

# UPSHOTS

DESIRE | INSPIRE | ADMIRE

2022

## Luxuriant Porcelain Surfaces

PORCEKO<sup>®</sup>  
PORCELANITE SLAB

*Quarry White*  
Collection

PORCEKO®

GENTLY BUILD THE SPACE  
WHERE DREAMS ARE MADE OF  
THE PORCELAIN SLAB COLLECTION

Fusion of different designs: marble, wood, cement, semi-precious crystal, are united in a new warm and natural surface. Offering three finishes: ultra gleam, polished and cresta mattè the large format slabs cater to the demands of both modern and contemporary design thanks to the technological quality and innovative aesthetics, which makes the Porceko Porcelain slabs ideal for installation in newly built spaces or for practical applications

+PPS

PORCEKO  
PORCELANITE  
SLAB



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CREATE  
YOU CAN!

Table / Volga Blue I Quarry Black  
Floor / Pixel White I Pexelite



A Sustainable High - End Porcelain Surface Depicting the Best of Its Nature What we call a revolution in the recent times, PORCEKO, was ignited in our minds way back when the culture of large format slabs was invented in the industry. We became fascinated by the idea of discovering and celebrating the extraordinary of every space and surface around us.

With breakthrough research and findings, PORCEKO aims in imparting an alluring effect in the form of exclusive, and yet handy patterns and designs, one could easily catch up with.

We persevere to develop and deliver something truly unique and relevant at your doorstep, with the purpose of giving a sense of clarity and satisfaction to maybe not whole, and a niche only, who would welcome with happy minds and understanding hearts.





## THE APPROVAL OF GRACE



Caring about our wellbeing should be one of the most important practices for a long, happy and healthy life, and we care about your wellbeing. It is said that charity begins at home, and so is hygiene, that starts with you and us. Bringing in an innovation with the new “CoverX Technology”, we have developed a technique to create a pure environment for you - a fit and healthy immune system for all.

The new “CoverX Technology” is designed to enable the product surface not to absorb any liquid spread on it, called as Spill Proof Surface. The specially crafted technique, protects the surface from any harmful organisms or unwanted bacteria to grow or live on it.

Ensuring maximum safety and minimum maintenance efforts, we have put in and will always give our greatest attempt to develop a product technology with a higher shield and increased protection. Making your health and safety a first priority always.



# +PPS

PORCEKO  
PORCELANITE  
SLAB

Ideas are incombustible,  
and so PORCEKO aims in making a  
spill proof surface, that is hygienic,  
and ensures maximum safety  
and minimum maintenance

A lot happens just  
beneath the surface.  
PORCEKO has developed  
3 surface types, suitable  
for building the most  
elegant spaces.

Touch and sight are  
the senses that guide  
the aesthetic and architectural choices  
of those who wish to live in  
symbiosis with their spaces.

What makes PORCEKO PORCELANITE SLAB  
unique is our +PPS working system, which includes  
3 phases those are equally important.



## Inception

Offering products capable of moulding space is  
the latest challenge issued by the most advanced  
technologies in the world of architecture and  
design. Excellent and versatile materials lend a  
new form to the surfaces, offering original  
solutions to inspire creators of and those who  
wish to live in a naturally elegant environment. It's  
always the nature, that provides great inspirations  
for finishes and shades. The final goal is to live and  
keep with the harmony of the environment



## Execution

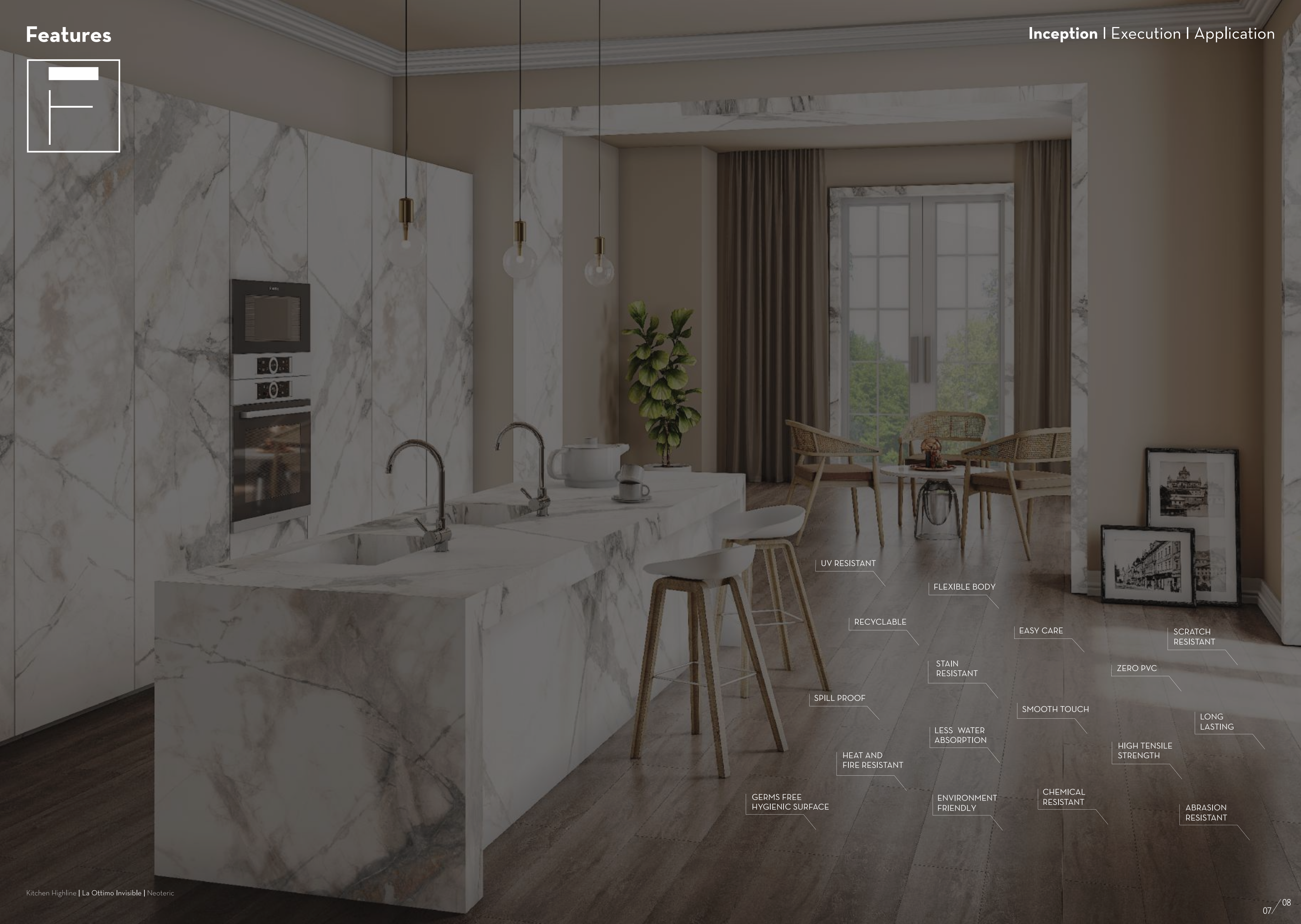
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and safety a first priority always.



