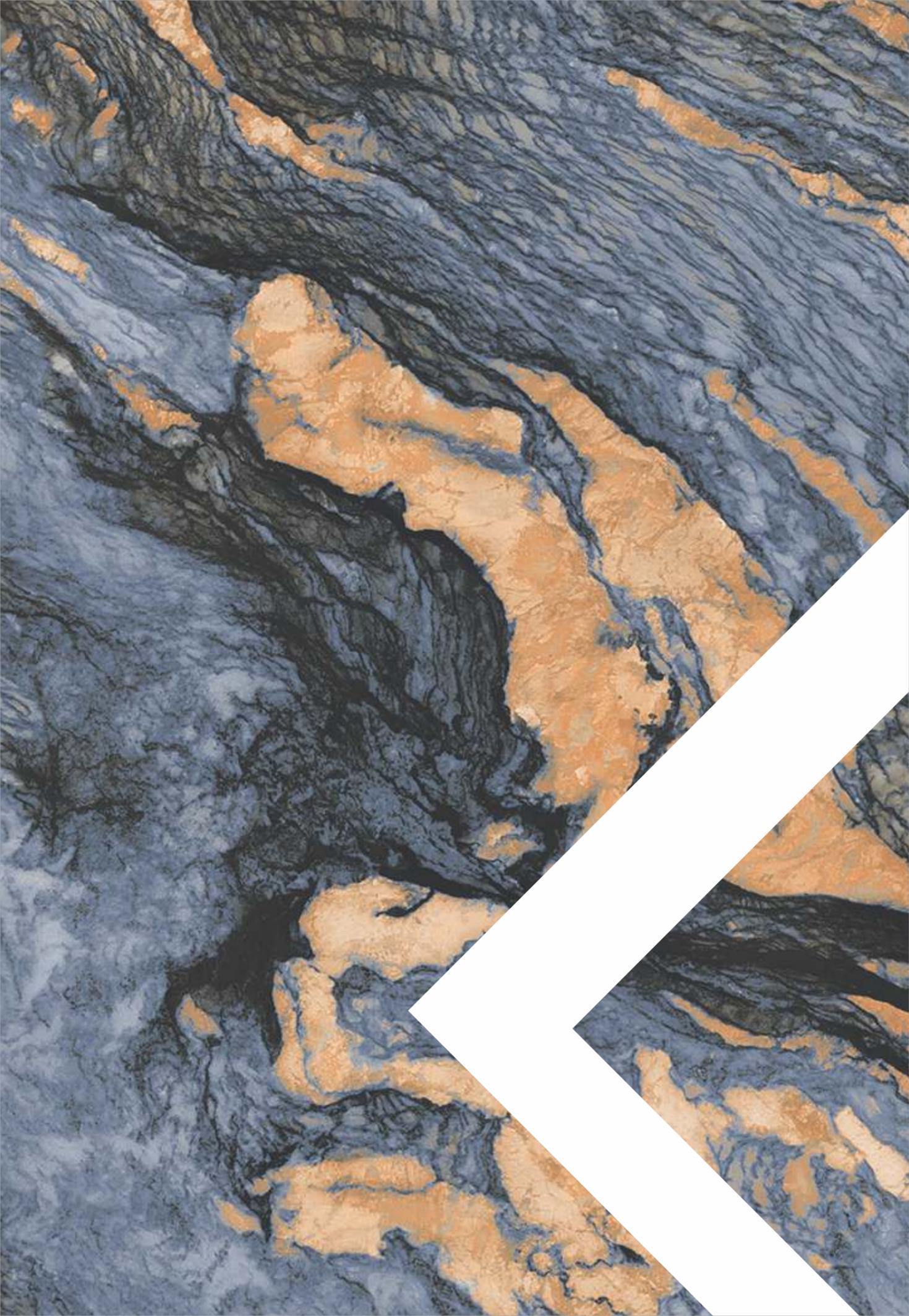
120x120cm

PRODUCT BOOK
YEAR \ 2019 - 2020

Defination of dimension

AN ASPECT OR FEATURE OF A THING.

A MEASURABLE EXTENT OF
SOME KIND,
SUCH AS LENGTH, BREADTH,
DEPTH OR HEIGHT.





Step into the
new dimension of
infinity slab

Our Slab is a new large-size our project developed
to explore new frontiers of Vitrified Stoneware
surfaces and to expand design and customization
possibilities with an incredibly versatile, resistant
and light material.

Shape your ideas with infinity slab

Infinity Slab is a revolutionary new hi-tech product that lets you customized to any large-sized space.

INTERIOR & DESIGN



FLOORS, WALLS & STAIRS



VENTILATED FACADE



FLAT & CURVED WALL

We offer integrated solutions for flooring and wall cladding, technical applications, ventilated facades, raised floors, tactile floors and outdoor surfaces. A complete and wide-ranging offer, supported by more than 30 collections that can be mixed and matched with a wide range of sizes, colours and surfaces to design any type of commercial and residential space.

SHELVES & CONSOLE

TOPS & KITCHEN

DOORS & SLIDING WALLS

Choose your sizes with infinity slab



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



Random
faces



Min. 3mm
spacer



9mm
thickness



Infinite design &
size format



Versatile
slab



Natural
stone look



Fewer
grout lines



Easy to install &
maintain



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

Cruso's cutting-edge production system combined with the high level of expertise and professionalism of the business units and comprehensive range of products allows it to effectively meet all design and commercial requirements. The company's solid structure is able to meet the demands of an ever-evolving market, by offering an effective, accurate and high-quality services.



The slabs are obtained through a vitrification process, i.e. the complete fusion of sand, quartz, feldspar, kaolin, clay and natural colouring oxides to form a single material: these raw materials are fired at temperatures above 1200°C to create a compact and solid product with exceptional hardness and unparalleled mechanical properties. slabs meet the criteria of innovative architecture, able to perfectly combine striking aesthetics with high technological performance.

Choose your surface 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.

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.

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.

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.

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.

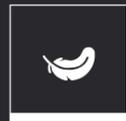
MATT

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.

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.

