

# **MY TOP**

**FONDOVALLE**

**TECHNICAL MANUAL**



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## **GENERAL INDEX**

# 00 INTRODUCTION

## METAMORPHOSES OF SURFACES

MyTop encapsulates a selection of large, 12 mm-thick and 20 mm-thick Vein Through slabs, which revolutionises the concept of ceramic tiling, taking it to new spatial and design dimensions. With pioneering technology, we have transformed and reinvented the looks and technical features of conventional porcelain stoneware and transferred them to large-scale designs. The resulting beauty of textures and finishes expands to let users explore future scenarios for contemporary living. MyTop brings innovative technology to the ceramics industry, which will change the face of tiling, expanding its potential for expression to include new applications and uses in the world of bathrooms, kitchens, and interior design in general. A unique and ideal solution for worktops that not only need to be stylish but also to offer a high technical performance. A product development that originates from Fondovalle's experience and commitment to research, the hands of our skilled craftspeople and technicians, and the tried and tested hands-on approach. In keeping with the changes and needs of modern living, it breaks down the confines of conventional methods and technology, to develop new creative synergies, spreading beauty and the essence of Italy.





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# 00 INTRODUCTION

## BIG ON SIZE, BIG ON POTENTIAL

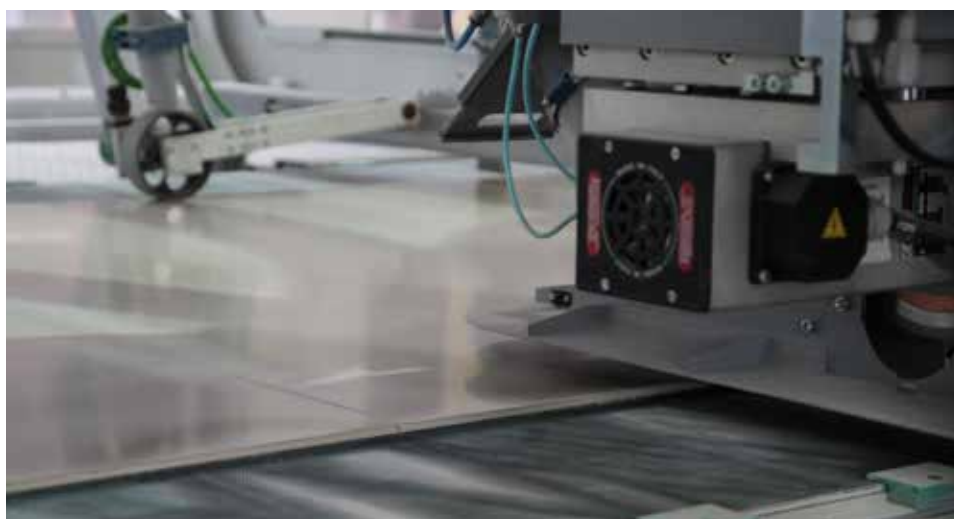
These products are the result of a unique cutting-edge manufacturing process developed by Ceramica Fondovalle at its plant in Casona di Marano, in the magnificent Sassi di Rocca Malatina natural park, working in partnership with one of the major leaders in automated systems for the ceramic tile industry.

These materials offer advanced technical features and are manufactured in compliance with Fondovalle's highest technical and quality standards, respecting the natural environment of the surrounding area. The new technology offers the possibility to use and mix traditional or new-generation materials, enhancing and stimulating the creativity and research of our technical staff. The slabs are available in 12 mm and 20 mm Vein Through thickness to cover all potential uses.

### APPLICATION FIELDS

The technical features of the slabs make them suitable for use in homes and public environments and in areas with high footfall (shops, halls, airports,); they can be used for flooring, walls cladding and matching furnishing elements.

