



Grenite[®] Sheet Fabrication Information.



v2.0 Effective: Updated 11/2014



Thank you for your investment in Grenite® products.

This information is provided to help you fabricate and install Grenite products in a beautiful, professional manner.

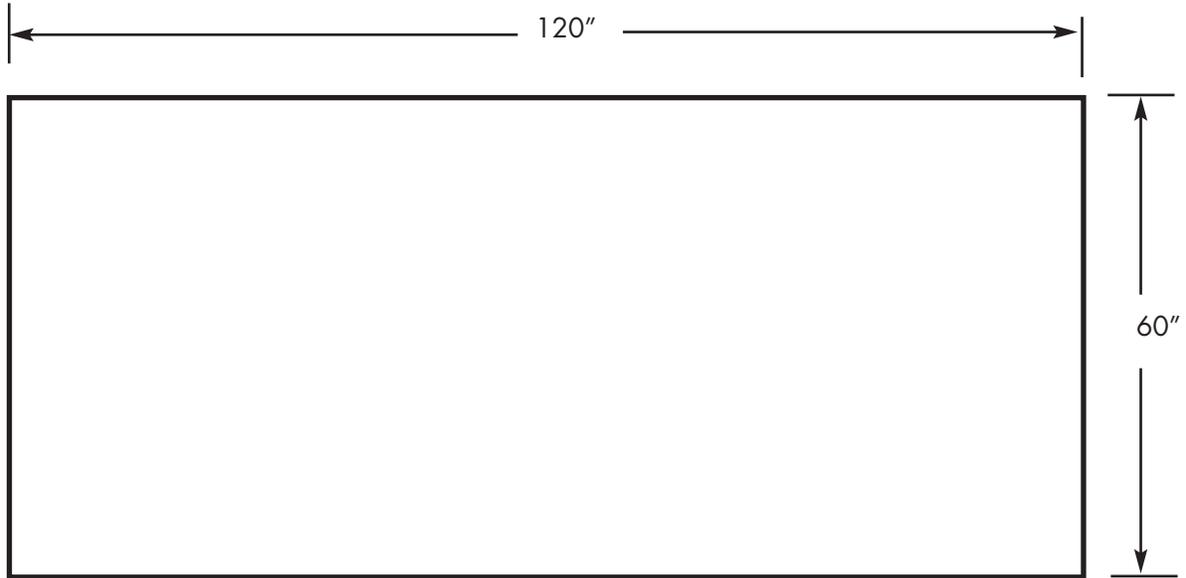




FABRICATING PRODUCTS FROM GRENITE® FLAT STOCK.

Grenite® (2cm), Grenite Anaconda (1.6cm) and Grenite Glass Surfaces (2cm) are available as 5' x 10' flat sheets

Grenite Recycled Solid Surfaces come in 30" x 144" x 1.2cm flat sheets



Top View



Side View

- Superior size allows many countertops and island tops to be made without seams
- Polished top surface, square cut edges, honed smooth back.
- Available in all current colors (contact your Grenite® representative for custom colors).
- Slab weight: up to 345 lbs.



WORKING WITH GRENITE®: SAFETY FIRST.

1. Insure that you have adequate machinery and/or man-power to move Grenite® products. Large pieces of Grenite can weigh hundreds of pounds.
2. Grenite, Grenite Anaconda and Grenite Glass surfaces can be fabricated like any other quartz-based engineered stone material (Silestone®, Caesarstone®, Cambria®). Wet fabrication with diamond tipped cutting equipment is preferred.

Grenite Solid Surfaces can be fabricated like all other polymer based surface material (Corian®, Starion®). Generally these materials can be fabricated with wood-working tools.

3. NOTE: HAZARD IDENTIFICATION.

Dry modification of engineered stone products may generate dust. This dust contains particles of crystalline silica (SiO_2). Inhalation of large amounts of crystalline silica can negatively effect the pulmonary system and can worsen pulmonary diseases (asthma, bronchitis, emphysema, etc.). Suitable measures of protection, including but not limited to, ventilation systems, dust/powder collection systems, vacuum cleaning systems and type FFFP3 personal respiration protection should always be used when dry modifying any engineered stone product. Wet fabrication systems and methods should be used whenever possible.





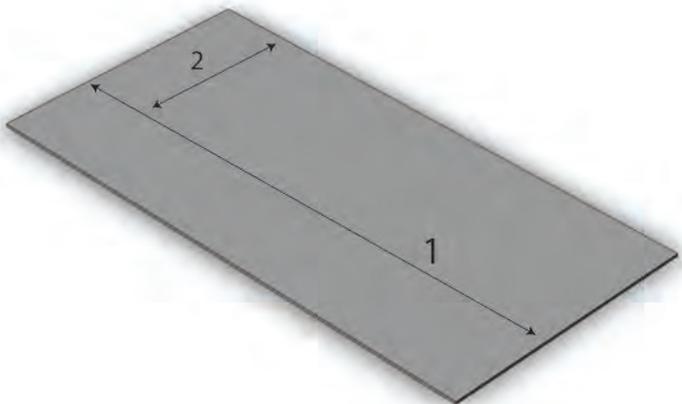
IN-HOUSE FABRICATION OF FLAT STOCK.

Preparation/Planning

1. Check the sheet for possible defects before cutting. Clean the sheet and inspect it under suitable light from different viewing angles.
2. Calculate the material necessary to complete the project. Ensure that enough material is available before starting.
3. Check that the measurements of the various parts of the countertop do not exceed those of the Grenite® sheet.
4. If more than one sheet is required to fabricate the project, check that the color of all slabs match. Remember that Grenite® is a recycled product and natural variations in color and patterns can occur.

