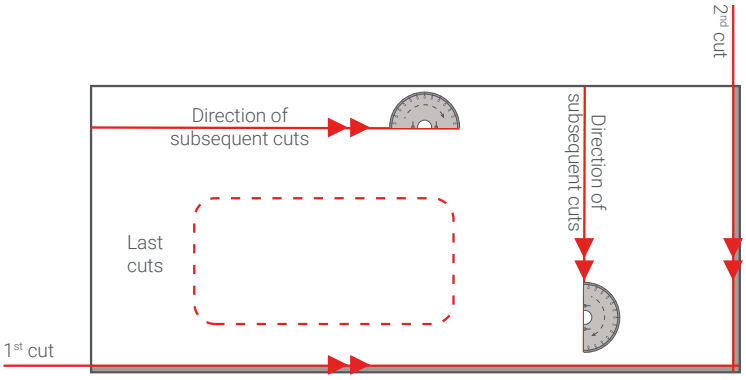
QUICK FABRICATION GUIDELINE

Before carrying out any processing, the slab must be trimmed with a longitudinal and transversal cut with incremental distance from the edge with respect to its thickness. The subsequent cuts will be made starting from the rough side towards the previously trimmed side. By trimming the 4 sides there will be no constraint on the direction of the subsequent cuts.



Trimming size

1/2"	2 edges - 3/4"
3/4""	2 edges - 1' 1/4"
1' 1/4"	2 edges - 1' 1/2"

All internal corners relating to a cut-out must have a minimum radius of 3/16".

A larger radius gives greater structural strength to the workpiece (see figure 1), while any non radiused corner creates a stress point on the countertop (see figures 2, 3 and 4).

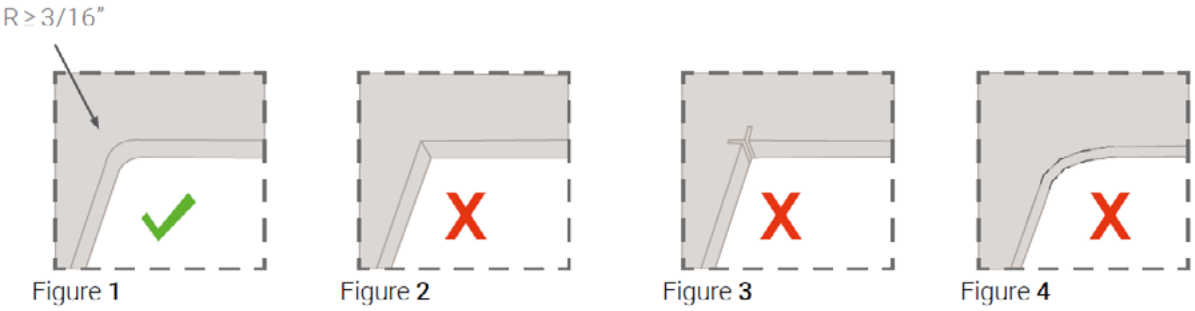
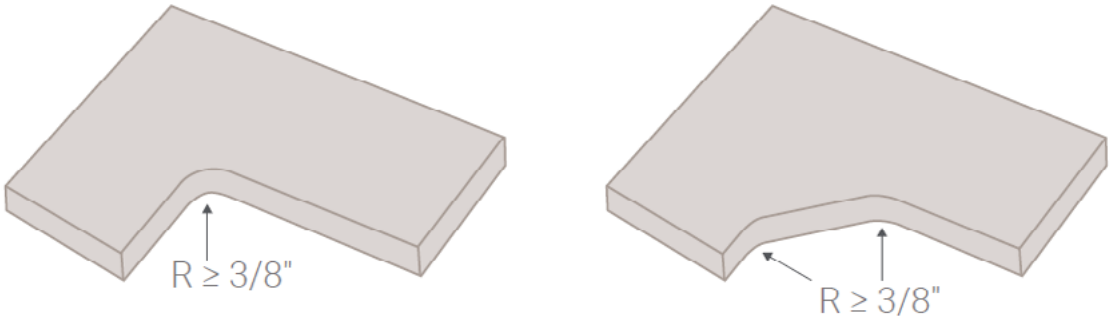


Figure 1 Figure 2 Figure 3 Figure 4

To make a single piece L-shaped countertop, the minimum radii must be 3/8".