Get advantage of technical characteristics with infinity slab



LIGHT WEIGHT



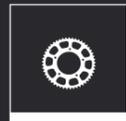
FLEXIBLE STRENGTH



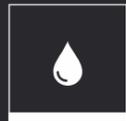
CHEMICAL RESISTANCE



FLEXURAL STRENGTH



WEAR RESISTANCE



WATERPROOF SURFACE



RESISTANCE TO FIRE



FROST RESISTANCE



IMPACT RESISTANCE



HYGIENIC SURFACE



SCRATCH RESISTANCE



ECO FRIENDLY



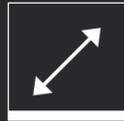
RECTIFIED BODY



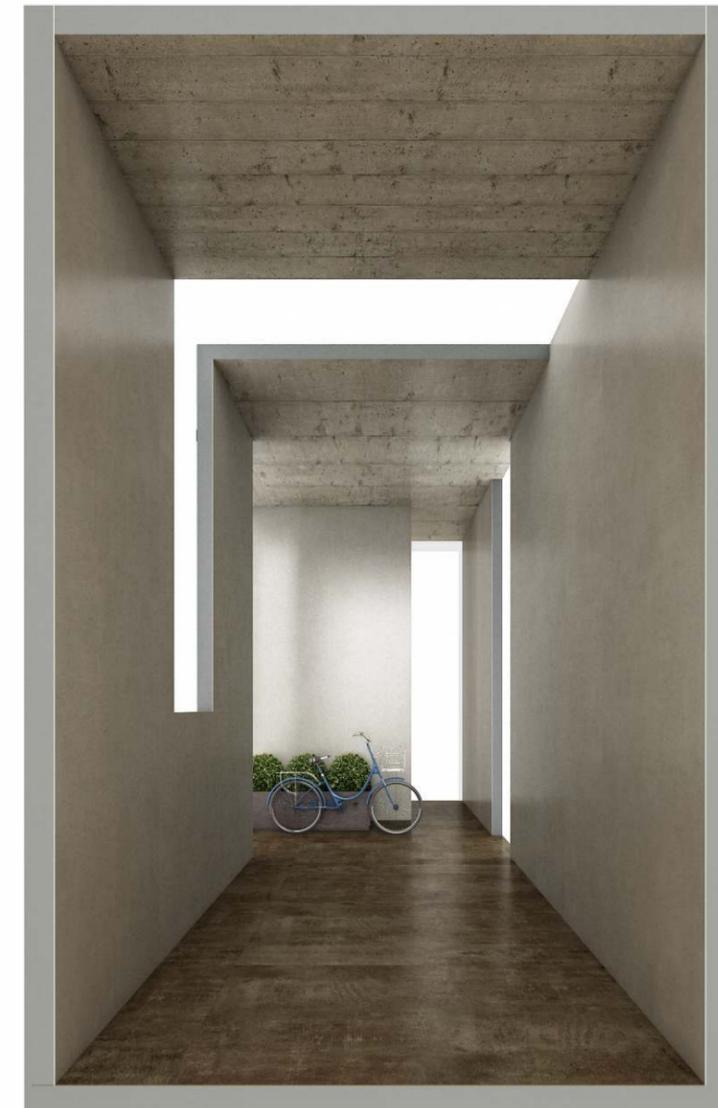
SLIP RESISTANT



STAIN RESISTANT



DIMENSIONAL STABILITY



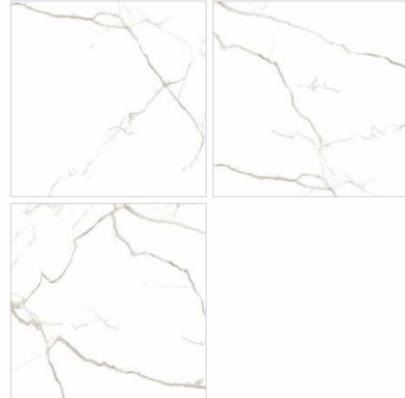
Our creation has been categorized and sorted in cool trendy ways. It is easier to pick and decorate your own surroundings just the way you want. More options and better judgments about our various tiles will conquer your heart once and for all.

**120x
120cm**

Introducing the sensational
square-sized tiles to take you to
the galaxy and back.



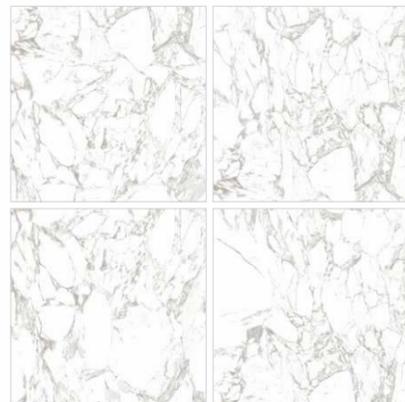
\ STATUARIO ABSOLUTE



Finish \
POLISHED

**120x
120cm**

\ STATUARIO SELECT



Finish \
POLISHED

**120x
120cm**

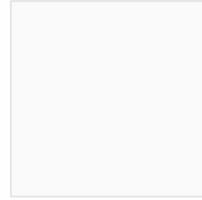
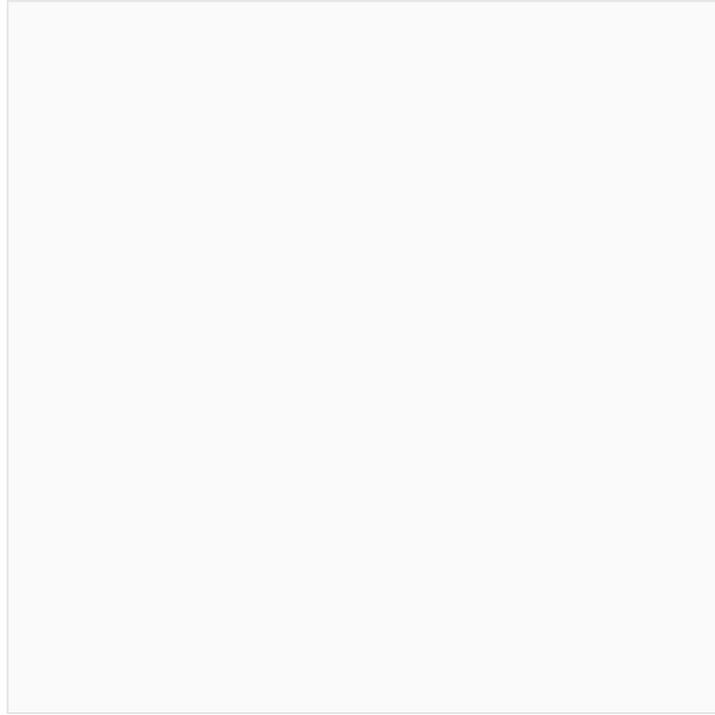
Technical features \