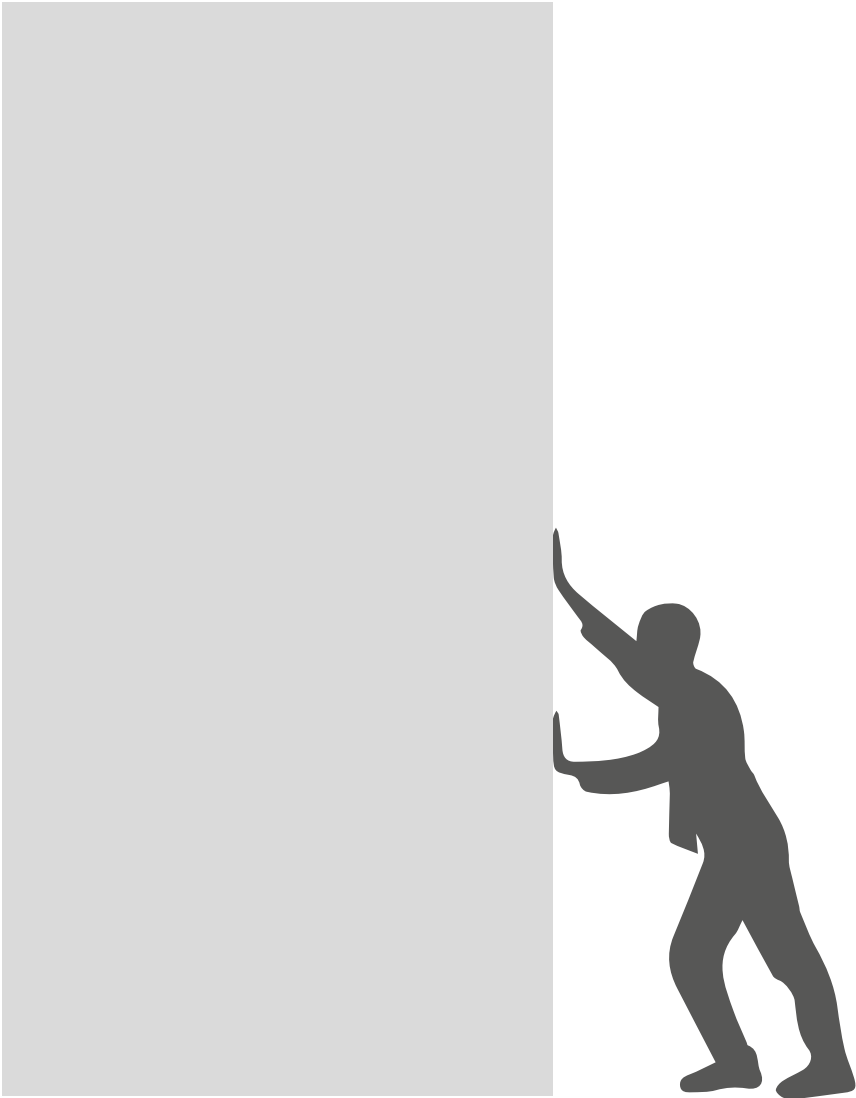
For more details, please visit our site at [www.fondovalle.it](http://www.fondovalle.it)





# 01 SIZES & THICKNESSES

The 12 mm-thick and 20 mm-thick Vein Through, not rectified porcelain stoneware slabs with backing material covering the entire rear of the slab, are particularly recommended for tops in kitchens and bathrooms, worktops, tables and custom-made furniture. Extremely hygienic, waterproof, and long-lasting, these porcelain stoneware products offer an excellent alternative to other materials such as marble, granite and aluminium. The slabs can be cut, machined, and bored to make them suitable for a range of uses. Large size, quality materials, and advanced technical features open up new design horizons, allowing users to create ultramodern designs through a range of tiling with clean lines and endless opportunities.



