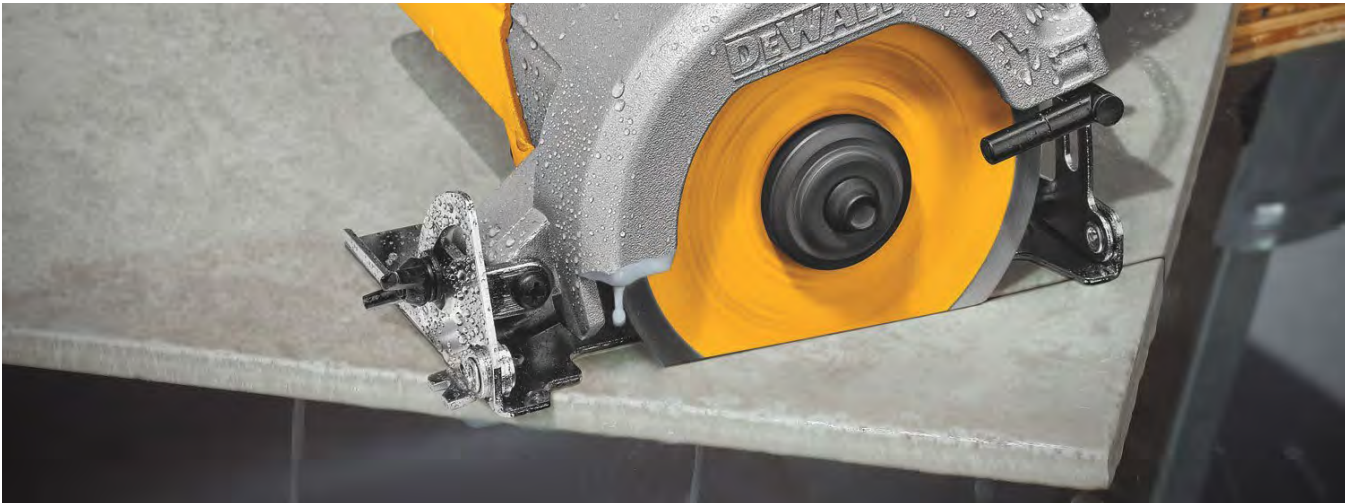


Field Cutting Instructions



SUGGESTED CUTTING TOOLS

Use a wet saw with continuous diamond rim blade (examples listed below)

DeWalt DWC860W 4-3/8" Wet/Dry Masonry Saw

Alpha 5" Wet Stone Cutter/Saw AWS-125

Makita 4101RH 5" Cutter

MK-1590 Wet Cutting Rail Saw

Recommended for longer cuts or higher volume.

MK Diamond 159414 MK-212-4 Wet Cutting Tile and Stone Saw

Recommended for cross or narrow cuts.

SAFETY + WORK GEAR

Eye protection is required for all cutting operators.
Material Safety Data Sheets (MSDS) are available upon request.

