TECHNICAL MANUAL DEKTON

BRIDGE

Before to work:
1. Cut 20 mm around the slab’s perimeter
2. Used 50% of the speed

- Table:
  - Solid and tough
  - Perfectly flat and leveled

- Disc:
  - In good conditions
  - High water flow
  - Test approved tools
BRIDGE

- Cutting parameters

<table>
<thead>
<tr>
<th></th>
<th>Soft</th>
<th>Medium</th>
<th>Strong</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colours</td>
<td>Strato, Sirocco</td>
<td>Domoos, Sirius, Ananke, Kadum, Keranium, Edora, Irok, Vega</td>
<td>Zenith, Ariane, Danae, Aura, Kairos</td>
</tr>
<tr>
<td>Speed</td>
<td>1-1.2m/min</td>
<td>0.8-1m/min</td>
<td>0.5m/min</td>
</tr>
<tr>
<td>How deep (Table)?</td>
<td>2mm</td>
<td>2mm</td>
<td>4mm</td>
</tr>
</tbody>
</table>

- Miter edge

  Feed 0.4-0.5m/min
  How deep 4 mm

To avoid chips leave 1 mm tab
TECHNICAL MANUAL DEKTON

WATERJET

- Slats of the table in perfect condition, with a separation between them as small as possible to give the maximum support
- Water in the machine should be at the height of the table
- 3mm gap between the nozzle and the slab
- Abrasive used to cut Dekton should be 600 gr/min
- The pressure used to cut Dekton: always begin piercing at 70ba and continue cutting at high pressure 350ba
- Cutting speeds:

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<td>0,4m/min</td>
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Wrong

The cut must start on the further side of the edge

Good
Feed 0,6m/min
Pressure: 1.8 bar for all positions
Sequence
46gr, 46gr, 60gr, 60gr, 120gr, 120g
1. Make the drill where there is more material
2. Cutouts must be done in one step
3. Use the parameters and tools recommended by Cosentino
4. All the pieces to cut must be supported
MANUAL WORK

- Always work in wet
- Use always tested tools to get the best quality
- Sharp the drill every for 4 holes
- Use pads or brushes for gloss or mate texture
TECHNICAL MANUAL DEKTON

MITER EDGE

- Make small grooves to increase the grip between the two pieces
- Use framing square to get exactly 90°
- Joint must be clean, without dust and water

- Use suitable glue
- Minimum bevel 2-3 mm
DEKTON

INSTALATION

- Cutout must be done with a minimum radius about 5 mm
- The whole counter top must be completely flat, supported and leveled
MOST COMMON PROBLEMS DEKTON

APPROVED BLADE:
Sigmadiamant
Tecnodi diamant
Vena

BLADE CUTTER OR SIMILAR

SUPPLIER DETAILS

TOOL DETAILS

REFERENCE (SD): Blade
REF: Z1CD82300 Blade Ø 300x10+Central axis, 50 or 60
REF: Z1CD82350 Blade Ø 350x10+Central axis, 50 or 60
REF: Z1CD82450 Blade Ø 450x10+Central axis, 50 or 60

OBSERVATIONS: Inform the supplier of the internal diameter. These discs can also be ordered in a silenced version.
MOST COMMON PROBLEMS DEKTON

Too fast at the beginning

Too fast at the end
MOST COMMON PROBLEMS DEKTON

- Not flat support
- Not same level support
- Silestone/Granit used like support
MOST COMMON PROBLEMS DEKTON

- Not minimum radius
- Not deep enough
MOST COMMON PROBLEMS DEKTON

Not completely cutted:
- Low pressure
- Too fast
- Not enough sand
MOST COMMON PROBLEMS DEKTON