## Application

The flexibility of "COVER X Technology" allows  
the various product collections developed by  
PORCEKO to be completely adapted to generate  
projects ranging from simple flooring or coverings  
for large or small surfaces to object-based  
applications and furnishing accessories. It is now  
possible to create genuine products or  
installations with the added benefits that come  
with ceramic technology. The very nature of the  
material also lets designers apply each of these  
possibilities in indoor and outdoor environments.  
PORCEKO offers designs that are rare beauty  
with all of the delights of the most prized marble,  
rocks eroded by the passing of time and the latest  
trends in the field.





UV RESISTANT

FLEXIBLE BODY

RECYCLABLE

EASY CARE

SCRATCH  
RESISTANT

ZERO PVC

LONG  
LASTING

HIGH TENSILE  
STRENGTH

ABRASION  
RESISTANT

SMOOTH TOUCH

STAIN  
RESISTANT

LESS WATER  
ABSORPTION

CHEMICAL  
RESISTANT

HEAT AND  
FIRE RESISTANT

ENVIRONMENT  
FRIENDLY

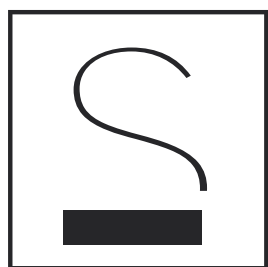
GERMS FREE  
HYGIENIC SURFACE

SPILL PROOF





## Surface



The beauty of the PORCEKO surfaces, is derived from the proximity of polished or matt, shiny spaces, mutually emphasised by the light reflecting on the slabs.

### Crestamattè®

Introducing the exceptionally vibrant – "Cresta Matte Surface", that has an unwrinkled matt finish, makes the Porceko Slabs a versatile product to engage in.

Whether looking for an increased durability, or less maintenance efforts, the cresta matte finish slabs are a premier choice to go with. The slabs are super smooth in its touch, thus breaking the myth that matt surfaces are always rough in its texture. Being resistant to any kind of scratches or stains, render the slabs in becoming an ideal solution to be used in any of your spaces.

"Easy to clean with no spots to be seen – The Cresta Matte surface slabs lends a magical feel to all your needs."

### ULTRA GLEAM

Introducing the marble spirited - "Ultra Gleam Surface", the Porceko slab has an eye sparkling mirror like finish, making it a perfect alternative for marbles. The brighter look gives an elegant and spacious view to the ambience. The enamel coating and hard grinding discs, render a sleek surface to the slabs. Highly durable in its surface is what makes the Porceko slabs quintessential solutions for any of your spaces.

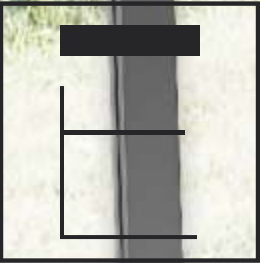
### POLISHED

The through body porcelain Polished surface lends a subtle glossy finish to be bewitched with. An exquisite Polished Porceko slab possess colours and chips that cross the whole body of the slab on its surface, enabling the slabs to hide the scratches over it. Composed of the same material throughout, the colour of the top surface passess exactly same to the body , thus imparting a full body feature to the slab. "The unique aesthetic values and technical performance" render the Polish Surface suitable for both residential use and commercial use, even for more demanding stresses.





