

 <small>a steelcase company</small>	MANAGEMENT SYSTEEM <small>volgens ISO 9001, ISO 14001, OHSAS 18001, EEA, EN-ISO 28722, IEN-SO 28762, EN14434, C2C, SCS.</small>	Doc. nr. : 35.312E
		Aanmaakdatum: 27/02/2001
		Revisie nr.: 0
	Set up waterjet PolyVision Genk	Wijzigingsnr.:
		Datum:

1 Speed:

Panelcomposition	Total thickness	Speed m/min
Ceramicsteel/ HC / Z	Up to 16 mm	1 to 1.3
	>16 mm	0.8 to 1
Ceramicsteel / Z	All thicknesses	0.7

Note: always cut with the enamelside up

2 Flow of sand:

Between 170 and 190 grams per 30 seconds

3 Pressure:

3000 to 3300 Bar

4 Nozzle:

Diameter of 0.030

5 Orifice:

0.010 when using the green Olivine sand

0.013 when using the red Garnet sand

6 Type of sand:

We only use sand of 120 mesh, but of 2 different suppliers.

6.1 Panels

For soft support material and ceramicsteel and backing :

- If the cutting on the enamelside is very important, we use OLIVINE 120 mesh. The backside will be less smooth.
- If the cutting can have some splintering :we use the GARNET 120 mesh. The backside will be more smooth.

6.2 Steel

- Always use red Garnet

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7 The water level

The waterjet table has to be completely covered with polystyrene foam of ± 20 mm thickness

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