**1630x3240 mm**

*64,17"x127,56"*



**12 mm**



**20 mm Vein Through**



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# 02 COLLECTIONS

## 1/2" WITH BACK REINFORCEMENT

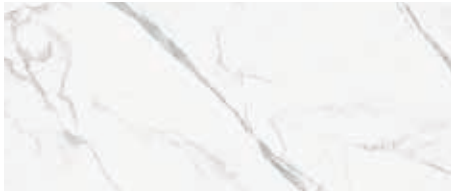
### MARBLE EFFECT: INFINITO 2.0



Statuario Extra Honed | Polished



Statuario Honed | Polished



Calacatta White Honed | Polished



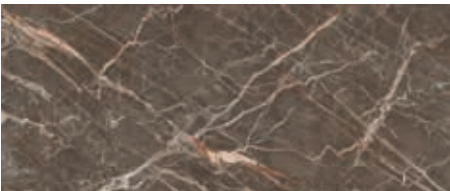
Calacatta Gold Honed | Polished



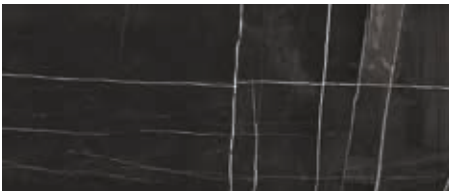
Lincoln Honed | Polished



Fior di Bosco Honed | Polished



Ombra di Caravaggio Honed | Polished



Sahara Noir Honed | Polished

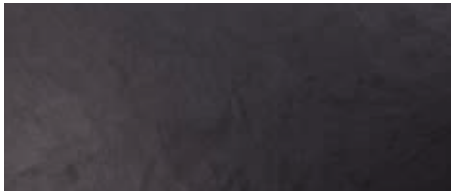
### RESIN EFFECT: RES ART



Talc Natural



Powder Natural



Lava Natural



CONCRETE EFFECT: PORTLAND



Jordan Naturale



Hood Naturale



Tabor Naturale

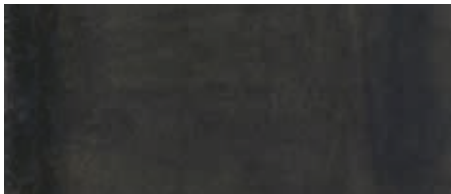
METAL EFFECT: ACIDIC



Corten Naturale



Silver Naturale



Iron Naturale

1" VEIN THROUGH WITH BACK REINFORCEMENT

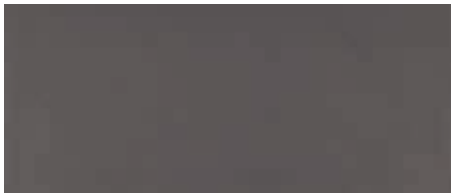
STONE EFFECT: 20PURE



20Pure Brera Honed | Polished



20Pure Cardoso Honed | Polished



20Pure Lavica Honed | Polished

## 03 PLUS

Projecting knowing how to rely on the quality of time-free, functional and practical surfaces is a guarantee that supports any kind of creation. Unlike other surfaces, these slabs are suitable for contact with food, which means they are hygienic, stainproof, mouldproof, and easy to clean. Porcelain stoneware is unaffected by high temperatures, scratchproof, and completely waterproof, and also withstands UV rays and all kind of weather. All this means maximum practicality and freedom, no limits to worry about or special care needed during daily use.



> HYGIENIC AND SUITABLE FOR CONTACT WITH FOOD



> IMPACT-RESISTANT



> TOTALLY WATERPROOF



> SCRATCHPROOF AND ABRASION-RESISTANT



> STAINPROOF



> EASY TO CLEAN



> RESISTANT TO MOULD, MILDEW, AND FUNGUS



> RESISTANT TO CHEMICALS, ACIDS, BASES, AND SOLVENTS



> RESISTANT TO HEAT AND HIGH TEMPERATURES



> SUITABLE FOR USE INDOORS AND OUT



> FROSTPROOF



> GUARANTEED FLATNESS AND STABILITY OVER TIME



> UV-RESISTANT

# 04 COMPARISONS

	MyTop Honed	MyTop Polished	Quartz agglomerates	Laminates and Wood	Solid Surface	Natural Stones	Steel
Hygienic	●●●	●●●	●●●	●	●●●	●	●●●
Non porous	●●●	●●●	●●●	●	●●●	●	●●●
Suitable for use outdoors	●●●	●●●	●	●	●●	●●	●●
Resistant to heat and high temperatures	●●●	●●●	●●	●	●	●●	●●●
Resistant to mould, mildew, and fungus	●●●	●●●	●●●	●●	●●●	●	●●●
Stainproof	●●●	●●	●●	●●	●●	●	●●●
Detergent-resistant	●●●	●●	●●	●●	●	●	●
Chemical resistance	●●●	●●	●●	●	●●	●	●●
Resistance to thermal shock	●●●	●●●	●●	●	●●	●●●	●●●
Frost resistance	●●●	●●●	●●●	●	●	●●	●●●
Dampness resistance	●●●	●●●	●●●	●	●●●	●	●●●
UV-resistant	●●●	●●●	●●	●	●	●●	●●●
Scratchproof and abrasion-resistant	●●●	●●	●●	●	●	●●	●
Easy to clean	●●●	●●●	●●●	●●	●●	●	●

