



OKITE®

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OKITE®

Fabrication Guidelines



Fabrication Guidelines

As fabrication and installation of OKITE® quartz surfacing is similar to that of granite and other quartz surfacing products, we recommend to follow the basic guidelines listed below in order to deliver a professionally fabricated OKITE® stone work.

SLABS INSPECTION

Slabs should be inspected upon arrival at fabrication facility. We suggest taking pictures of the A-Frame right before unloading it. If any damage is noticed, Customers are encouraged to immediately contact Seieffe Corporation (Tel. 713 849 3800).

Prior to fabrication, slabs should be inspected for color consistency and major defects before determining the cutting layout. Any undesirable spot should be marked prior to cutting to make sure the final piece won't include that; Use slabs from the same lot number, especially for pieces that are next to each other.

TOOLS & MACHINE INSPECTION

Inspect the tools and the machinery prior to use. Inspect that the surface on which the slab is going to be placed and/or cut is flat and in good conditions.

- Follow the machine manufacturer's instructions at all times, to avoid incorrect use.
- Follow the tools manufacturer's instructions at all times, to avoid incorrect use.
- Edge polisher belts and CNC vacuums should be clean and free from residues and dirt.

CUTTING & CUTOUTS PROCESS

Blades used for cutting should be first quality blades, specifically designed for granite or quartz surfacing. Blades should be inspected prior to cutting for proper alignment;

Cutting speed should not exceed 12LF/min (up to ¾" material) or 8 LF/min (1" ¼ material);

Do not use any permanent marker to draw/define the cutting path on the surface of the slab.

When slabs are incorrectly stored and become warped the cutting should be carried out twice; the first step being cutting the material to half the thickness, the second cutting the material through all the thickness.

Cutouts should not have any square angle, but should have a minimum of ¾" radius, and a minimum of 1" radius applications with hot/cold variations (including but not limited to food lines). For polished sink cut outs, we also recommend a negative reveal of 1/8" (3 mm).

Minimize heat transfer (hot or cold) by installing insulation along the side of cut out edges (i.e. cooktop cut out edges). A minimum of two layers of Nomex® (or equal) insulating tape with a minimum thickness of 0.11"/layer and a minimum weight of 9.5 oz./yd²/layer is recommended. Do not fold this tape onto the OKITE® surface. DO NOT allow the foil tape to create a heat transfer path directly to OKITE®.

EDGE DETAILS

Exposed edges: refrain from any sharp edge. A minimum radius of 1/8" is requested for eased edges, to avoid chipping;

Calibration: OKITE® is already calibrated; however we recommend calibrating the material along the edges prior to the polishing process.

EDGE POLISHING TOOLS

We recommend using edge polishing tools specifically designed for quartz surfacing.

For polished slabs, the following sequence should be followed: 100-200-400-800-1500-3000.

For honed slabs the following sequence should be followed: 100-200-400-800.

Recommended RPM between 1000 and 1500 RPM.

For hand polishing, avoid using electric machines as they are more dangerous due to water being used.

For edge polishing carried out with CNC machines, we recommend a 7 steps process (4 diamonds, 3 polishing).

Speed and RPM of CNC tools will vary. Please refer to manufacturer's tools chart.

Edges should be inspected before delivery and installation.

INSTALLATION

OKITE® should be installed as any other quartz surfacing or natural stone. We recommend using matching adhesives specifically developed by Integra Adhesives to match OKITE's sheet color. Please contact Integra Adhesives (www.integraadhesives.com - 888.862.6665) or refer to OKITE® matching adhesives chart.

GENERAL INSTRUCTIONS

- ALWAYS FABRICATE OKITE WITH PLENTY OF WATER.
- 30mm (1" ¼) material is recommended for applications with hot/cold variation (including but not limited to food lines); for such applications wider "soft" seams (at least 1/8") are also recommended. Please review our "OKITE® in food service applications" booklet for more info.
- RECYCLE THE WATER USED FOR FABRICATION.
- DO NOT SEAL OKITE. Sealing OKITE will void the warranty.
- DO NOT BUFF/GRIND UNEVEN SEAMS. If seams are uneven, use shims instead.
- DO NOT APPLY ANY COLOR ENHANCER ON OKITE. Applying a color enhancer, will void the warranty.
- USE ONLY WINDEX GLASS CLEANER OR SOFT SCRUB TO CLEAN OR REMOVE RESIDUES.
- Use caution when handling slabs. Slabs can weigh as much as 700 LBS/EACH.
- Always wear respirators, safety glasses, helmets and safety boots when fabricating or handling OKITE®.
- Provide OKITE® Material Safety Data Sheet to all employees, subcontractors and any other person handling, fabricating or installing OKITE®. OKITE® Material Safety Data Sheet (MSDS) is available for download at www.okite.us or simply by request to Seieffe Corporation (713-849-3800 – info@okite.us).
- Inform customer of the proper technique to clean and maintain OKITE®. Care and Maintenance manuals are available for download at www.okite.us or simply by request to Seieffe Corporation (713-849-3800 – info@okite.us). Seieffe Sales Terms and conditions apply, which are available at www.okite.us/terms&conditions.html. Purchasing OKITE® slabs implies acceptance in full of such terms and conditions.

For any question, please visit our website www.okite.us or contact us (713-849-3800 – info@okite.us).



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