

# KORE QUARTZ

by **STONEBASYX**

## Fabrication Protocol Guide

This guide is intended for use by Kore Quartz® fabricators / OEM Customers and installers as a reference guide. The guidelines incorporated herein, including references to third parties, must be adhered to in order for any product warranty to be valid. Any deviation from these procedures must be approved in writing by Kore Quartz® prior to fabrication.

### FABRICATION TECHNIQUES AND TOOL:

Fabrication equipment and tools used for quartz fabrication, such as CNC machines and Gantry saws, may be used to fabricate Kore Quartz slabs. Diamond core bits and diamond blades with water feed are strongly recommended and yield the best results. Equipment varies by shop and will affect the speed, feed rate, and diamond cutting blade size that is best for quartz fabrication. Prior to fabrication test cuts should be performed as too aggressive of an approach can cause dislodging, chipping, shattering and splitting.

Colors are produced from Cristobalite such as : Calacatta Gold, Carrara Classic, Pure White, Himalaya Summit, Calacatta Oro should be cut more slowly and carefully.

Update the software to the latest version of the manufacturer for the digital control device.

### FABRICATING GUIDELINES FOR KORE QUARTZ:

1. Ensure that cutting table is perfectly level and flat to reduce risk of cracking during the cutting process. Cutting table must also be solid without any gap/open space.
2. Always use diamond bit blades and diamond core bit tooling.
3. Slower feed rate and more water than for Granite stone.
4. Whenever possible, cut from the outside of the slab toward the center, if cut from inside, must drill holes before cutting. Avoid interrupting.
5. Avoid fractures by predrilling holes on inside corners that are to be radiused. i.e. Sink, cooktop, plumbing and other cutouts.
6. Wet grinding and polishing of edges and at perimeter of cutouts is recommended. Diamond pads are recommended for grinding and polishing. They should also be used to remove cutting marks deep scratches and minor shaping of the cutout.
7. Let the Tools do the job. Do not force the blade or touch the material.
8. Regularly check your tools and equipment for excessive wear. It is recommended that testing be performed regularly, but at least every 300 hours of use.

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## Fabrication Recomendation

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### FABRICATION RECOMMENDATION:

This speed applied for Genya cutting machine from Breton and knife fi500, thinkness 4mm from ADI brand.

#### **2cm Thickness slab**

- Feed rate: 2.8 meters/minute
- Spindle rotation speed 1850 rpm
- The depth of the knife penetrates cutting table 1mm
- Safe height when exiting the knife 4cm
- knife lifting speed 3.5 meters/minute
- knife lowering speed 0.42 meters/minute

This speed applied for Genya cutting machine from Breton and knife fi500, thinkness 4mm from ADI brand.

#### **3cm Thickness slab**

- Feed rate: 2.1 meters/minute
- Spindle rotation speed 1850 rpm
- The depth of the knife penetrates cutting table 1mm
- Safe height when exiting the knife 5cm
- knife lifting speed 2.6 meters/minute
- knife lowering speed 0.32 meters/minute