Biocare

Lapitec recommend the use of Biocare on any application that exposes machined top surface (such as drain board for example) or finished exposed edge (kitchen edge profile, pool coping, etc etc) regardless of interior or exterior application.

PROCESSING WITH BRIDGE SAW

Standard Blade Parameters

Diameter	Revolution speed rpm
14"	1800-2000
16"	1600-1800
18"	1400-1600

Feed

	Plunge cut - in/min	Straiht cut - in/min	Inclinedcut - in/min
1/2"	4	55	32
3/4"	4	32	18
1' 1/4"	4	18	12

Note: If the number of spindle revolutions is fixed, you must choose the disc that requires a number of revolutions closer to those of the spindle.

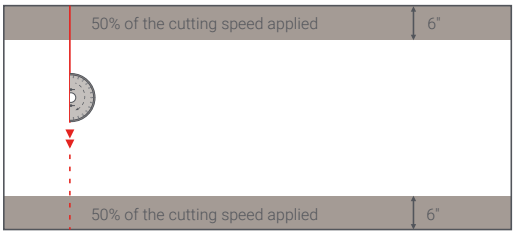
Veloce Blade Parameters

Diameter	Revolution speed rpm
14"	3000
16"	2600

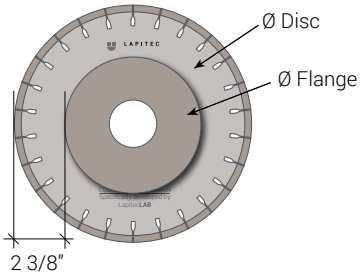
Feed

	Plunge cut - in/min	Straiht cut - in/min	Inclinedcut - in/min
1/2"	4	55	32
3/4"	4	32	18
1' 1/4"	4	18	12

Slow the feed rate down to 50% for the first 6 in and the last 6 in*
Ensure that the cutting bench is in good condition and flat. Should the bench not be in good condition, we suggest placing a high density technical rubber mat between the material and the cutter bench, reducing vibrations and improving the finish of the cut. *



Flanges should be as big as possible to limitate vibration of the blade*

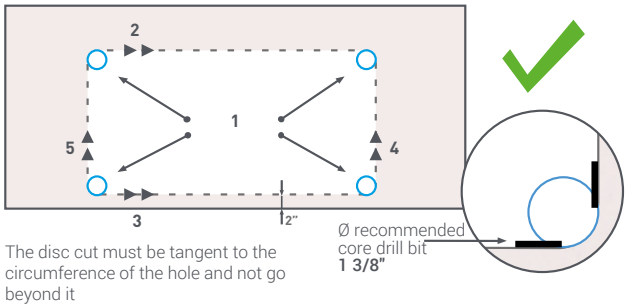


Recommended

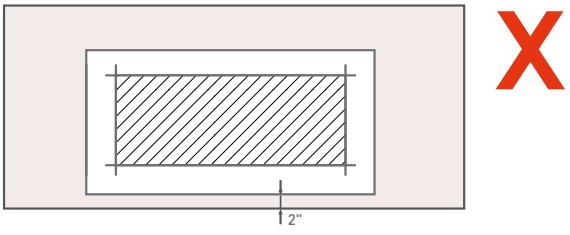
*Mandatory for the Veloce blade

Water well directed to the blade, using adjustable pipes*

Sink cut-out with disk diagram



The disc cut must be tangent to the circumference of the hole and not go beyond it



PROCESSING WITH WATER JET

Low pressure entry hole piercing parameters

Thickness	Minimum pressure Bar	Minimum pressure Psi	Abrasive 80 Mesh kg/min
1/2" - 3/4" - 1 1/4"	600	8700	0,77 - 0,99

High pressure cutting parameters

Thickness	Minimum pressure Bar	Minimum pressure Psi	Feed rate mm/min	Abrasive 80 Mesh kg/ min
1/2"	3600-3800	52200-55100	19,7 - 35,5	0,77 - 0,99
3/4"	3600-3800	52200-55100	15,7 - 19,7	0,77 - 0,99
1 1/4"	3600-3800	52200-55100	7,9 - 11,8	0,77 - 0,99

Advice

The data shown are the maximum recommended values. Lower the feed rate parameters to achieve a better finish.