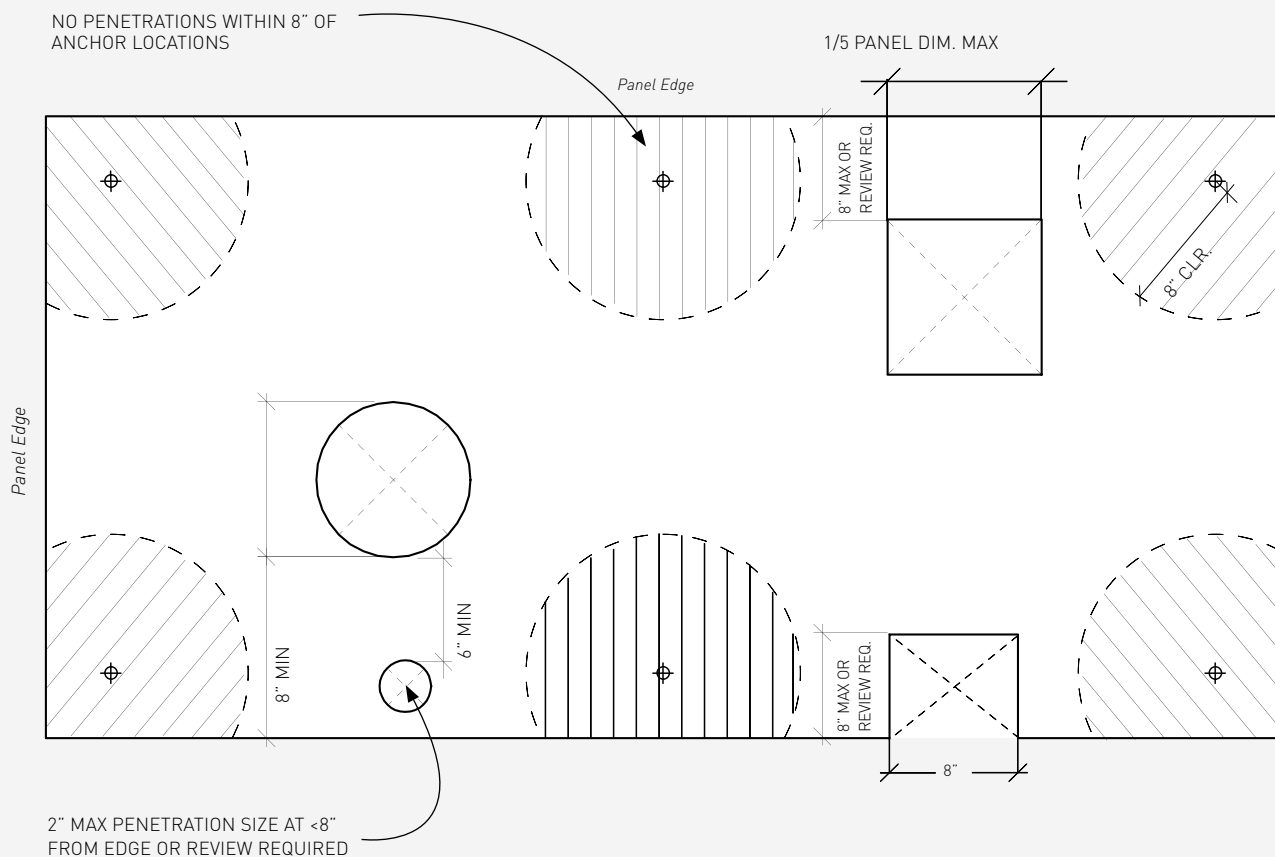
ENVIRONMENT

Please adhere to all local, state, and federal regulations pertaining to the treatment and discharge of wastewater generated as a result of cutting and drilling TAKTL material. TAKTL is a non-hazardous material for the purpose of wastewater classification. Requirements for treatment of wastewater will be specific to project, site location, and cutting/drilling conditions.

TAKTL panels are typically cut per approved drawings prior to shipment. However, situations may arise in which field cutting is required. Be prepared to cut TAKTL in the field in order to accommodate any of the following situations:

- Building dimensions that do not match drawn conditions and require panel adjustments
- Panels ordered as "field cuts" where building dimensions could not be finalized in advance of drawing submission
- Panels ordered as overage in the event that a project panel was damaged during installation
- Occasional errors in drawing, design, or manufacture

Field Cutting + Drilling General Guidelines



SETTING UP THE CUT/DRILL PLACEMENT

- Guideline drawing (above) is provided as a general recommendation.
- Anchor quantity and spacing are to be determined by the project engineer or installation contractor per local codes, standards, and environmental conditions.
- Check for anchor hole locations prior to starting cuts.
- Pilot holes recommended for all drilling larger than 1/4".
- Penetrations should be made only with:
 - 8" minimum clearance from any anchor location
 - 2" minimum clearance from edge for any penetrations <2" diameter
 - 8" minimum clearance from edge for any penetrations >2" diameter
 - 6" minimum clearance between penetrations

IMPORTANT

Before Cutting



Wet cutting is required to reduce heat build up, sustain blade life, and produce clean cuts with the least amount of chatter.



Generally, the tools and techniques used for cutting and drilling stone or ceramics will provide effective results with TAKTL products.

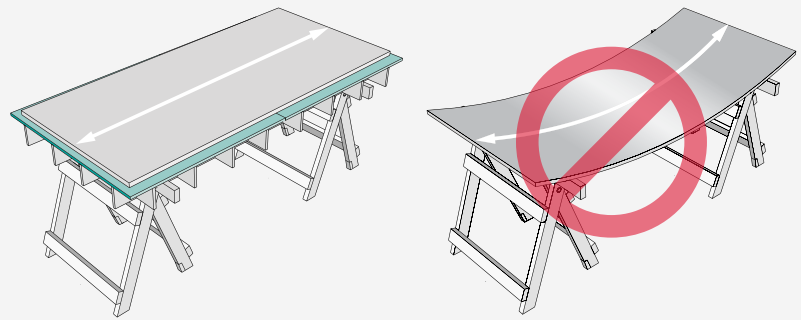


Remember to maintain all TAKTL handling instructions while staging, moving, thoroughly drying, and storing panels.

01 Securing the Panel

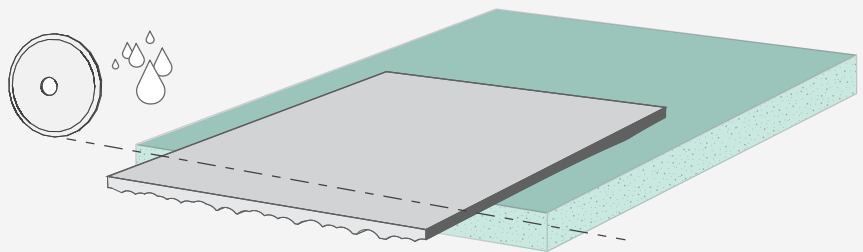
Cut on a large, flat work surface with continuous support to prevent flexing. Do NOT span the panel across unsupported saw horses (FIG. A).