Edges Possibilities



Double Bevel



Half Bevel



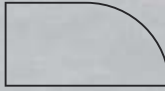
Half Bull Nose



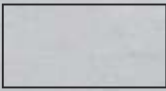
Flat Edge



Full Bullnose



Demi Bullnose



Straight With  
Eased Edges



Pencil  
Round



Double  
Pencil Round



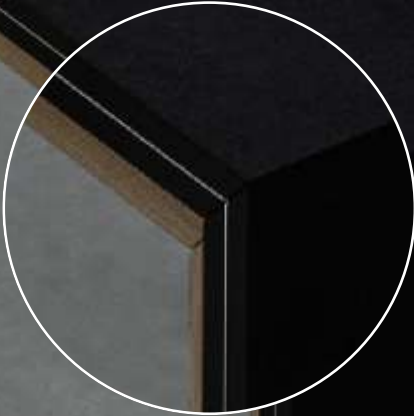
Double Quarter  
Round



Square Ride  
At 45°



Quarter  
Round

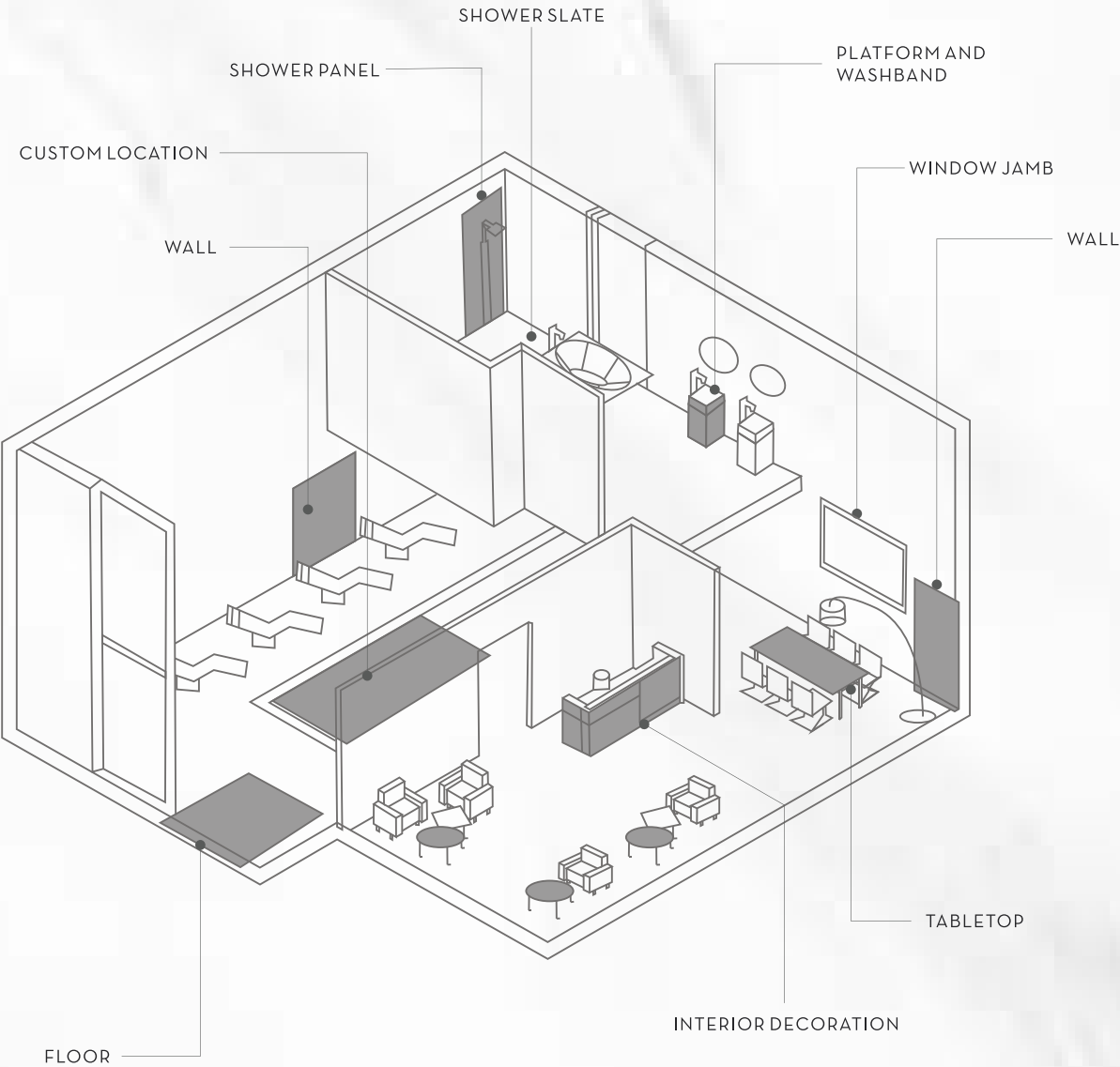
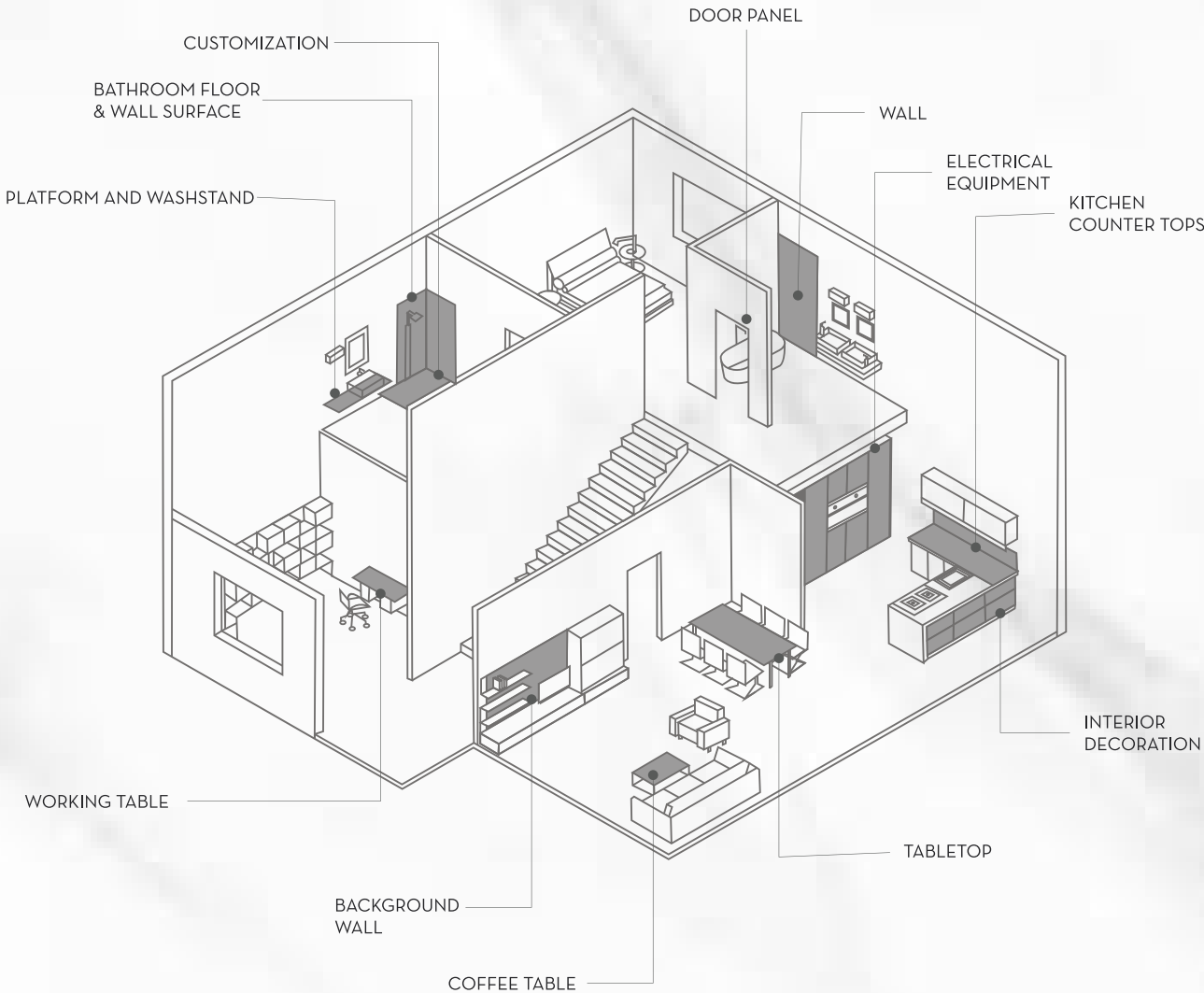


“SANDWICHED  
PORCEKO  
PORCELANITE SLAB”





RESIDENTIAL  
SPACE  
APPLICATION



PUBLIC  
SPACE  
APPLICATION



# Quarry White

Collection



Inspired by the Italian marble textures, the Quarry White collection simulates the beauty of a real marble for a fraction of the price. Digitally recreated veined patterns combine with the flat ultra-gloss surface to give a highly reflective detailed finish, together with the precision as close as a replication of the natural marble stone. Possessing Statuario, Carrara, Quartzite and other such exquisite designs, the collection offers both bold and yet subtle variety of patterns, that render an infinite choice to impart a refinement for all, from modern to classic spaces.





**BORGHINI**  
*Borghini*

## BORGHINI

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE

Known for the highest marble quality replica, the Borghini Porceko Slab is inspired from one of the oldest marble of Italy which adds a dynamic range to the customary slab collection. Tinges of honey-accented veins with a grey colour fusion, the crisp white background adds a beautiful warmth that balances white modern features and complements earth-tones.

Being the slab a brilliant choice for developing a classic refined style in kitchens and baths, Borghini has garnered a reputation as an especially rare and luxurious choice for personal residences always.





Bar Counter/Table | Patagonia Pie | Quarry White





PATAGONIA  
*Pie*

## PATAGONIA PIE

Inspired from a Brazilian Quartzite, The Patagonia Pie Porcelo Slab combines light uniform and transparent quartzite like look in its structure. Distinguished by a combination of shapes and colours: some parts of white, black, beige and brown, alternating with other shades of translucent grey and golden veins, the slab takes the spotlight of the surroundings placed in.

Its hardness and resistance properties build a pertinent fit for both private and public spaces, including kitchen tops, tables, coffee tables and bathroom surfaces.