For water jet cutting it is also recommended to carry out the trimming procedure.

Make sure the workbench is in good condition and flat. The workpiece must rest perfectly without interference from processing waste or discontinuities.

SINK CUT-OUT DIAGRAM

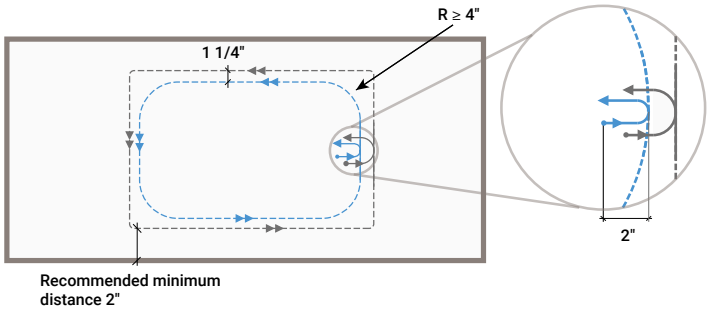
If one or more of the following conditions are present, it is recommended to follow the cutting diagram below:

- the support base is not flat;

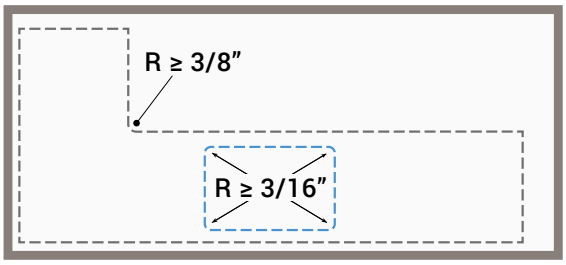
- islands measuring more than 102" x 23 1/2".

- sinks measuring more than 22" x 19".

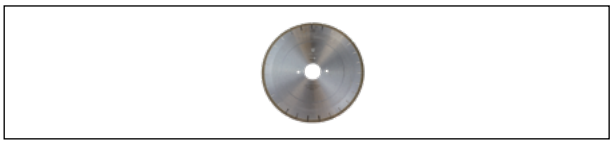
NB: the sink cut-out must begin inside the pre-cut as in the figure below.



All internal corners relating to a hole must have a radius of at least 3/16" while the internal angles relating to the general shape of the workpiece (e.g. L-shaped countertop) must have a radius of at least 3/8". A superior radius gives greater structural resistance to the workpiece, whereas any non-radiused corner creates a stress point on the countertop.



ACCESSORIES



Lapitec disks

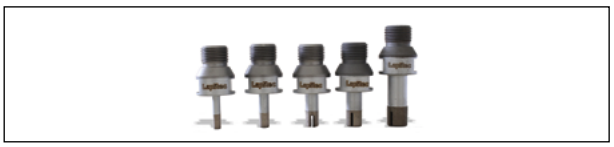
Diameters 12” - 14” - 16” - 18” - 20”

Lapitec finger bit tool

Diameter 7/8”

Lapitec drill for through holes

Diameters 1 1/4” - 1 3/8” - 2 1/4” - 2 3/4” - 4”



Lapitec incremental router for flush top recesses

Diameters 1/4” - 5/16” -3/8” - 1/2” - 5/8””

Lapitec bushing tool for blind holes

Diameters 6-7-8-10-11-12 mm

Lapitec Keil/ Fischer drilling tool for undercut holes

Lapitec router tool for incremental cutting

Diameter 5/8”

Lapitec stubbing wheel tool

Diameters 2” and 3 1/2”

Tenax Strongbond adhesive

Available in all Lapitec colors

Biocare