Technical features \



\ ROBINSON WHITE



Finish \
POLISHED

**120x
120cm**

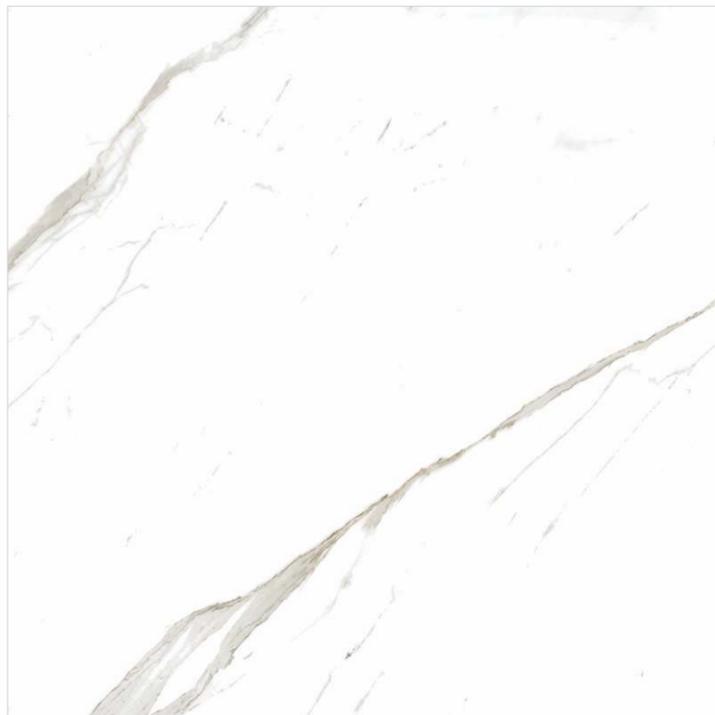
\ STATUARIO SUPER



Finish \
POLISHED

**120x
120cm**

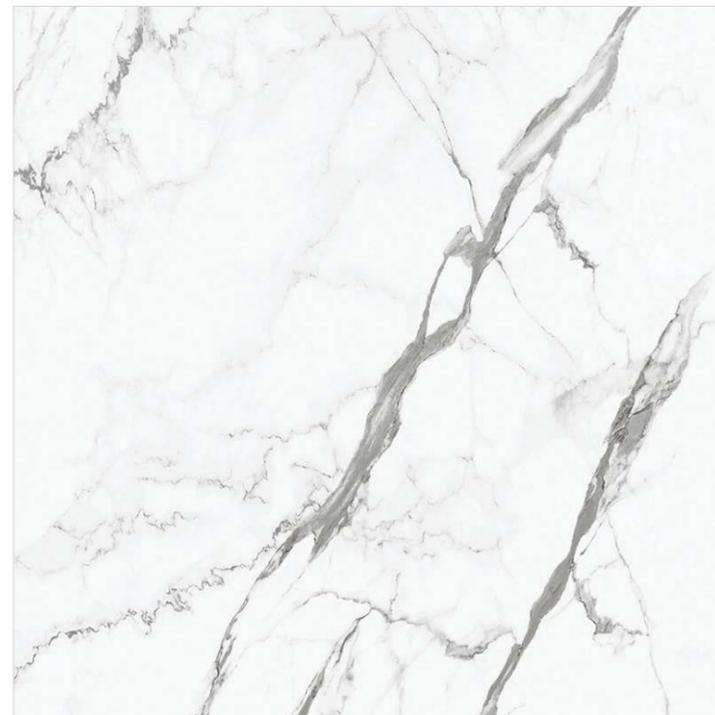
\ STATUARIO ONE



Finish \
POLISHED

**120x
120cm**

\ STATUARIO BLANCO



Finish \
POLISHED

**120x
120cm**

\ STATUARIO ELEGANT



Finish \
POLISHED

**120x
120cm**

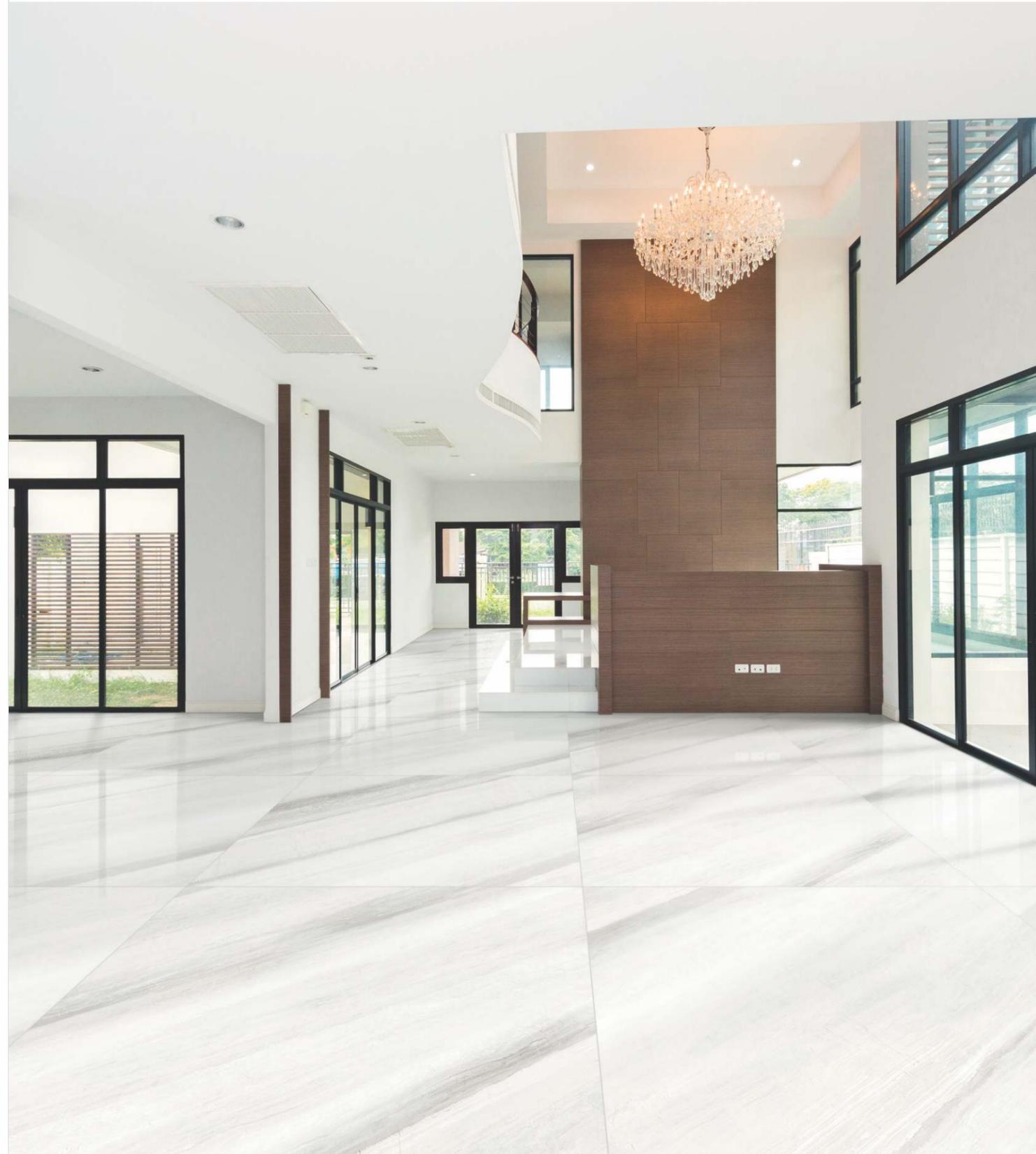
\ BIANCO MARMO



Finish \
POLISHED

**120x
120cm**

Technical features \



\ ONYX CLOUDY



Finish \
POLISHED

**120x
120cm**

Technical features \



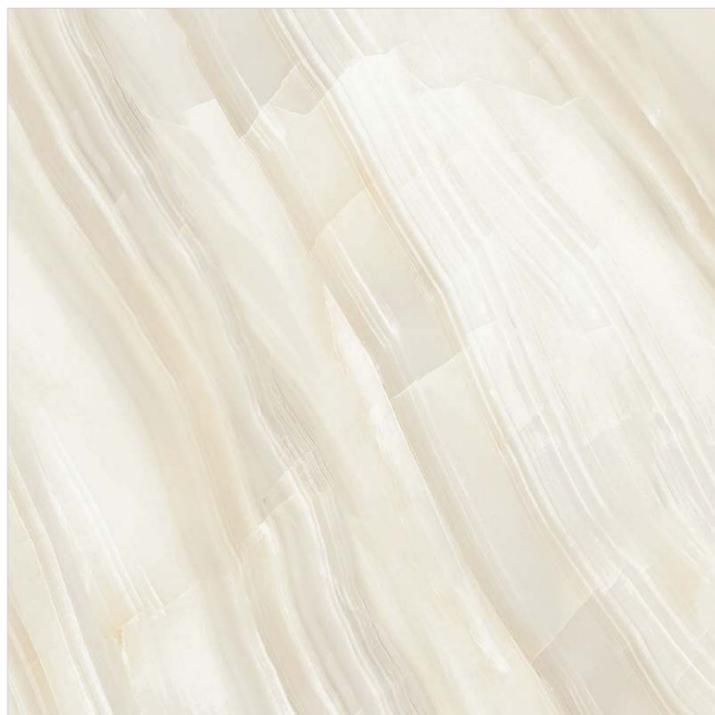
\ ONYX BIANCO



Finish \
POLISHED

**120x
120cm**

\ ONYX MANGO



Finish \
POLISHED

**120x
120cm**



Technical features \



\ ONYX PANTHERA



Finish \
POLISHED

**120x
120cm**

\ HOLLIS BEIGE



Finish \
POLISHED

**120x
120cm**

\ CARRARA



Finish \
POLISHED

**120x
120cm**

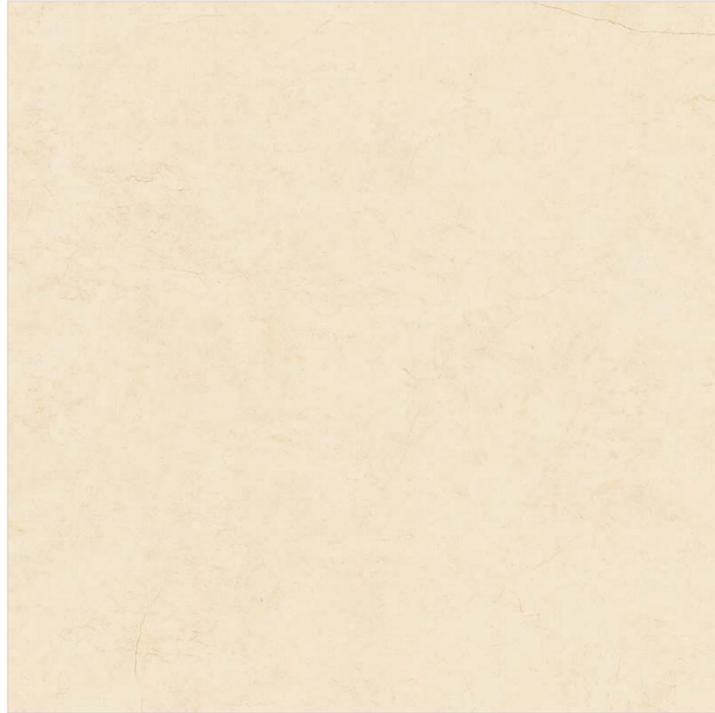
\ HOLLIS GREY



Finish \
POLISHED

**120x
120cm**