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE

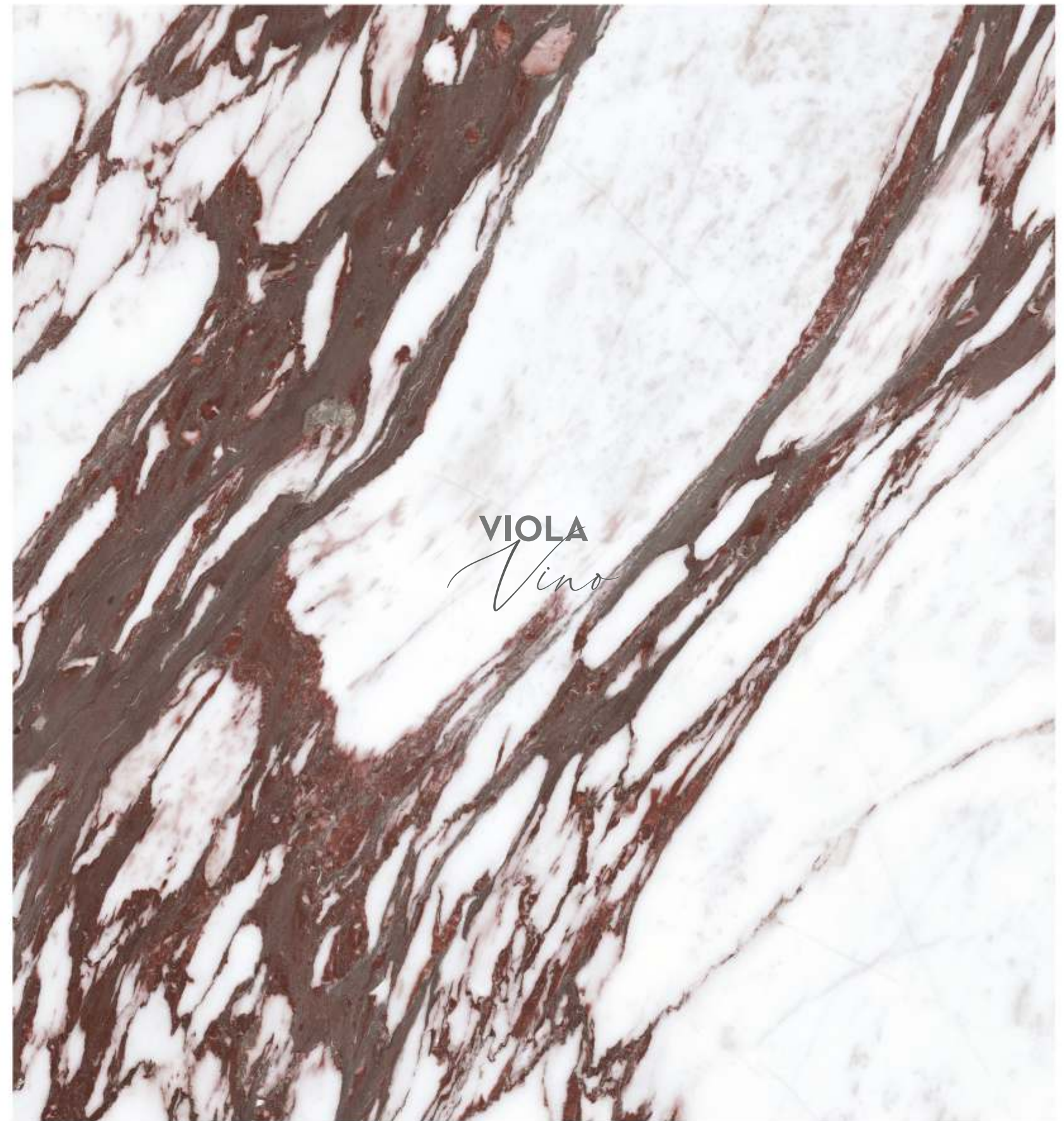


Bar Counter/Table | Patagonia Pie | Quarry White









## VIOLA VINO

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE

A vivid and elegant stone replicating Italy's most loved Viola Marble, the Viola Vino Porcelo slab incorporates a classic white background with an upscale rich burgundy veining, a combination sure to captivate the eyes and mesmerize the heart of the audience.

Stocked in 15 mm thick with an ultra - gleam finish, this Italian marble replica has a variety of application uses, resembling it a perfect natural stone like centerpiece in your surroundings. The Viola Vino slab compels in a sense of traditional European charm while helping create striking modern settings too.









## CASTELLO QUARTZITE

Castello quartzite slab offers a beautiful game of contrasts between the white background and grey - brown veins. Created by merging the diverse geological formations, the slab leaves behind a moon - like magnificent visual impact.

The fluidity of its lines is ideal for large-format claddings with a distinct style and vein continuity. Preferred by the architects and designers for unique hotel and residential projects, the product is perfect for all areas including bathroom cladding, accented walls, and murals too.

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE



Table | Castello Quartzite | Quarry White





Kitchen/Wall | Carrara Blanco | Quarry White  
Floor/Kitchen Top | Pixel Grey | Pixelite





Stair | Carrara Blanco | Quarry White



CARRARA  
*Blanco*

## CARRARA BLANCO

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE

Inspired by the authentic Carrara Marble, Carrara Blanco is a result of meticulous selection process, possessing delicate shades of white and grey veining formed throughout the surface.

Classified as a premium marble that embodies distinction, classicism, and exclusivity, thanks to its unique aesthetic properties, that have an ability to uplift the face of any of the interior projects.





Kitchen | Statuario Natural | Quarry White  
Floor | Pixel Verde | Pixelite





Wall | Statuario Oro | Quarry White  
Floor | Pixel Crema | Pixelite





STATUARIO  
*Natural*

## STATUARIO NATURAL

Inspired by the most loved Italian Statuario Marble, the Statuario Natural Porcelo Slab is an exclusive stone in which fluid grey and gold veining, contrasts a luminous white canvas. The striking bold pattern of the stone appeals to designers and architects alike. The slab is more than a statement piece but a long-lasting natural stone replacement.

Its gleaming natured surface provides endless designing possibilities, thus making it a versatile and unique marble stone.

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE



Kitchen | Statuario Natural | Quarry White  
Floor | Pixel Verde | Pixelite





Wall | Statuario Oro | Quarry White  
Floor | Pixel Crema | Pixelite



STATUARIO  
*Oro*

## STATUARIO ORO

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE

The Statuario Oro is fiercely bold with a marbled white backdrop that sets a perfect stage for the grey coloured veins to intertwine throughout. When too much is just enough, this design will be the perfect enhancement to any room.





