

## ÉCLOS<sup>®</sup>

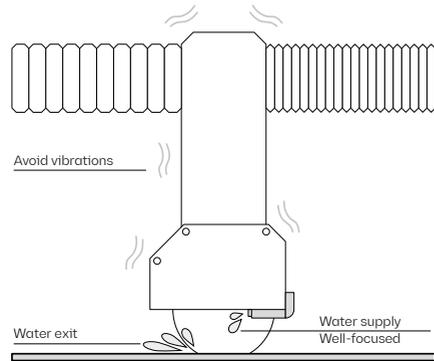
# QUICK FABRICATION GUIDE

INTENDED FOR: FABRICATORS,  
PROFESSIONAL INSTALLERS,  
AND ARCHITECTS



## 1. Bridge Saw

Prior to Fabrication

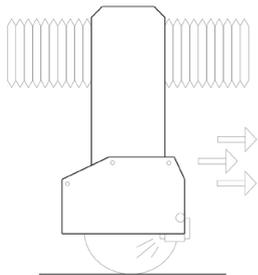


BLADE	ROTATION
300 mm [12"]	2400 rpm
350 mm [14"]	2200 rpm
400 mm [16"]	2000 rpm



Processing

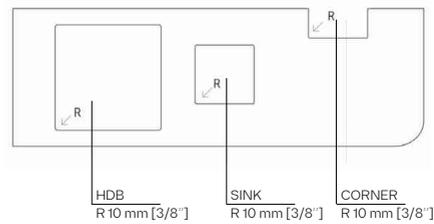
Feed Rate



PARAMETERS	2 CM	3 CM
Straight speed	2.5 m [100"] /min	1.8 m [70"] /min
45° cutting speed	1.5 m [60"] / min	1.0 m [40"] / min
Lowering speed of the plunge	0.3 m [12"] / min	0.3 m [12"] / min
Depth	3 mm [1/8"]	3 mm [1/8"]

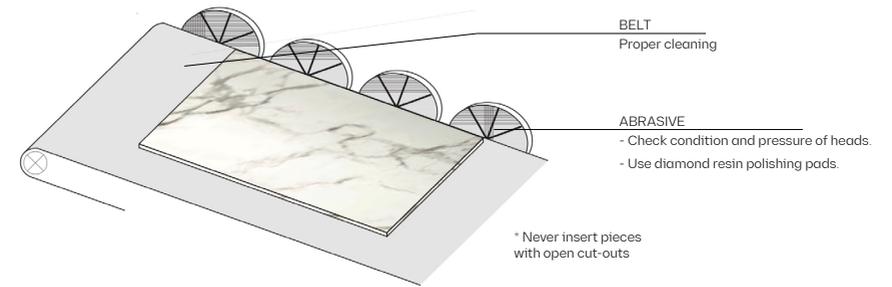
Recommended Radius R

10 mm (3/8")



## 2. Edge Polisher

Prior to Fabrication



Processing

1. Polished

FINISHES	SEQUENCE
Polish	50 - 120 - 220 - 400 - 800 - 1500 - 3000 (Abrasive)
Matt	46 - 60 - 120 - 220 - 400 - 600 (optional) (Brushes)

SPEED: 600 mm [24"]/min

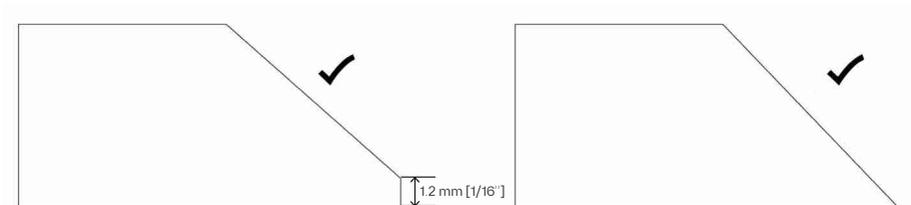
PRESUURE: 1.8 bar - 2.2 bar

(Depends on condition of machine and manufacturer)