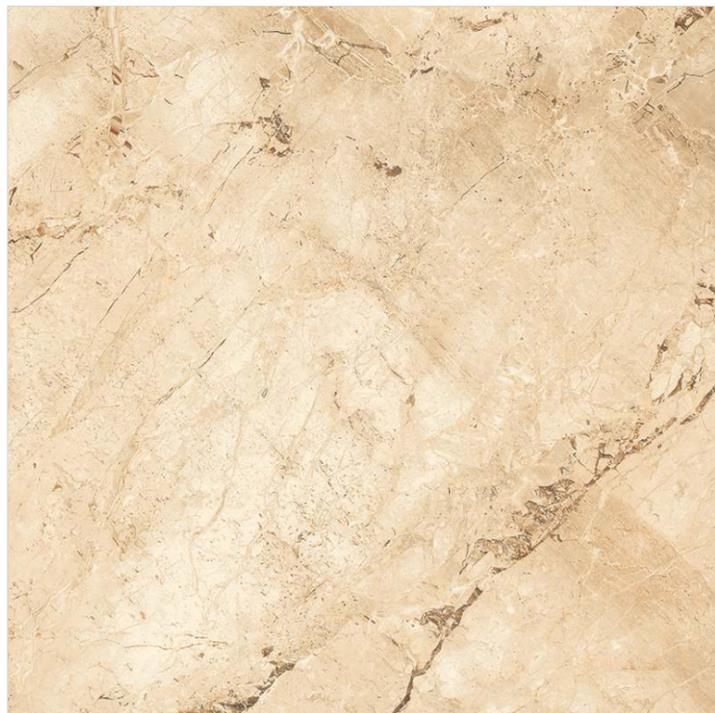
\ CREMA MARFIL



Finish \
POLISHED

**120x
120cm**

\ MOONSTONE BEIGE



Finish \
POLISHED

**120x
120cm**

Technical features \



\ BOTTOCINO CLASSIC



Finish \
POLISHED

**120x
120cm**

\ PULPIS DINOVA



Finish \
POLISHED

**120x
120cm**

Technical features \



Technical features \



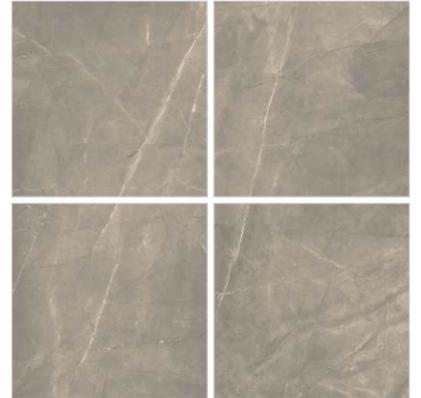
\ ARMANI BIANCO



Finish \
POLISHED

**120x
120cm**

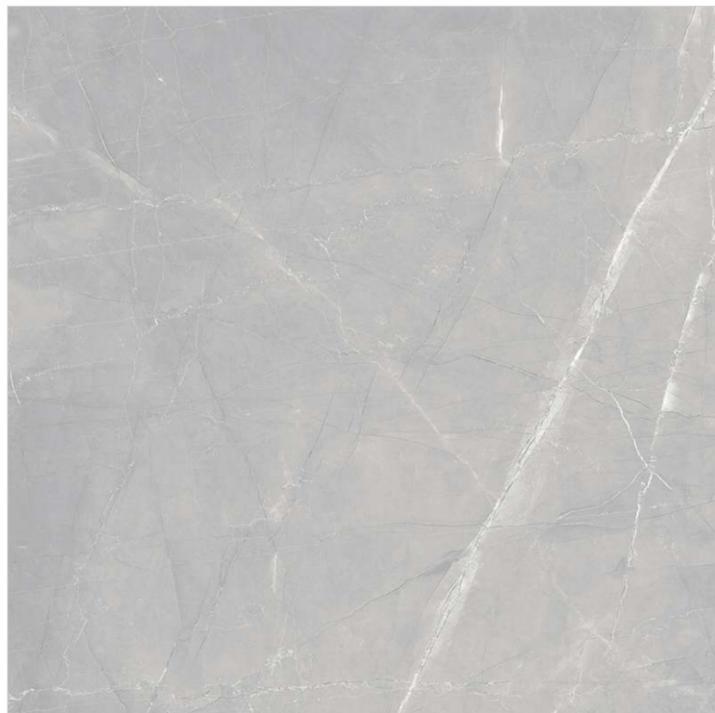
\ ARMANI GRIS



Finish \
POLISHED

**120x
120cm**

\ ARMANI GREY



Finish \
POLISHED

**120x
120cm**

\ TRAVERTINO CLASSICO



Finish \
POLISHED

**120x
120cm**

\ DYNA CLASSIC



Finish \
POLISHED

**120x
120cm**

\ DYNO BEIGE



Finish \
POLISHED

**120x
120cm**

Technical features \



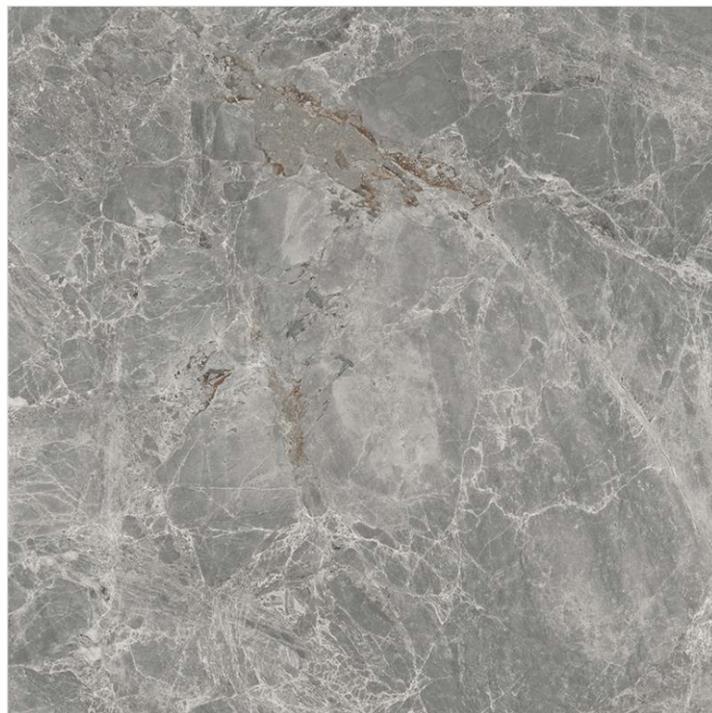
\ EMPERADOR NUOVO



Finish \
POLISHED

**120x
120cm**

\ EMPERADOR GRIGIO



Finish \
POLISHED

**120x
120cm**

Technical features \



\ BRESCIA



Finish \
POLISHED

**120x
120cm**