Wall / Table | Venatino | Quarry White  
Floor | Pietra Regio Grey | Neoteric





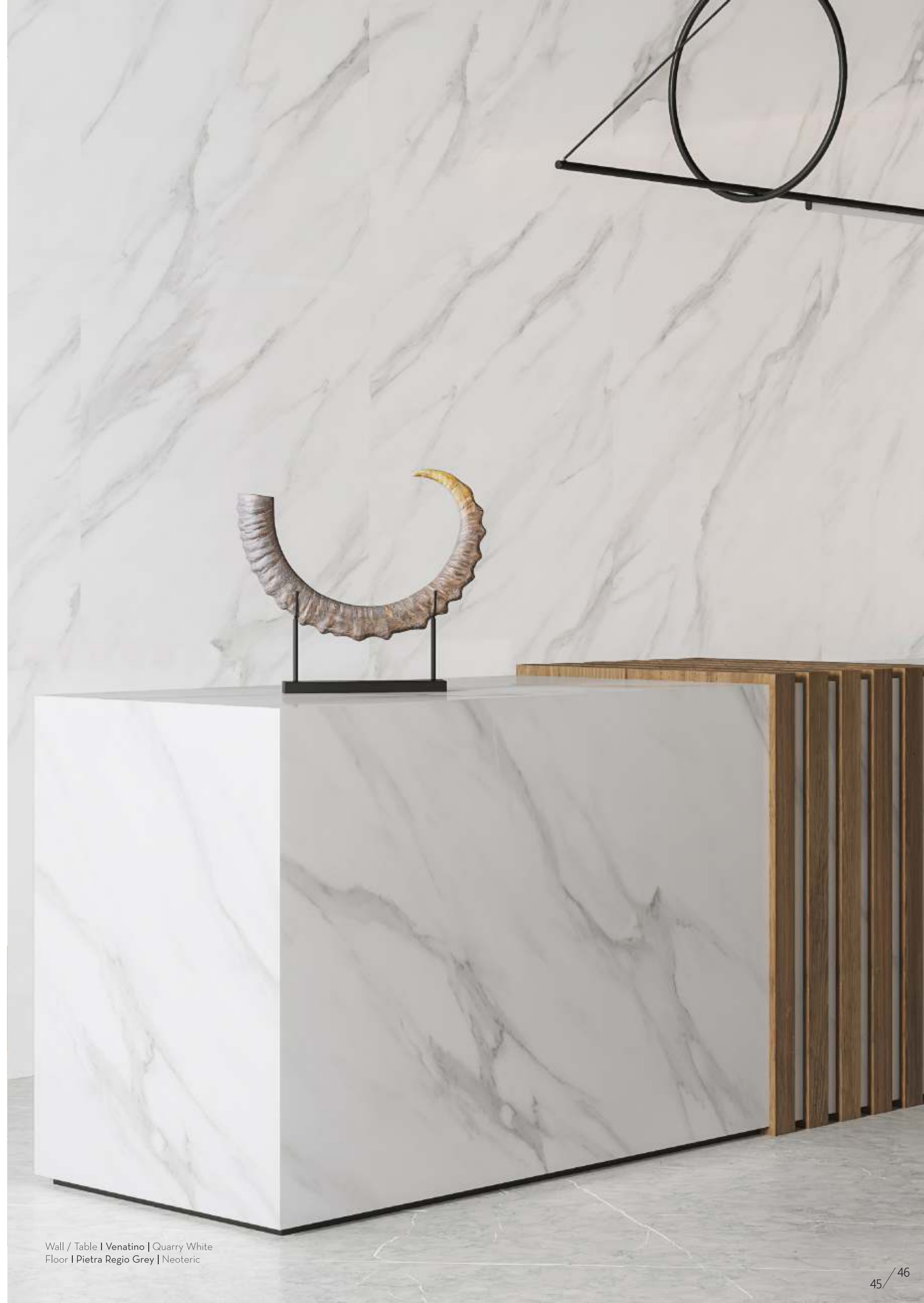
VENATINO  
*Venatino*

## VENATINO

White marble inspired porcelain slab, Venatino has a white tone base, subtly marked by soft grey streaks.

The beauty of the ultra - gleam finished surface, generates a more spacious feel to any of your surroundings, thus making it an unparalleled natural stone substitute to dress up the luxury interiors in a graceful manner.

FINISH | ULTRA GLEAM  
BODY COLOR | WHITE






Wall / Table | Venatino | Quarry White  
Floor | Pietra Regio Grey | Neoteric



<b>01</b> DESIGN Name of design for ordering	<b>04</b> DESIGN DETAIL Addition technical specification of tile.
<b>02</b> COLLECTION Name of collection for ordering	<b>05</b> DIMENSION The measurement of the length, width and thickness
<b>03</b> SYMBOLS Production related specifications described individually below	<b>06</b> VARIANTS Design random faces or colour randomness.

SYMBOLS/Description

Description Of The Symbols  
And Classification Used In This Catalogue

<b>M</b> CRESTA MATTÈ SURFACE Easy to clean with no spot to be seen, the Cresta Matté Sur face lends unwrinkled matt finish to an ambient.	 BODY COLOR Color of ceramic body beneath surface of slab
<b>G</b> ULTRA GLEAM SURFACE Phenomenal marble look with strength, Ultra Gleam Surfaces are quintessential solutions with mirror like finish.	 GRAPHIC VARIATION Indicates the degree of graphic variation –understood as the diversity of designs– within the same collection and it can also vary depending on the format.
<b>P</b> POLISHED SURFACE Subtle gloss with high endurance render, Through-Body Polish Sur face makes it suitable for stressful purpose with minimal look.	 COLOR VARIATION Indicates the degree of shade variation in the collection. Indicates the variety of tones –understood as the richness of colours– that one same piece can have.

Additional Information

PORCEKO provides a number of different faces for the same item, to create a pleasant aesthetic variability when fixed. The order preparation process assures a random face selection. For this reason neither the vein continuity through the ordered slabs nor the sequence of the various faces can be guaranteed. The continuous veining between slabs is subject to the typical variation tolerances of particular products.