2. Mitered Joint Cutting

BLADE: 250 mm [10"] /min

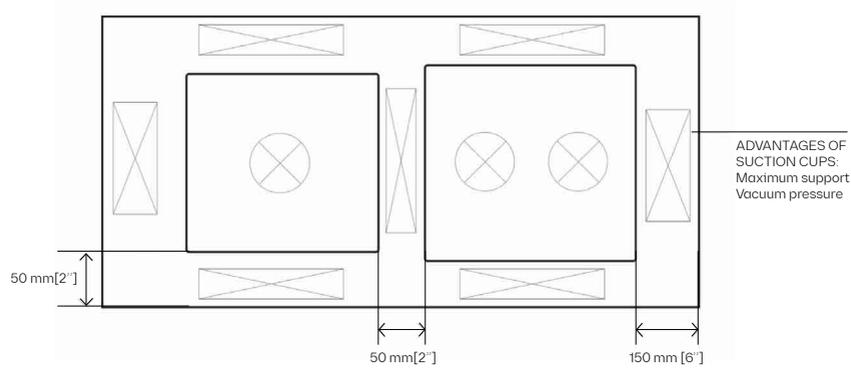
SPEED: 200 mm [8"]/min



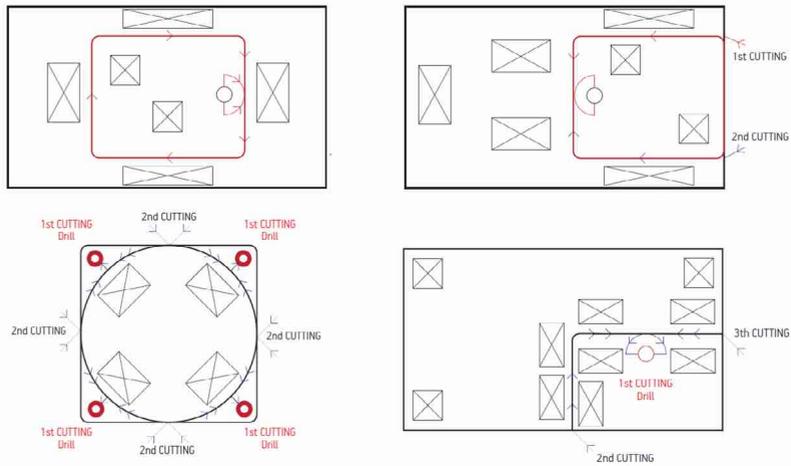
(Better quality cut)

### 3. CNC

Prior to Fabrication



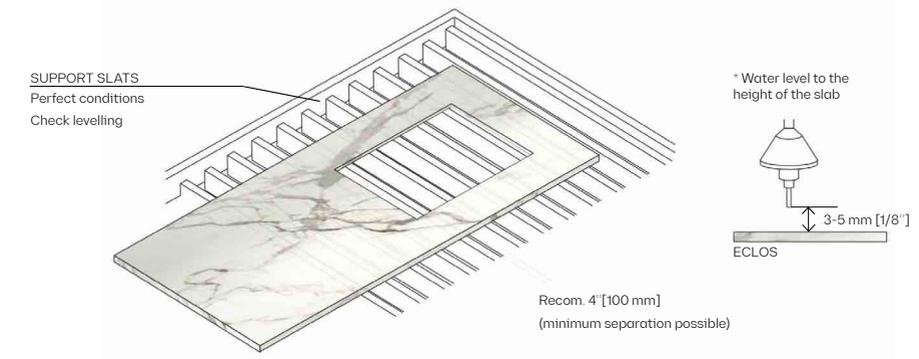
Processing



TOOLS	2 CM	3 CM	OBSERVATIONS
Drills	0.15 m [6"] / min	0.15 m [6"] / min	-
Finger bit	0.5 m [20"] / min	0.35 m [14"] / min	-
Polishing	To polish the edges use regular polishing wheels, for Matt finish only use the first 4 polishing wheels and finish with manual suede pads (220 and 400 grit).		Check the tool wear

### 4. Water Jet

Prior to Fabrication



Processing

#### CUTTING PRESSURE

Low pressure (piercing): 15000 PSI [103421.4 mil Pa]

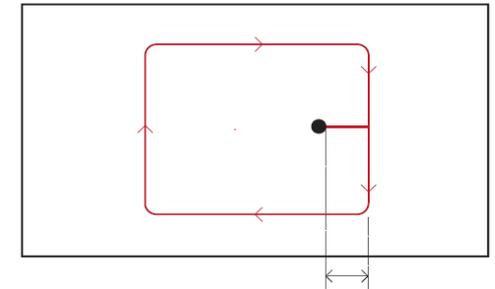
High pressure (cutting): 50000 PSI [344738 mil Pa]

#### ENTRANCE PIERCING

Out of the slab except for cut-outs. 10 sec.

#### ABRASIVE FLOW

600 g/min (recommended grain 80 micras)



#### CUTTING SPEED

COLORS	WHITES	REST OF COLORS
Straight cutting speed	380 mm [15"]/min	600 mm [24"]/min
Miter cutting speed	300 mm [12"]/min	300 mm [12"]/min

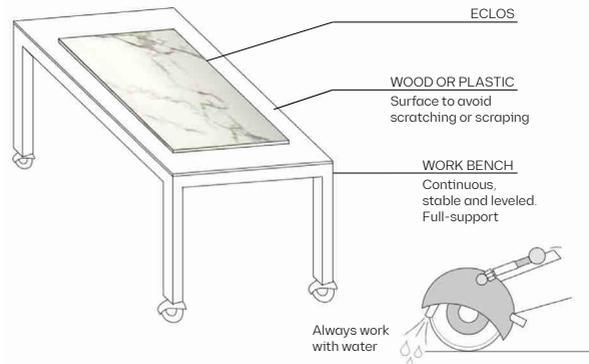
\* If good quality not achieved, reduce speed or increase amount of sand per minute.