\ BRESCIA FAME



Finish \
POLISHED

**120x
120cm**

Technical features \



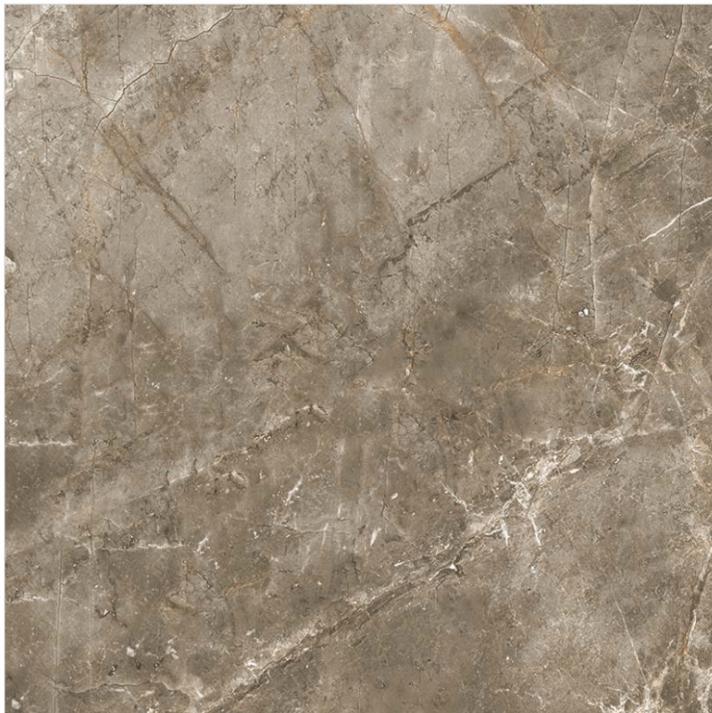
\ BRESCIA NUOVO



Finish \
POLISHED

**120x
120cm**

\ SILVER RIVER



Finish \
POLISHED

**120x
120cm**

Technical features \



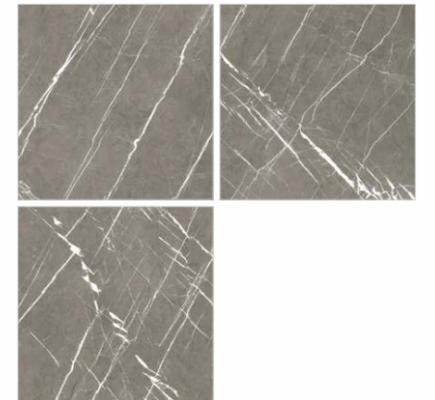
\ ROYAL BURBERRY



Finish \
POLISHED

**120x
120cm**

\ PIETRA SMOKE



Finish \
POLISHED

**120x
120cm**

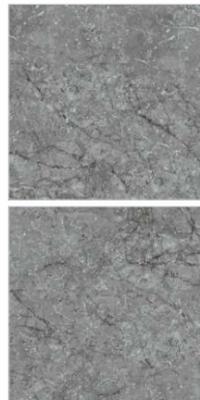
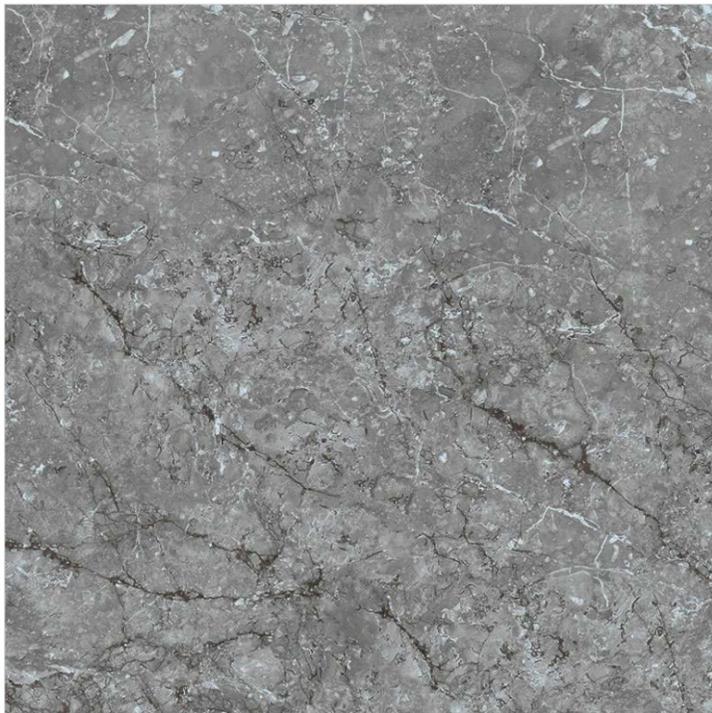
\ PICASO OLIVE



Finish \
POLISHED

**120x
120cm**

\ WILLIAM GREY



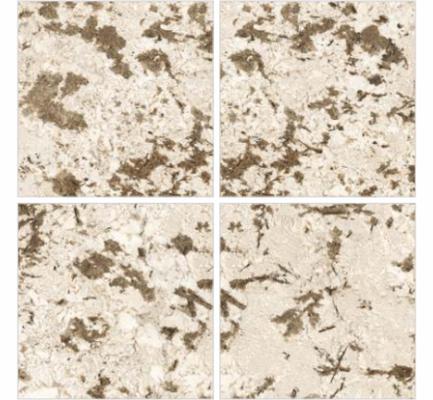
Finish \
POLISHED

**120x
120cm**

Technical features \



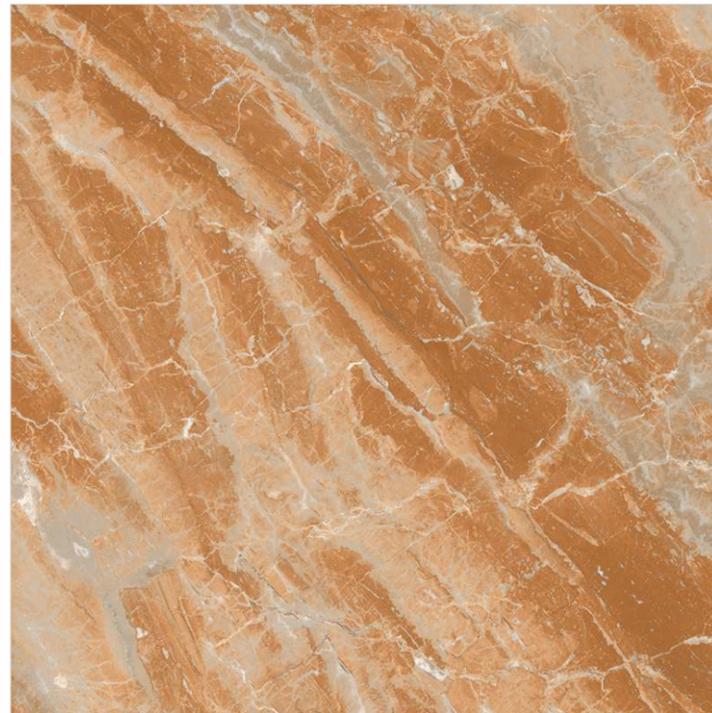
\ ARTIC WHITE



Finish \
POLISHED

**120x
120cm**

\ ROSSO FIRE



BOOK MATCH - A+B

Finish \
POLISHED

**120x
120cm**

Technical features \



\ STATUARIO ELEGANT



Finish \
SILK

**120x
120cm**

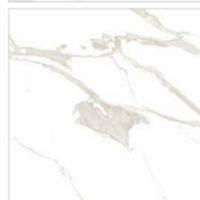
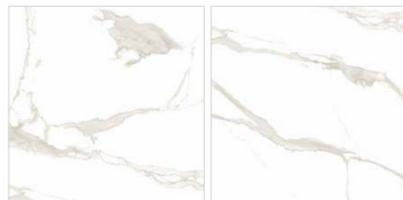
\ STATUARIO SELECT