01

02

03

LA OTTIMO INVISIBLE

NEOTERIC

V4

G4

M

O

06

05

04

SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
Crestamattè®

COVERAGE  
25.51Sqft

WEIGHT  
86 Kgs





# Quarry White

Collection



CARRARA BLANCO QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

STATUARIO NATURAL QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

VENATINO QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

STATUARIO ORO QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

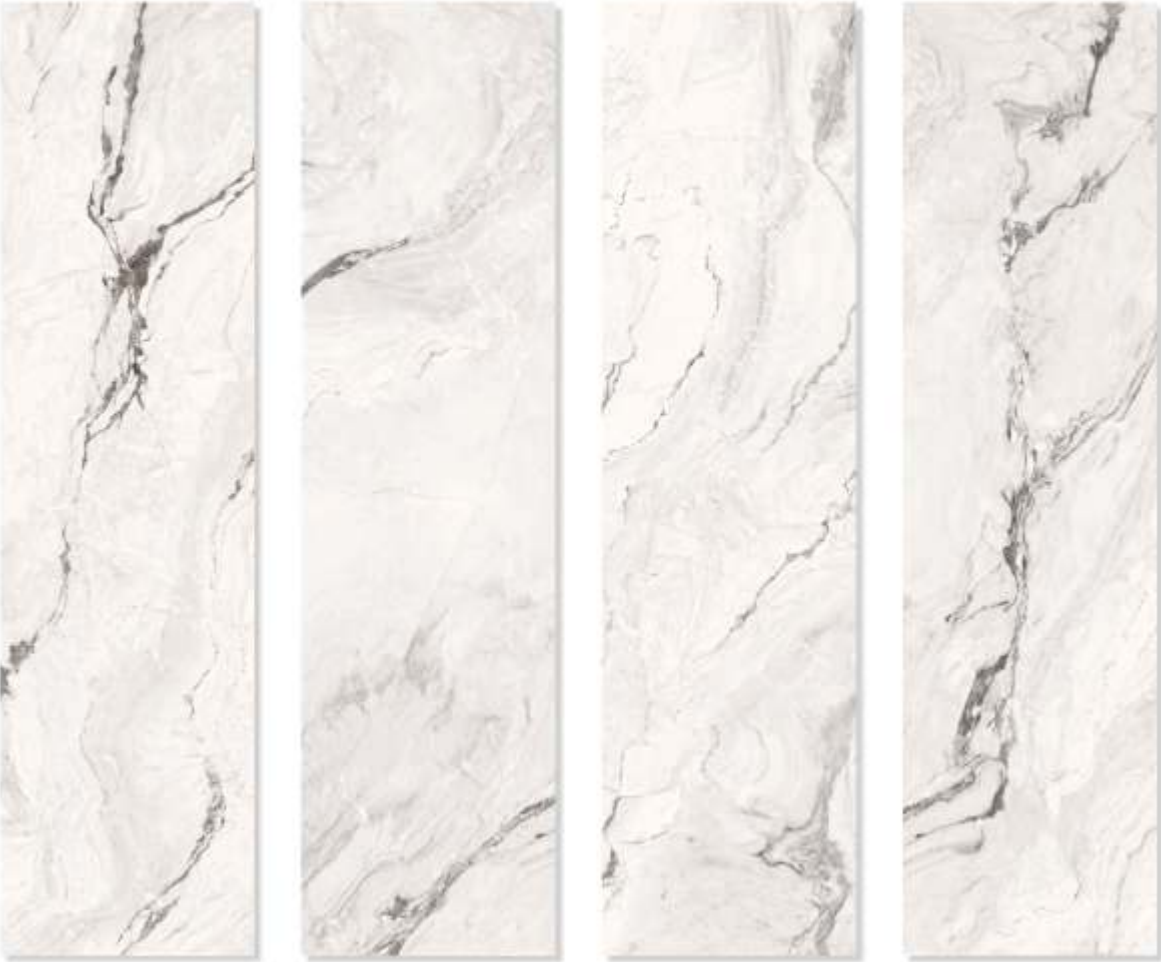
FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs



CASTELLO QUARTZITE QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

PATAGONIA PIE QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

BORGHINI QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

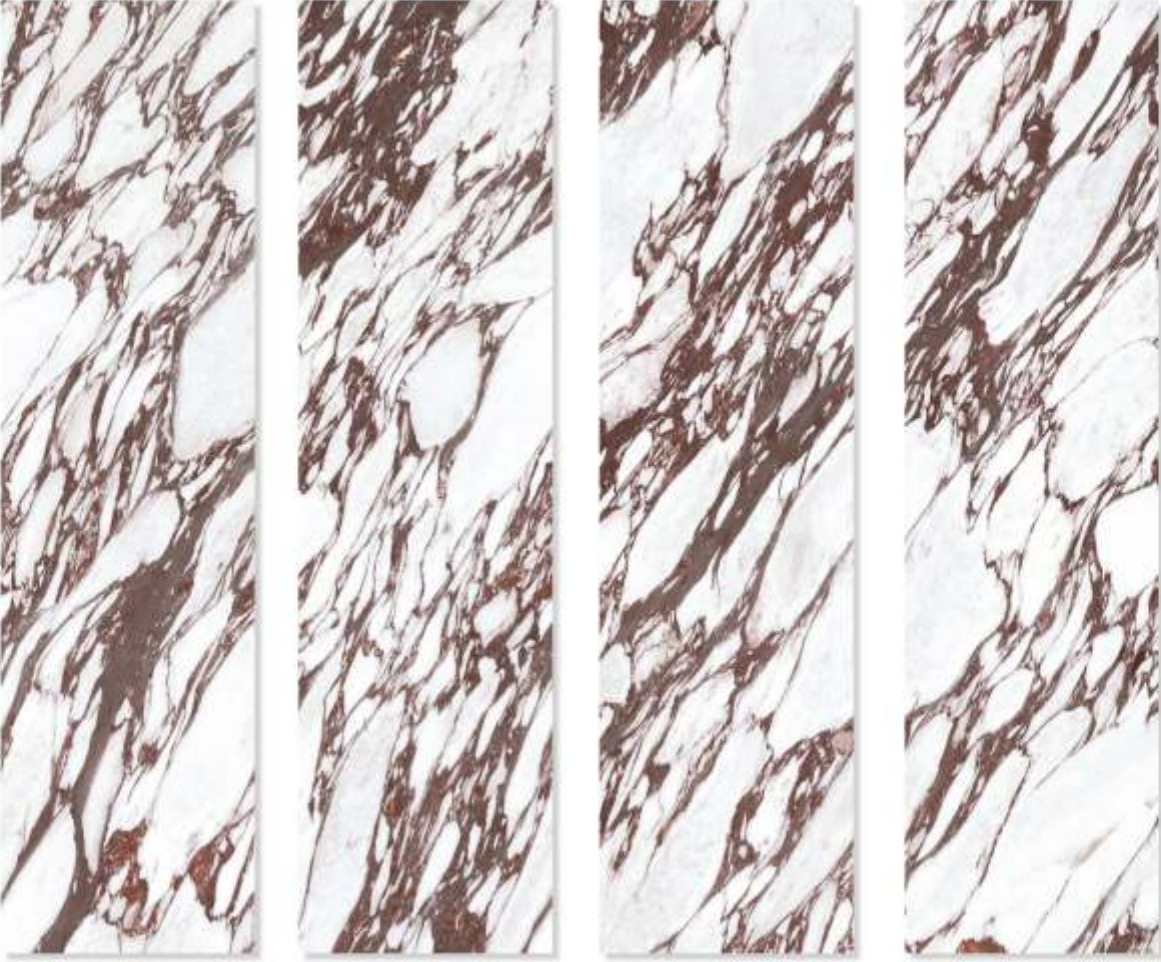
BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs

VIOLA VINO QUARRY WHITE



SIZE  
790X3000MM

THICKNESS  
15MM

BODY COLOR  
WHITE

FINISH  
ULTRA GLEAM

COVERAGE  
25.51 Sqft

WEIGHT  
86 Kgs



TECHNICAL  
SPECIFICATION



Shower | La ottimo invisible | Neoteric  
Floor | Pixel Grey | Pixelite

CHARACTERISTIC	STANDARD AS PER ISO13006:2018/EN14411 Gr.Bla	MEAN VALUE OF PORCEKO	TEST METHOD
Regulatory Properties			
Deviation in Length and Widt	± 0.30 % (±1.00mm)	± 0.10 %	ISO 10545-2
Deviation in Thickness	± 5.00 % (±0.50mm)	± 4.00 %	ISO 10545-2
Straightness in Side	± 0.30 % (±0.80mm)	± 0.10 %	ISO 10545-2
Rectangularity	± 0.30 % (±1.50mm)	± 0.10%	ISO 10545-2
Surface Flatness Central Curvature	± 0.40 % (±1.80mm)	± 0.20 %	ISO 10545-2
Surface Flatness Edge Curvature	± 0.40 % (±1.80mm)	± 0.20 %	ISO 10545-2
Surface Flatness Warpage	± 0.40 % (±1.80mm)	± 0.10 %	ISO 10545-2
Surface Quality	± < 95% defects free	< 95% defects free	ISO 10545-2
Small Color Difference(for Plain Colour)	E > 0.75	E > 0.30	ISO 10545-16
Glossiness ( Polished)	as per mfg.	Gloss Value<90	Gloss Meter 60°
Glossiness (Matt)	as per mfg.	3 <Gloss Value>7	Gloss Meter 60°
Glossiness (Satin/Posh)	as per mfg.	7>Gloss Value>18	Gloss Meter 60°
Structural Properties			
Water absorption	≥0.50 %	≥0.060 %	ISO 10545-3
Bulk density	as per mfg.	Min. 2.28 g/cc	ISO 10545-3
Massive Mechanical Properties			
Modulus of Rupture (For ≤15 mm)	Min. 35.0 N/mm <sup>2</sup>	Min. 42.0 N/mm <sup>2</sup>	ISO 10545-4
Breaking Strength Thickness ≤7.5 (For ≥15 mm)	Min. 1300.0 N	Min. 7500.0 N	ISO 10545-4
Surface Mechanical Properties			
MOH'S hardness #	as per mfg.	Polished Min. 4*/ Satin,Posh & Matt Min. 6	BS EN 15771
Deep abrasion resistance #	Max. 175mm <sup>3</sup>	Max. 132mm <sup>3</sup>	ISO 10545-6
Thermal Hydrometric Properties			
Moisture expansion	Max. 0.06%(0.6mm/m)	Max. 0.02mm/m	ISO 10545-10
Thermal expansion(COE) at 100°C	as per mfg.	Max. 6.0 x 10 <sup>-6</sup>	ISO 10545-8
Thermal shock resistance	Min. 10 Cycle	Min. 10 Cycle	ISO 10545-9
Impact resistance(COR) #	Min. 0.55	Min. 0.55	ISO 10545-5
Frost resistance	as per mfg.	Frost Proof	ISO 10545-12
Chemical Properties			
Resistance to staining glazed	Min. Class 3	Min. Class 4	ISO 10545-14
Resistance to house hold chemicals & swimming pool salts glazed	Min. Class UB	Min. Class UA	ISO 10545-13
Resistance to low concentrate acid and alkalis glazed	as per mfg.	Min. Class ULB**	ISO 10545-13
Resistance to high concentrate acid and alkalis glazed	as per mfg.	Min. Class UHB**	ISO 10545-13
Safety Properties			
Skid resistance(DCOF-WET PENDULUM) ##	as per mfg.	Glossy Po(<12),Satin, Posh ≤P1(12 <sup>34</sup> ) Matt -P2(25 <sup>34</sup> )	BS 7976-2
Slip Resistance -Satin/ Matt	as per mfg.	R9 to R13	DIN 51130
Parameters are applicable for 1st Choice/Premium Grade Materials Only.			
* With Nano polished			
** Except Hydrofluoric Acid & it's compound			
# Tiles Intended for use on floor			
## As per customer requirement			

PACKING DETAILS

PRODUCT	SIZE	ACTULE SIZE	THICKNESS	TILES / BOX	COVERAGE AREA / BO	
Porcelanite Slab	80x300cm	800x3000mm	15mm	1pc	25.83 Sq ft	2.39 Sq m
Porcelanite Slab	79x300cm	790x3000mm	15mm	1pc	25.51 Sq ft	2.37 Sq m



INSTALLATION

CLEANING & MAINTENCE

After each cutting operation on waterjets, disc cutters, or numerical control machines, clean the slab surface with plenty of water to remove any processing residues, then dry with a squeegee or similar. To eliminate any residues of dust after fabrication, we recommend washing the product using a mild acid based detergent. After installing the material, clean the surface to remove any contaminants (glue or other adhesive residues...) which is present.

TYPE OF STAIN	CHEMICAL PRODUCT	EXAMPLE
Grease	Alkaline - Solvent	Detergent
Oil	Solvent	Ammonia, Backing Soda
Ink	Oxidant - Solvent	Alcohol, Liquid Bleach, Nail Paint Remover
Rust	Acid	Hydrochloric Acid, Vinegar, Red Harpic
Lime	Acid	Descaling Reagent, Hydro Chloric Acid
Cement	Acid	Hydro Chloric Acid
Wine	Alkaline	Ammonia, Liquid Bleach
Coffee	Alkaline - Solvent	Ammonia, Liquid Bleach
Rubber	Solvent	Alcohol, Thinner
Plaster	Acid	Hydro Chloric Acid
Candle Wax	Solvent	Alcohol, Thinner
Iodine	Oxidant	Liquid Bleach
Blood	Oxidant	Liquid Bleach
Ice Cream	Alkaline	Liquid Bleach

NOTE: Clean the affected areas using a soft cloth dampened with acetone or solvent, as indicated by the adhesive manufacturer. If necessary, we recommend protecting the surface of the slab before applying adhesive, with a plastic film or masking tape. Moreover, clean the slab surface after installation with water and neutral detergent using a sponge or damp cloth.

Do not use abrasive sponges or detergents containing abrasives.

Clean liquid spills such as coffee, tea, cola, etc. quickly off the surface with an absorbent cloth For everyday cleaning of the Porceko Porcelanite Slab use hot water and neutral detergents if required, with a soft cloth.

INSTALLATION

Install the Countertop at a distance of 2-3 mm from the wall for Joint.

Porcelain Slab can be fix same as natural Stone and other engineered stone with suitable Bond adhesive and epoxy.

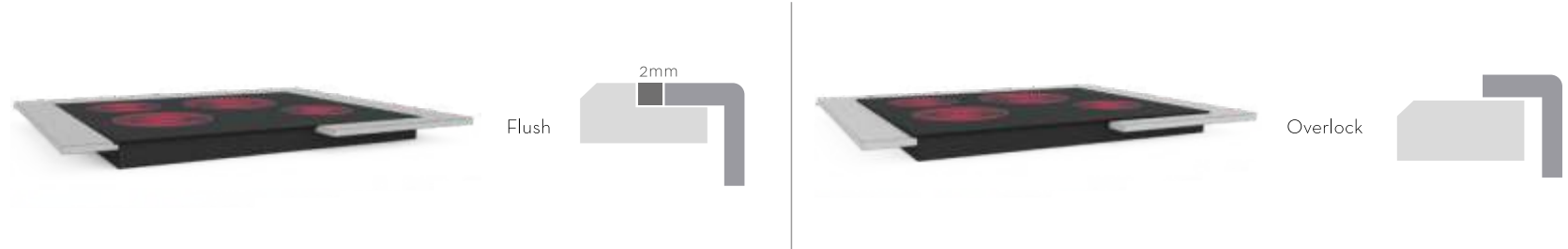
In the design of a kitchen top, maintain a minimum distance of 50 mm (2 inch) from the outer edge with holes and grooves. The same minimum distance must be maintained between adjacent openings.

The countertop edge can be finished using automatic machinery or by hand, depending on the visual effect desired.

