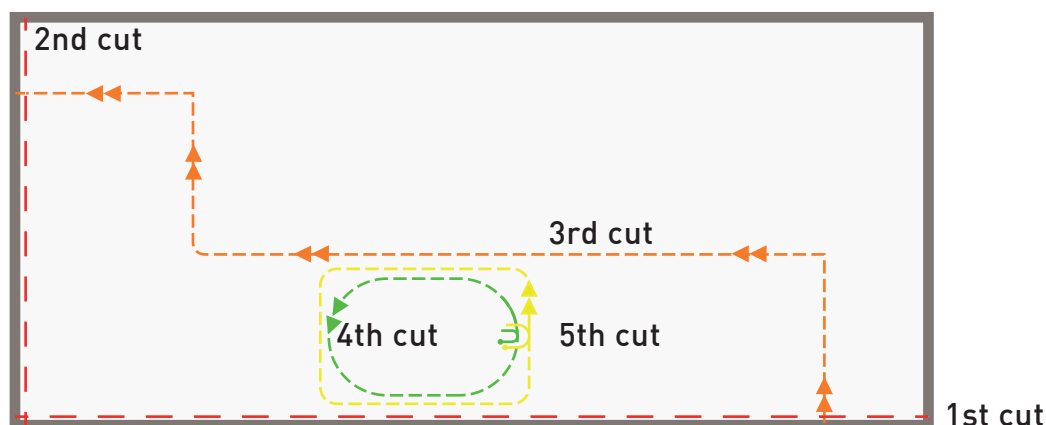


# MACHINING

## WATERJET CUTTING OF WORKPIECES

Before starting to cut a slab in a waterjet machine check that the worktable is in good condition and that you have complied with the indications given in our Lapitec<sup>®</sup> Technical Manual and in this Newsletter to ensure optimal machining results.

### Cutting sequence



### Machining steps:

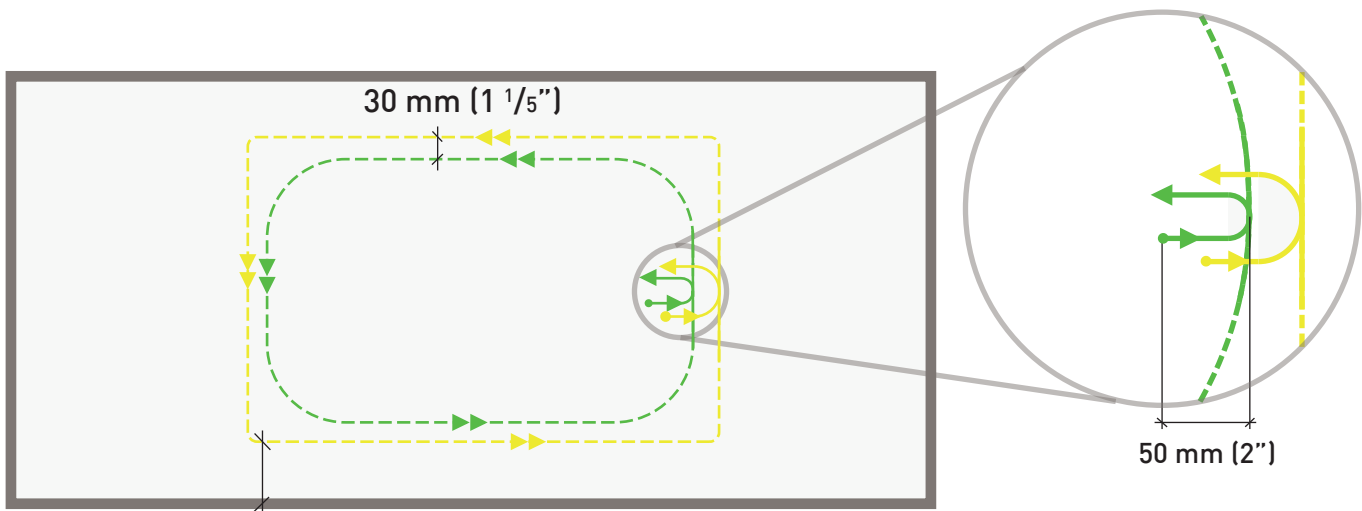
- 1-2. Slab trimming (colour portions red)
3. Workpiece shape cutting (colour portions orange)
4. Sink pre-cutting, if required (colour portions green)
5. Sink cutting (colour portions yellow)

## Sink cutting

If one or more of the following conditions apply, follow this cutting diagram:

- non-flat resting base
- islands measuring more than 2600x600 mm (102x23 1/2")
- sinks measuring more than 560x480 mm (22x19")

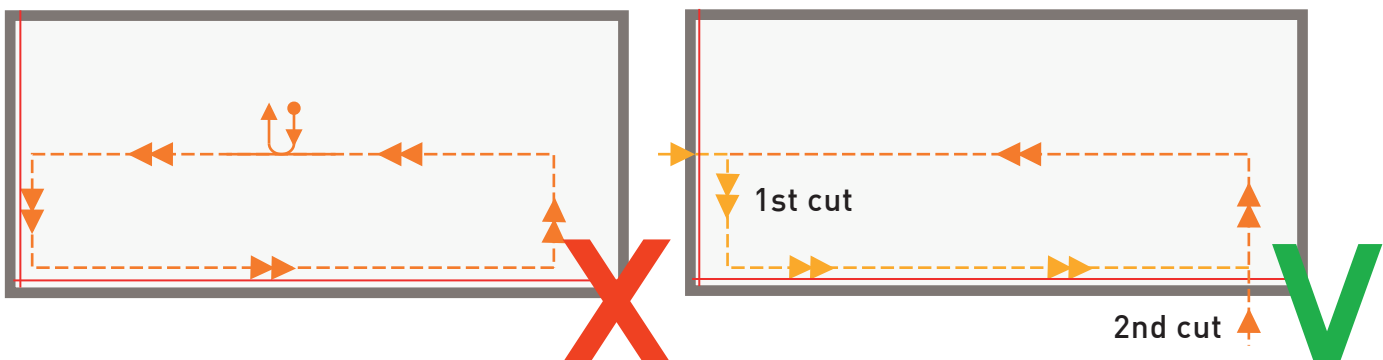
N.B.: the sink cut must be started inside the pre-cut as shown in the diagram below



Minimum recommended distance 50 mm (2")

## Cutting diagram

If you decide to cut the shape inside the trim cuts, it is good practice to divide the cutting geometry into two parts, always starting with the cuts from outside of the slab.



## Internal angles

All internal angles must follow a radius of at least 5 mm ( $\frac{3}{16}$ ").

A larger radius gives more structural strength to the workpiece, while any non-radiused angle will create a stress point on the top.