A

**02 Cutting Face Down**

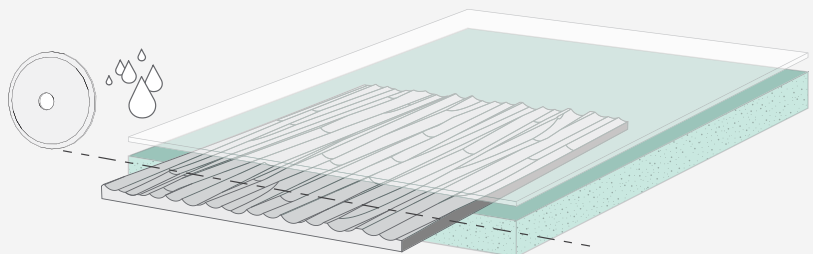
[Recommended] Lay the panel face down on the clean foam provided in shipping crate. Cut from back. Keep the surface uniformly wet (FIG. B).

B

**2.1 Cutting Face Up**

[NOT Recommended] Lay the panel face up on the clean foam sheeting provided in shipping crate. Shield the panel face with Plexiglas, or similar material, to prevent scratching or abrasion to finished surface (for both smooth and textured surface). Keep the surface uniformly wet (FIG. C).

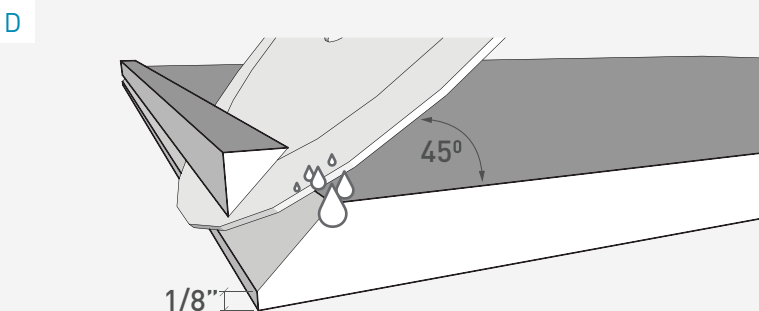
C



03 Cutting Quirk Miters

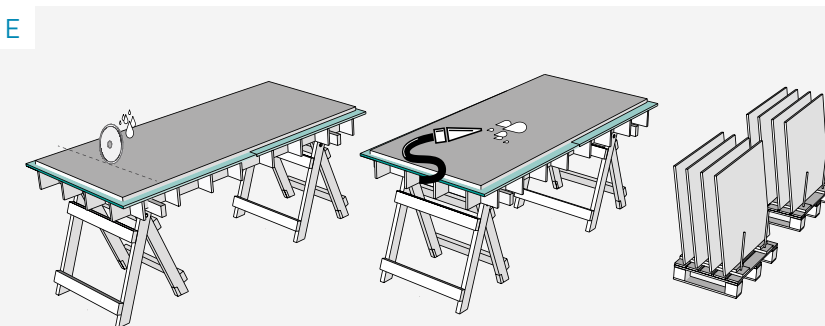
Quirk miters are used in corner applications on some projects to minimize potential for edge chipping.

Set the saw at a 45 degree angle and adjust the fence so that the blade does not cut through the corner, leaving 1/8" return. Keep the surface uniformly wet while cutting (FIG. D).



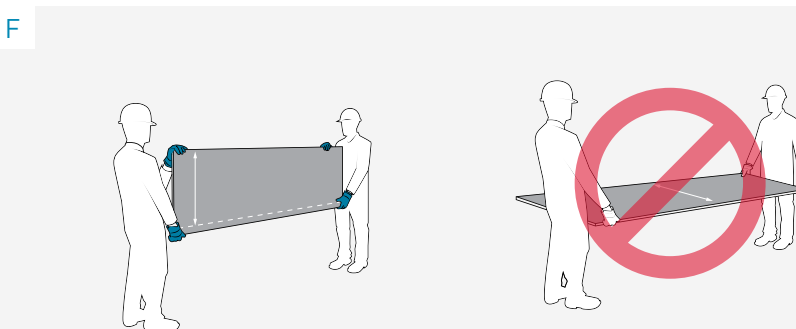
04 Handling the Cut Panel

Immediately after cutting, rinse the panel surface, wipe completely with a non-abrasive cloth or sponge, rinse, and dry with an air stream from a compressed air gun or electric leaf blower. Improper surface cleaning and drying will result in surface staining, water spotting, or adherence of slurry (FIG. E).



05 Moving Processed Panel

Panels must be carried with the shortest dimension perpendicular to the ground, similar to how glass would be handled (FIG. F).



06 Processed Panel Storage

Panels should be stored on edge in a staging rack for ventilated drying. Alternatively, panels may be re-crated with original padding (only if completely and evenly dried). Panels should always rest on back edge atop clean foam, provided in shipment, to prevent chipping (FIG. G).