The flat edge is the finish that keeps the body edge of the slab visible. It can be used as a perimeter edge for tabletops and kitchen tops, or to finish the sink hole when the sink is fitted beneath the top. Subsequently, where required, it is possible to polish the edge using a sequence of abrasive diamond grinders, with increasing grit size, on numerical control machines. To guarantee the durability of the edge over time, the straight edge must end with a chamfered angle of at least 1 mm. Generally, only the upper corner must be chamfered, but in some cases, it may be necessary to chamfer on both sides: in this case, use a tool that can perform the operation in a single passage.

To join Porceko Porcelanite Slab edges, use a color matched 2-part epoxy, polyurethane, or equivalent. We also recommend that a mock-up be prepared for the first bonding, testing the sample under the most severe conditions, according to the final application, to assess the stability of the support panel.

A Good Craftmanship is always Recommended



The need to add sinks and induction hobs on countertops offers different possibilities. It is recommended to leave always at least 2mm between the fixture and the edge ofthe cut-out.If it is chosen the over-mount installation, it must be guaranteed the water tightness, sealing the joints correctly with natural silicone. Do not undercut edges more than 4mm.

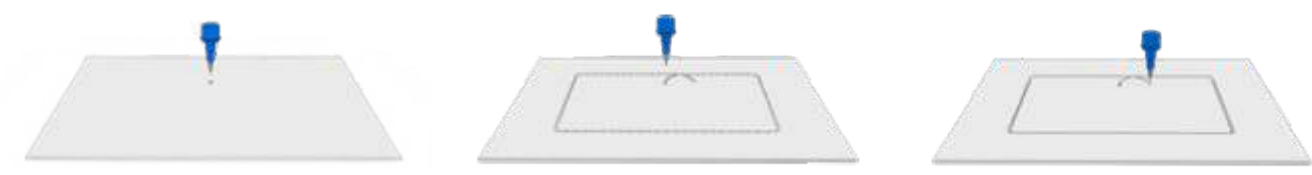


In the case of installing large format sinks, it is recommended to use a sink setter or support rail system in order to avoid peeling it off or even the breakage of the piece.





# WATER CUTTING MACHINE (BRIDGE TYPE)



The use of a water jet cutting machine lets us make anytype of cut or drill with a high precision level. The quality ofthe cut finish will depend on the correct combination of the parameters recommended on the table. This combination can be slightly different depending on the available machinery. As with the CNC cutting machine, we shall always start with an initial drill inside the opening space, located preferably in the farthest part from the edge of the piece, when cutting an inner opening. From here we shall cut along the cutting perimeter getting to it with a curved movement. If the edge finish needs to be polished, we recommend reducing to half the speed for a smoother and easy to work finish.

Abrasive	Speed
300-380 g/min	white 0.4 m/min
	other colours
Initial pressure	Maximum pressure
700-800 bar	3500-3800 bar

## MANUAL WORK

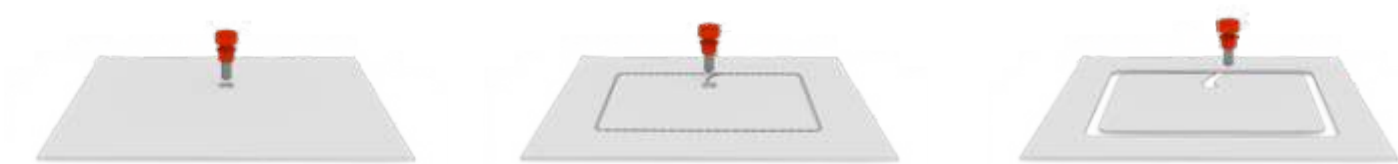


Some stonemasons or ountertop workers work in a traditional way, making cuts and holes in thepieces manually. We thus recommend always using wet operation, with suitable tools for porcelain tiles, always in good condition.



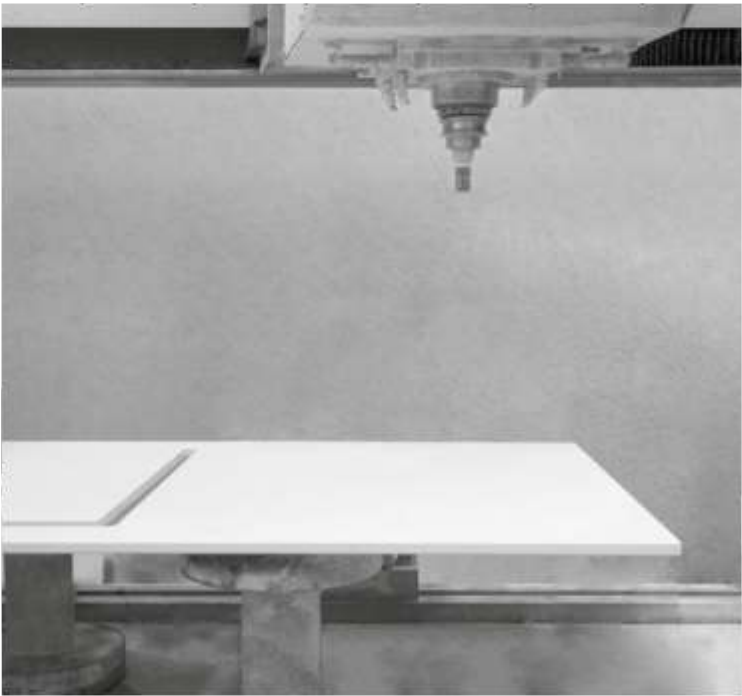
When making rectangular spaces inside the plate, we shall previously drill out holes on the rectangle's four corners, thus observing the recommended radii, and then making straight cuts joining the four drills.

# NUMERICAL CONTROL CUTTING MACHINE (CNC)



It is possible to cut holes and inner openings with a numerical control machine and the suitable tools (crown, diamond coated drill bit, etc.). To do this, we shall always start with an initial drill inside the opening space, located preferably in the furthest part from the edge of the piece. From here we shall cut along the cutting perimeter getting to it with a curved movement.

We recommend reducing the speed as the tool comes out. To prevent breakage of the plate during the machining process, the suction cups need to be correctly distributed and at least a couple of them shall be placed so that they prevent the scrap piece from rotating when we finish cutting. We shall avoid blocking the piece with clamps.



## CIRCULAR SAW CUTTING MACHINE



For making straight cuts with the bridge-type cutting machine we shall use diamond cutting blades suitable for porcelain tiles (eg, Italdiamant, Luna Abrasiv, etc.), always in good condition, and follow the blade manufacturer's recommendations. The water flow shall be at its maximum while cutting to ensure the correct cooling of the blade. To avoid overheating in the lighter models, which usually have a higher hardness,

Diameter	rpm approx	Speed
300mm	2100-2800	white
350 mm	1900-2500	0.5 m/min
400mm	1700-2300	other colours
450 mm	1400-2000	1 m/min
500mm	1200-1600	

values recommended by

	Diameter	rpm approx	Speed
Drill	23mm	3700-4100	0.2m/min
	15mm	3900-4000	
	20-22-23mm	3500-4000	
Crown	25mm	3000-4000	0.15m/min
	30-35mm	3000-3500	
	68-70-75-105mm	1000-1500	

values recommended by





# UPSHOTS

DESIRE | INSPIRE | ADMIRE

2022



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