# 05 CATAS CERTIFICATION



	Fondovalle values		Norms / Test method
	Honed 12 mm	Polished 12 mm	
Density	2500 kg/m <sup>3</sup> average value	2500 kg/m <sup>3</sup> average value	EN 14617-1 ASTM C97
Water Absorption	0,1 % average value	0,1 % average value	EN 14617-1
Bending strength	50 MPa average value	50 MPa average value	EN 14617-2
Frost resistance	Resistant	Resistant	EN 14617-5
Dry heat resistance	5 No visible effect till 200°C	5 No visible effect till 200°C	EN 12722 EN 438-2 par.16
Chemical resistance	From class A to B	From class A to C	ISO 10545-13
	Resistant	Resistant (except ink and methylene blue)	ASTM C650
Cold liquid resistance	5 No visible effect except ink (2)	From class 5 to 2	EN 12720
Cleaner product resistance	5 No visible effect	From class 5 to 3	PTP 53 CATAS
Abrasion resistance	28,0 mm	28,0 mm	EN 14617-4
Hygiene properties	Excellent (high degree of removal of bacterial cells >99% after cleaning with a biocide-free detergent)	Excellent (high degree of removal of bacterial cells >99% after cleaning with a biocide-free detergent)	Metodo CATAS
Resistance to fungus	No fungal growth	No fungal growth	ASTM G21
Lead and cadmium given off	0 mg / dm <sup>3</sup>	0 mg / dm <sup>3</sup>	ISO 10545-15
Overall migration	0 mg/dm <sup>2</sup> 0 mg/dm <sup>2</sup> no significant migration	0 mg/dm <sup>2</sup> 0 mg/dm <sup>2</sup> no significant migration	UNI EN 1186
VOC emission	class A+ French	class A+ French	UNI EN 16000-9
Shock resistance	No damage to ball drop 400mm	No damage to ball drop 400mm	ISO 4211-4 EN 14617-9
	3 J average value	3 J average value	
Light resistance	5 No visible effect	5 No visible effect	UNI EN 15187
Thermal shock resistance	Resistant	Resistant	EN 14617-6
Resistance to staining	Resistant	Resistant (except potassium hydroxide)	ASTM C1378

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## 06 APPLICATION FIELDS

### WORKTOPS



### FURNITURE



### HEAVY TRAFFIC FLOORING



### WALLS COATING



### EXTERNAL CLADDING



### HOTELLERIE



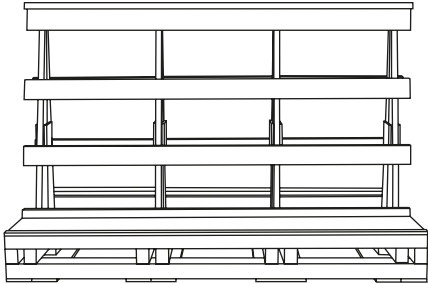
# 07 TECHNICAL DATA

Porcelain stoneware slabs - Gruppe Bla UGL (UNI EN 14411_G)			
	Established limits	Fondovalle values	Norms
Length and width	± 0,6%	± 0,9 mm	UNI EN ISO 10545-2
Thickness	± 5%	± 3%	
Edge straightness	± 0,5%	± 0,6 mm	
Rectangularity	± 0,6%	± 2 mm	
Planarity	± 0,5%	Compliant	
Surface quality	≥ 95%	Compliant	UNI EN ISO 10545-3
Water Absorption	≤ 0,5%	≤ 0,1%	
	-	0,1 % average value	ASTM C373
Bending strength	Modulus of rupture ≥ 35 N/mm²	≥ 45 N/mm²	UNI EN ISO 10545-4
Frost resistance	Resistant	Frost proof	UNI EN ISO 10545-12
Resistance to thermal shock	Resistant	Resistant	UNI EN ISO 10545-9
Deep abrasion resistance	≤ 175 mm³	≤ 145 mm³	UNI EN ISO 10545-6
Colour resistance to light exposure	Resistant	Resistant	DIN 51094
Chemical resistance	UB minimum	UA; ULA; UHA	UNI EN ISO 10545-13
Stain resistance	Class 3 minimum	Class 3-5	UNI EN ISO 10545-14
Fire reaction	Resistant	Resistant	EN 13501 (rev. 2005)

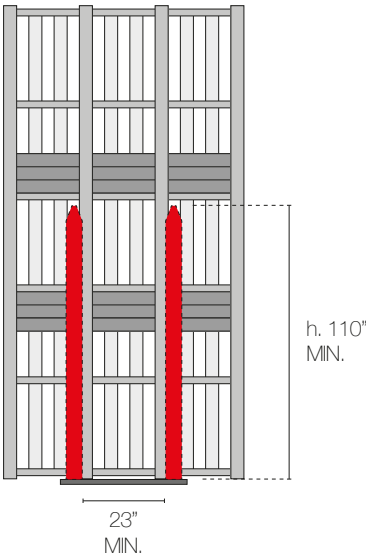
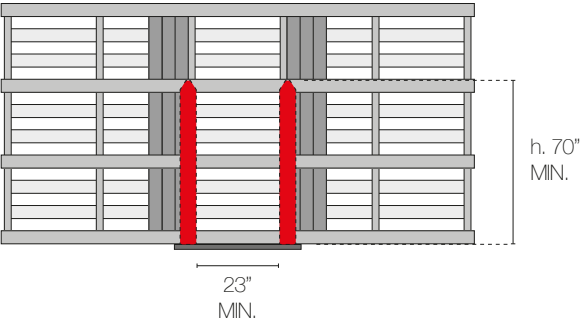
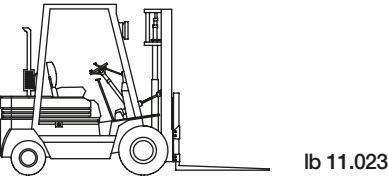
# 08 PACKING