#### CUTTING QUALITY

Depends on feed rate / flow of abrasive.

## 5. Manual Work

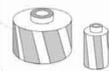
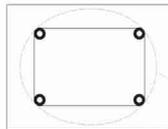
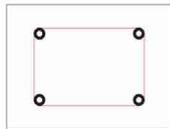
Prior to Fabrication



While Working

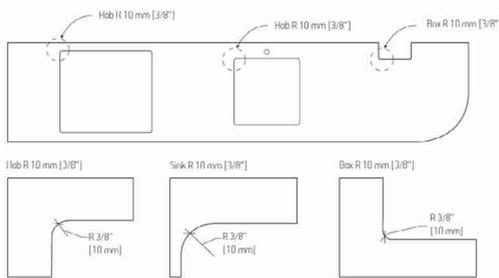
### 1. Fittings

1. Drill the 4 corners
2. Remove cut edges using the hand blade
3. Case of rounded holes



RECOMMENDED RADIUS:  
 \* 10 mm [3/8"] (Corner)  
 \* 10 mm [3/8"] (Hob)

Concave blade and diamond cups



### 2. Polishing

FINISHES	PADS	BRUSEHS
Matt		46 - 60 - 120 - 220 - 400 - 600 (opcional)
Polish	50 - 120 - 220 - 400 - 800 - 1500 - 3000	

\* Polishing pads or brushes for Silestone can be used. Always use tools recommended by Cosentino.

## 6. Installation

HANDLING AND PACKAGING

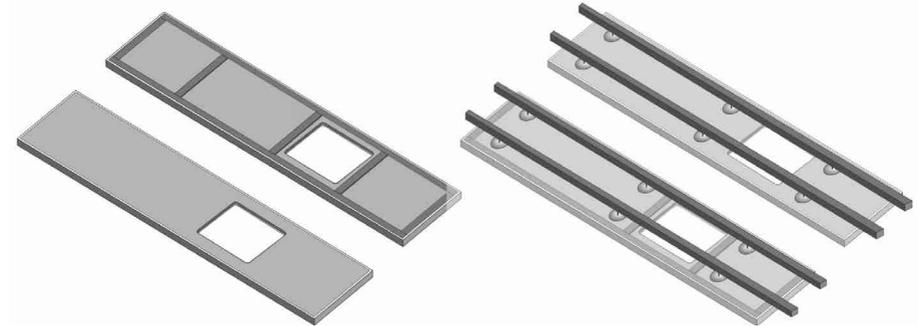
- Check the countertop measures.
- Protect edges and corners.
- Reinforce big pieces.

LOADING AND UNLOADING

- Adapt the A-frame protecting it with foam/ plastic.
- Place the load in a balanced way or vertically.
- Place the pieces faced and separated with a protective element (cork/cardboard).
- Secure the pieces with straps/belts or clamps.

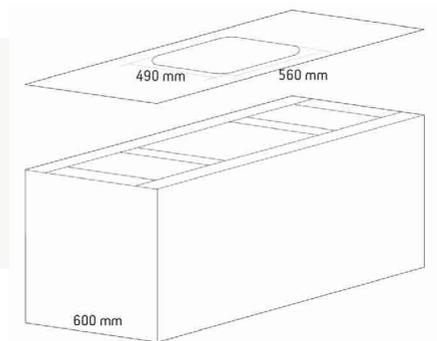
MOUNTS AND REINFORCEMENTS

EDGE FINISHES	REINFORCEMENT WITH STRIPS	MATERIAL	CONTINUOUS REINFORCEMENT	MATERIAL
STRAIGHT EDGES	Hidden in cabinets	Wood	Entire surface	MDF
MITRE EDGE	Hidden underneath	Eclos	Entire surface	MDF



DISTANCE BETWEEN SUPPORTS

COUNTERTOP WITH CUT OUT (GLASS-CERAMIC COOKTOP, SINK, ETC)	DISTANCE BETWEEN SUPPORTS
12 mm	600 mm [23"]
20 mm	800 mm [31"]
COUNTERTOP WITHOUT CUT OUT	
12 mm	900 mm [35"]
20 mm	1200 mm [47"]

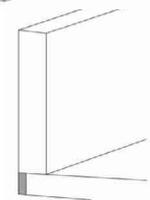


UNIT PREPARATIONS

- Clear and Clean the Surface.
- Level the cabinets adjusting the legs.
- Avoid the use of wedges.

MOUNTS AND REINFORCEMENTS

- Clean and dry the area.
- Use the Perfect Seam™ tool in order to improve the finish.
- Remove the excess silicone and epoxy resin with Clean-colorsil and a cutter.



Expansion joint: 3 mm

**ĒCLOS**<sup>®</sup>  
by **COSENTINO**

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