Finish \
SILK

**120x
120cm**

\ STATUARIO SUPER



Finish \
SILK

**120x
120cm**

\ ARMANI ORO



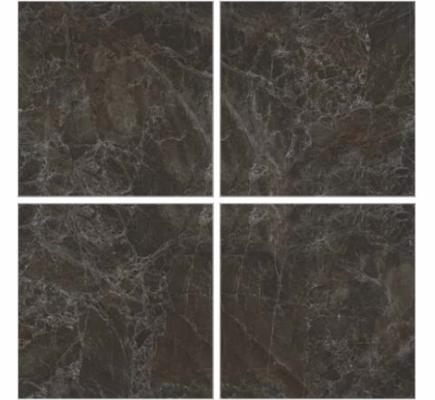
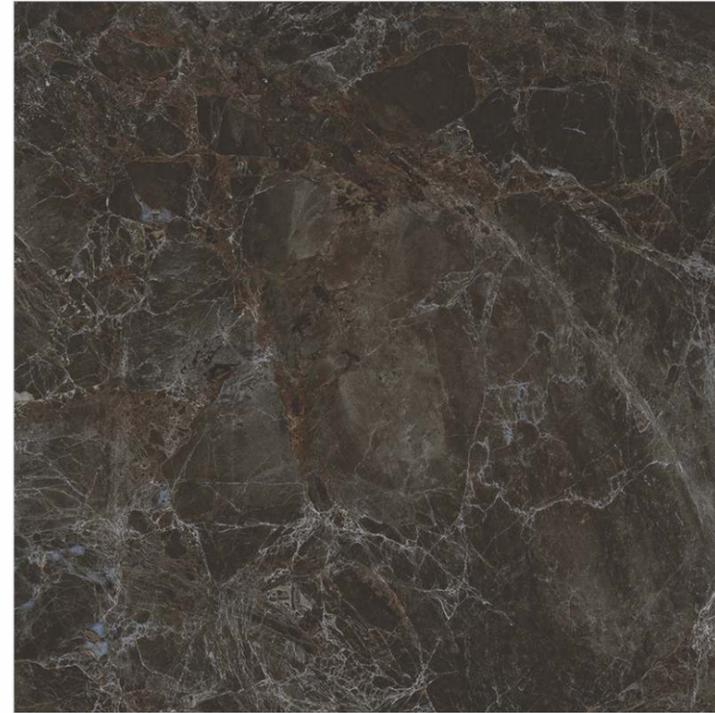
Finish \
HIGH GLOSS

120x
120cm

Technical features \



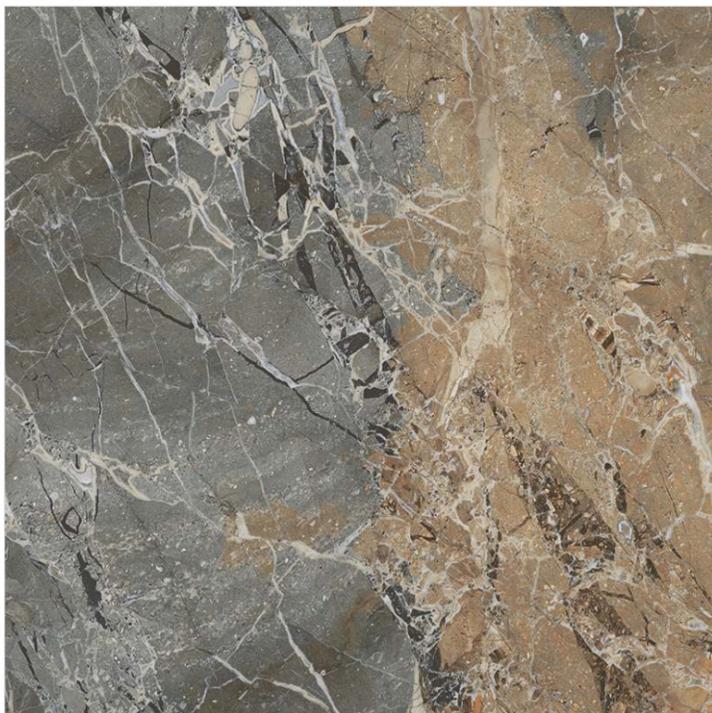
\ EMPERADOR DARK



Finish \
HIGH GLOSS

120x
120cm

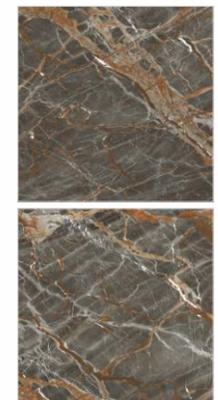
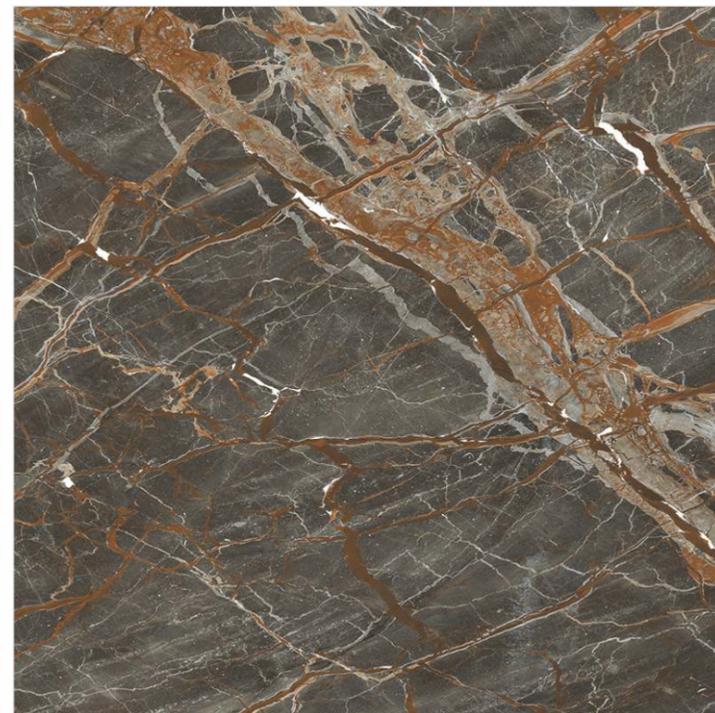
\ BLUE BRESCIA