Cutting

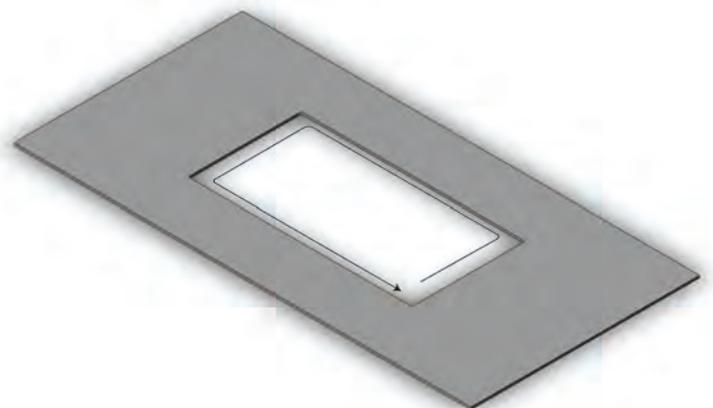
1. Review the drawing or template measurements.
2. In order to cut a Grenite sheet, first cut along the longest dimension of the slab and then make the shorter cuts.



3. Place the anchoring elements near the cutting line. This decreases the possibility of the part moving during the cutting process.

CUTOUTS.

1. When making a cutout, always take into account that the machine will have to go into the cutout.
2. Check the cutout measurements and mark them on the slab.
3. Check the thickness of the supporting flange.
4. Place adhesive tape on the slab to mark the cutout.
5. Draw the cutout on adhesive tape.
6. Drill a hole in each corner of the cutout. It is very important that the corners have a radiused shape. This greatly reduces the possibility of breakage and cracking.
7. Cut. Do not cross the cuts in the corners. This can cause the breakage of the countertop in the future. The cutting should end in the hole and never go beyond it.
8. Cut in a continuously forward direction.





EDGE BUILD-UP.

In many instances the edge treatment for the project must be both built and profiled.

To build-up an edge strips of Grenite® must be cut from the slab and adhered to the fabricated piece.

Grenite® sheets come in various thickness; therefore an additional strip(s) must be added to a fabricated piece to create a taller edge. Add 1/32" to the width of the strip to allow for edge profile forming.

Join the pieces together making up the edge and press with clamps. Place one clamp approximately every 4 inches.

After 30 minutes (or after glue sets), remove the clamps.

Cutting can create pin holes as parts of the Grenite aggregate is broken away from the matrix. Check for pin holes along the cut; if found fill with epoxy and allow to set before proceeding.

Grind away the extra 1/32" of material to remove the seam line from the edge. (The cleaner and tighter the two pieces are joined, the smaller the seam line will be.)

Proceed to procedures outlined under "Edge Profiling and Polishing" to shape and finish the edge.



Acceptable edge build-up



Unacceptable edge build-up



EDGE PROFILING AND POLISHING OF GRENITE, GRENITE ANACONDA AND GRENITE GLASS PRODUCTS WITH A MANUAL WATER POLISHING MACHINE.

DO NOT USE THIS PROCEDURE ON GRENITE SOLID SURFACES AS IT WILL SCRATCH AND DULL THE SURFACE.

1. Follow the machine manufacturer's instructions at all times.
2. Check that the polishing discs are in proper operating condition.
3. Set the water flow to high to cool the material and avoid burning the epoxy binder
4. Cut and shape the edges with the diamond wheel. The cutting of the edges initially shapes the edge. (If a straight edge is specified the diamond wheel is not needed).
5. Polish, using a sequence of diamond grit polishing pads: 50, 100, 200, 400 for washed finishes; continue to polish with 800, 1500, and 3000 grit polishing pads for Diamond Kissed finish.

Make sure that each grit application removes the marks of the previous grit.

6. Polish without pressing down on the material. The machine should be in continuous movement.
7. When completed, the entire edge edge should be evenly smooth.
8. The edge polishing quality depends on various aspects, such as the type of machine, water, abrasive, pressure, speed, etc. and the diligence of the operator! Do not rush; allow the equipment to do it's job!

Troubleshooting edge polishing with the manual water polishing machine.

The edge is not highly polished.

1. The machine is left on the same area for a long time, instead of continuously moving.
2. The machine revolutions rpms are too high.
3. There is too much pressure on the material. Pressure should be between 15-30 psi with constant movement of the tool.

The polishing pads are not being used in the set order. The proper sequence for polishing pad application is: 50, 100, 200, 400 (Washed Finish), 800, 1500, 3000 (Diamond Kissed) grit.

Not enough time is being spent working with the coarser grits (50, 100, 200).

Speed: Approximately 6-10 inches per min.
Pressure: Between 15 and 30 psi.

There are marks on the edge.

The polishing pads are not being used in the set order. The polishing pads should be used in the following order: 50, 100, 200, 400 (Washed Finish), 800, 1500, 3000 (Diamond Kissed Finish).

One of the grit polishing pads has not removed the marks from the previous pad. This is due to insufficient time polishing.

When the material was cut before being polished, deep cutting disc marks remain that cannot be eliminated when using the smoothing cutting disc.

In the event that the cutting disc problem cannot be resolved, the disc marks should be eliminated with a 35 grit diamond polishing wheel.



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