

# TECHNICAL INFORMATION

## STENI cutting disc

### STENI DIAMOND CUTTING DISC

Diameter = 150 mm, Thickness (t) = 2,6 mm, Bore = Ø30 mm. A liner is supplied for spindle/shaft diameters of d20, d22.2 and d25.4 mm.

### CUTTING PANELS

STENI panels with a painted finish should be cut from the front side of the panel.

STENI panels with a surface of crushed natural stone should be cut from the back side of the panel.

### CUT DEPTH

Set the blade to cut about 6 mm deeper than the panel thickness.

### FOR BEST RESULTS

Cut the panels on a stable and level surface. There must be no warping or imbalance in the cutting disc, and the STENI panel must be held firmly to keep it from vibrating during cutting. If there is imbalance in the cutting disc or the panel vibrates, it will produce a jagged and rough cut. A solid, spokeless cutting disc greatly reduces the risk of splintering. Any sharp edges can be smoothed out using sandpaper P120 along the edge (once). Before installing the panels, cutting dust must be removed using compressed air and a damp fibre cloth or a damp fibre cloth with an alkaline Basic Cleaner.

The diamond cutting disc should cut easily, with a steady feed pressure. Cutting speed depends on the power of the saw, RPMs and the operator's feed pressure. Excessive feed pressure often generates heat in the diamond cutting disc and the panel. If the diamond cutting disc overheats, it will cause an imbalance and lead to "wobbling" (the disc will expand and wobble from side to side). The cutting disc will normally return to its original shape once it cools. Hot fibreglass from overheated panels can give off particles that stick to the cutting disc. The ideal RMP for a 150 mm diamond cutting disc is 7500 RPM.

### SAFETY

- Always follow the manufacturer's safety description.
- Use only CE marked machines with proper safety protection.
- Always use personal protective equipment such as goggles, hearing protection and a dust mask (min. P3).



STENI material safety datasheets can be downloaded from [steni.com](http://steni.com).

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