Finish \
HIGH GLOSS

120x
120cm

\ ESTRADA



Finish \
HIGH GLOSS

120x
120cm

\ FRAPPUCCINO NATURAL



Finish \
HIGH GLOSS

**120x
120cm**

\ PIETRA NATURAL



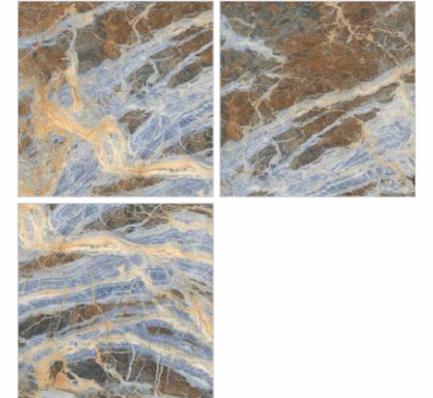
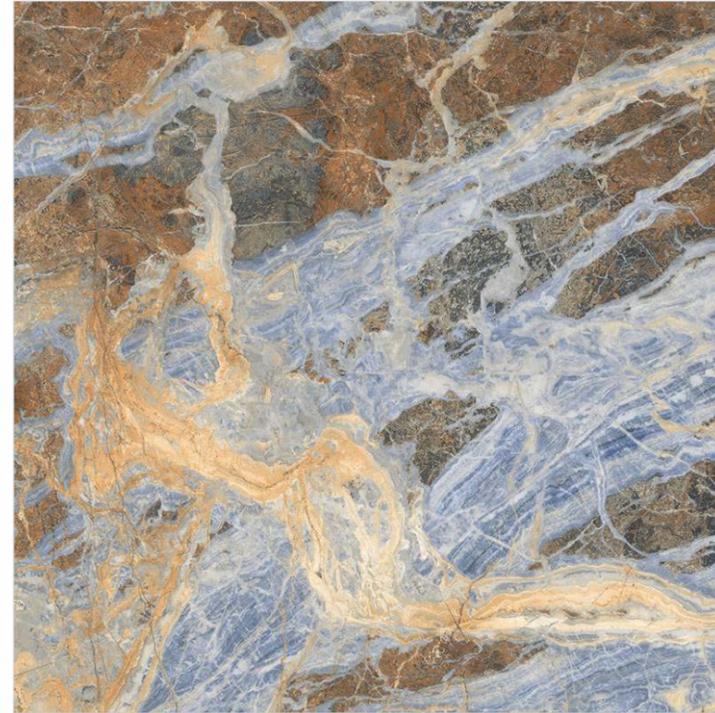
Finish \
HIGH GLOSS

**120x
120cm**

Technical features \
MIN. 3MM
SPACER



\ RAINBOW ROCK



Finish \
HIGH GLOSS

**120x
120cm**

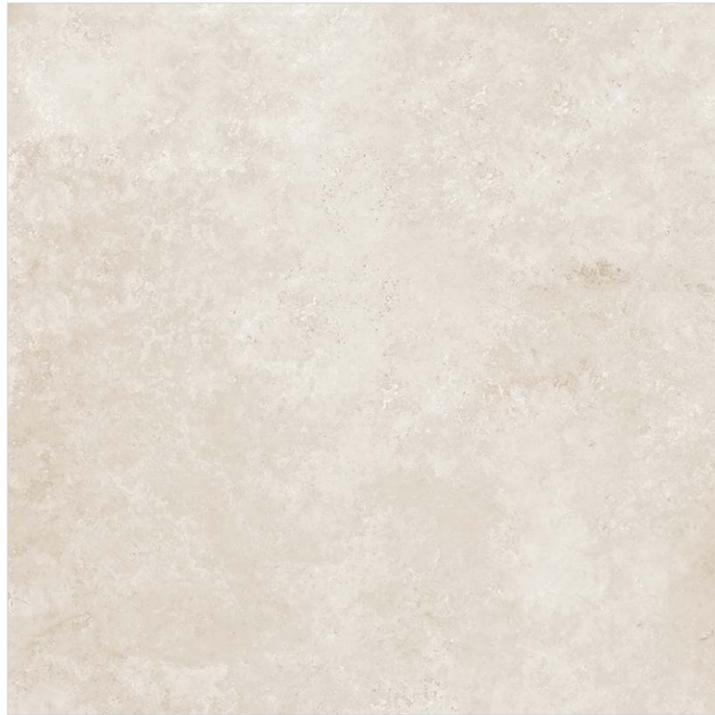
Technical features \

- MIN. 3MM SPACER
- 9MM THICKNESS
- LIVING SPACE
- COMMERCIAL SPACE
- PUBLIC SPACE
- COUNTER TOPS
- WALL CLADDING
- BUILDING FACADE



120x
120cm

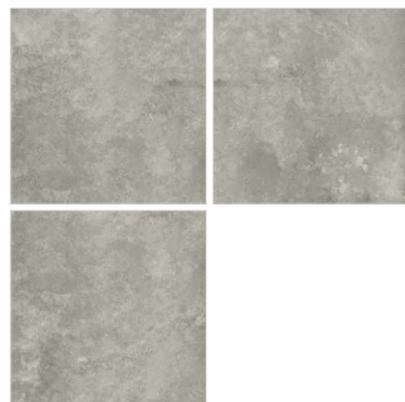
\ BRAZILIA CEMENTO



Finish \
MATT

**120x
120cm**

\ BRAZILIA GREY



Finish \
MATT

**120x
120cm**

Technical features \



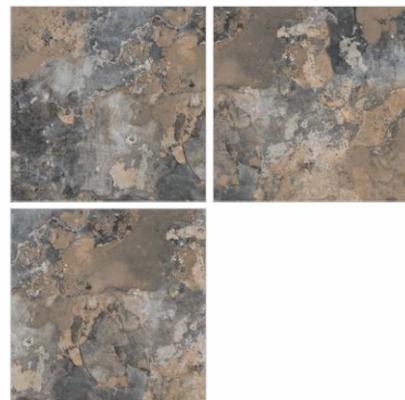
\ ELEMENTAL GREY



Finish \
MATT

120x
120cm

\ MONALISA GREY



Finish \
MATT

120x
120cm

Technical features \



Technical features \



\ SLATE BROWN



Finish \
MATT

**120x
120cm**

\ PORCELANO IVORY



Finish \
MATT

**120x
120cm**

\ SLATE GRIS



Finish \
MATT

**120x
120cm**

\ PORCELANO LATTE



Finish \
MATT

**120x
120cm**

Technical features \



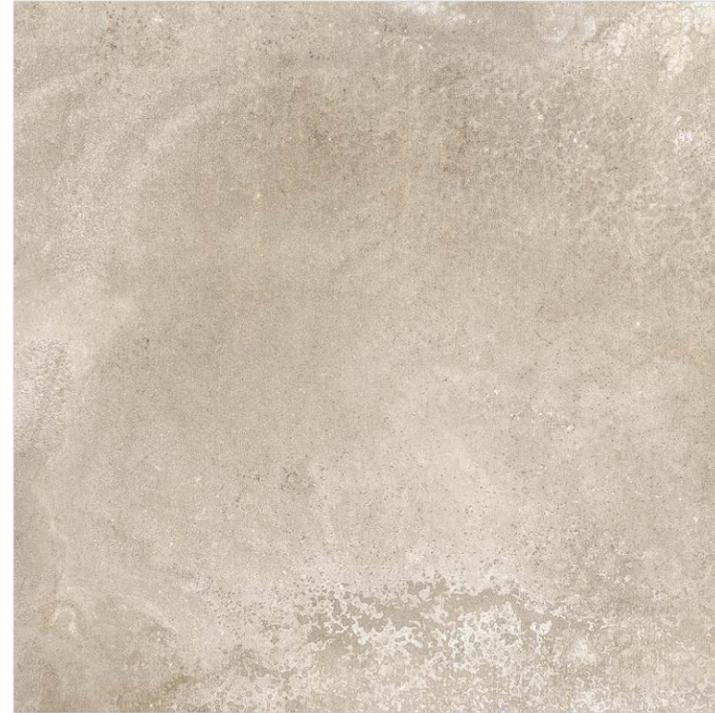
\ COTTO BROWN



Finish \
MATT

**120x
120cm**

\ SIMON BEIGE



Finish \
MATT

**120x
120cm**

\ COTTO GREY



Finish \
MATT

**120x
120cm**

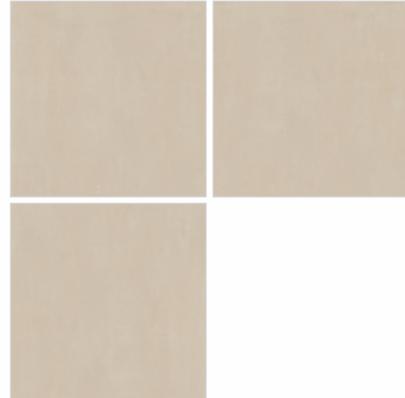
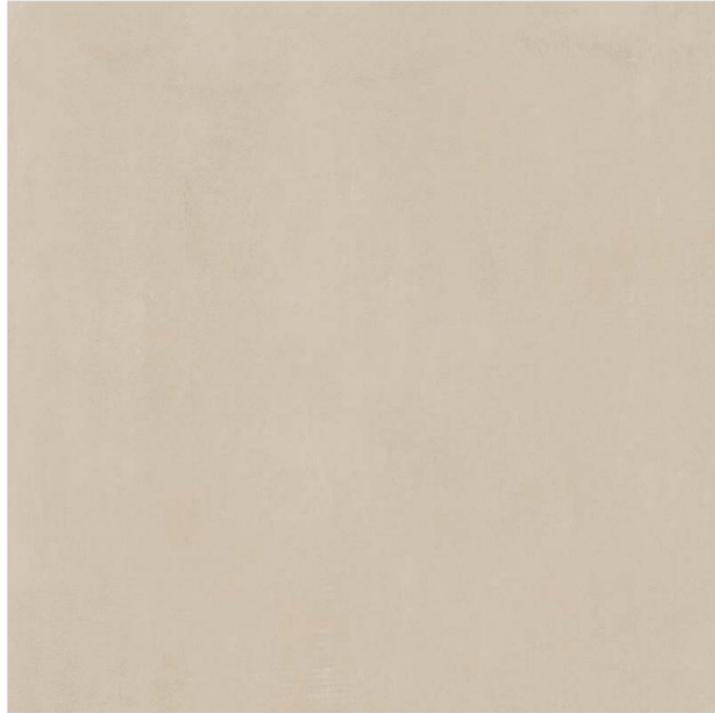
\ SIMON ASH



Finish \
MATT

**120x
120cm**

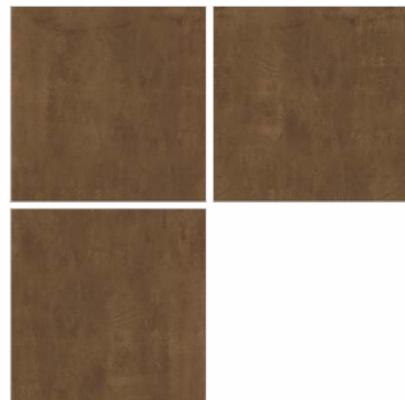
\ STONE BEIGE



Finish \
MATT

120x
120cm

\ STONE BROWN



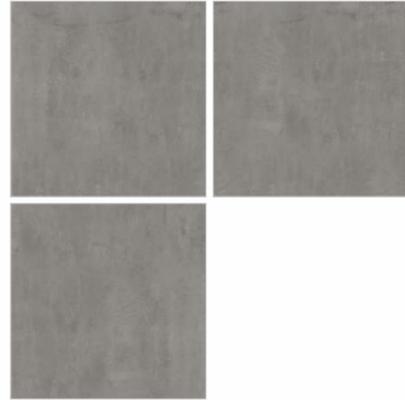
Finish \
MATT

120x
120cm

Technical features \



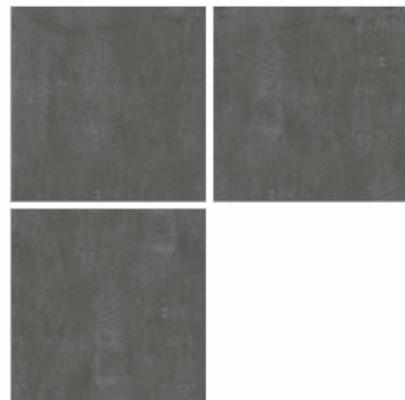
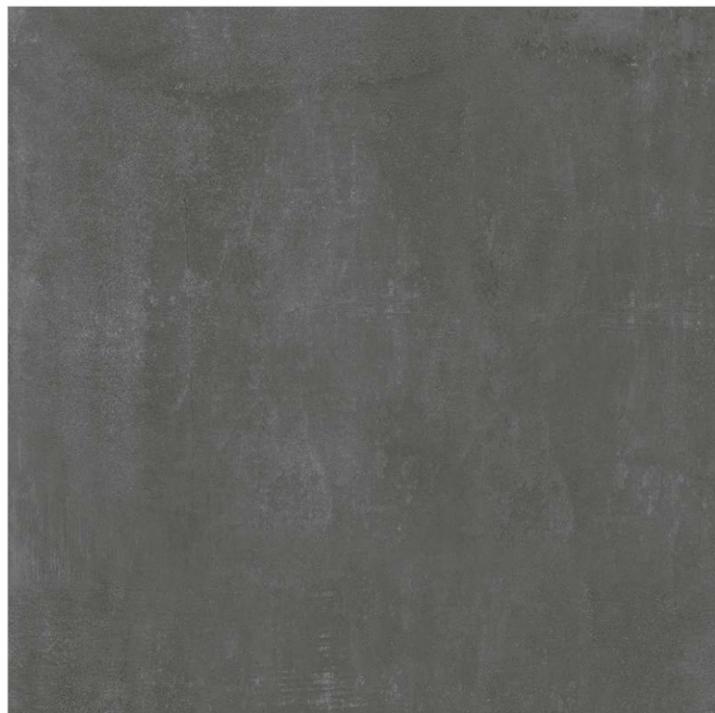
\ STONE CEMENTO



Finish \
MATT

**120x
120cm**

\ STONE GREY



Finish \
MATT

**120x
120cm**

Technical features \
MIN. 3MM
SPACER



\ LIME STONE



Finish \
MATT

**120x
120cm**

\ LIME STONE GREY



Finish \
MATT

**120x
120cm**

\ MATRIX METAL



Finish \
METALLIC

120x
120cm

\ WOODEN ALLOY



Finish \
METALLIC

120x
120cm

Technical features \



TECHNICAL SPECIFICATIONS

CHARACTERISTICS	STANDARD AS PER ISO-13006/EN14411 GROUP B/A	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/mm ²	Min. 40 N/mm ²	Min. 40 N/mm ²	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	As 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	As per mfg.	> 0.40	> 0.40	ISO-10545-17
Fire resistance	As 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 / Box (approx*)		Packing
1	120x120cm	9 to 9.5 mm	2 pcs.	2.88 sq. mtr.	31.00 sq. ft.	Box

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 Vitriified 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 Vitriified 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 vitriified 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 vitriified 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 vitriified stoneware slabs reinterpret a selection of prestigious natural marble with absolute fidelity, creating planning harmony with the Marvel decor for residential and commercial ambiances 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 unlaied 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 derivatives.

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.

Recommendations

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 unlaied 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.

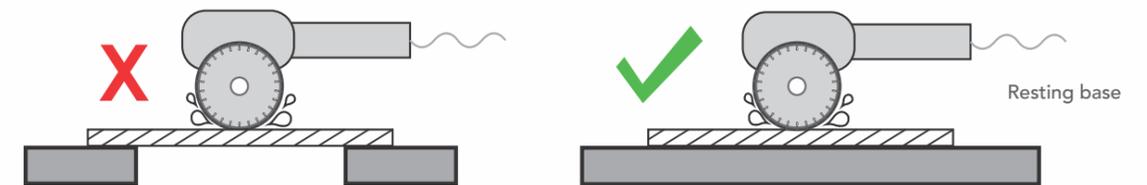
Disk diameter	RPM	Cutting speed (m/min)-(feet/min)
300 mm - 12"	2600 rpm	1/2 m/min - 4 feet/min
350 mm - 14"	2300 rpm	1/2 m/min - 4 feet/min
400 mm - 16"	1900 rpm	1/2 m/min - 4 feet/min

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.

Cutting



Drilling



Water jet 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.