MYTOP fullsize slabs are packed in vertical position on frames with two grab options (sideways and lengthways). MYTOP slabs must be loaded and unloaded with forklift or transpallet, after checking their maximum load capacity, considering the following weight specifications:

A-frame size	A-frame weight	Slab size	Thickness	Pieces	Total weight
130"x30"x77"	lb 454	64,17"x127,56"	1/2"	22	lb 7.826
			3/4"	12	lb 7.068



Before moving vertical a-frame, the operator must ensure that the slabs are well locked to the stand to ensure the safety of the personnel and the integrity of the material. A-frame must be loaded symmetrically to prevent damages. The safest grip is the one on the lengthways, with 70" lenght forks. To ensure the a-frame's stability, when moving, widen forks and balance the load. When loading on container (sideways grab) forklift must be provided with extension forks length of 110" and minimum load capacity of 11.000 lb.





## 09 HANDLING AND STORAGE

Before moving MYTOP slabs, operator must check the maximum load capacity of lifting devices. MYTOP slabs can be moved using lifting devices with suction cups, clamps, supported by an overhead crane or a jib crane and with rubber coated canvas straps. Never use chains or steel cables.

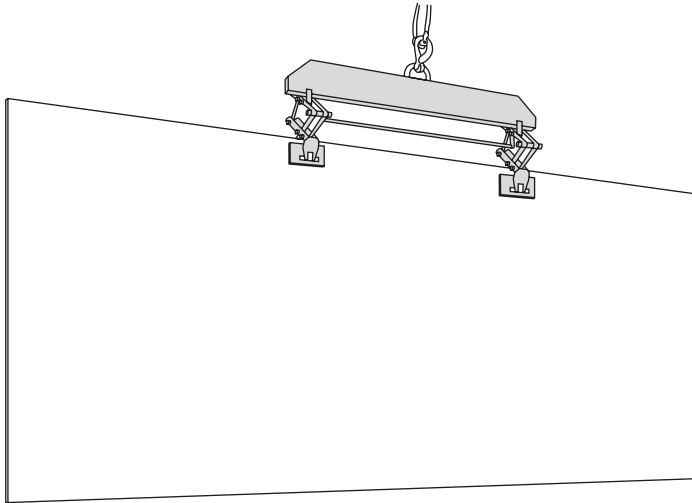
Here weight details of single slab:

12 mm = lb 340

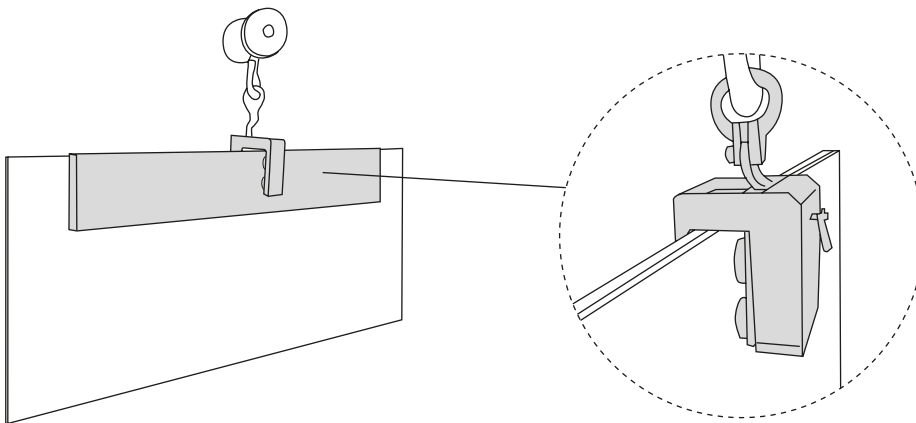
20 mm = lb 565

### SINGLE SLAB

Single slab are handled by pneumatic vacuum system or by bridge-crane provided with clamps or soft canvas. Slab must be cleaned before lifting with pneumatic vacuum that must be fixed to the centre of slab. When lifting MYTOP single slab with double clamps system, make sure to reduce movement in order to avoid bending, splintering or breakage. In case of clamps with metal surfaces, protect them with foam tape, before handling MYTOP slab. Never clamping 2 slabs at the same time



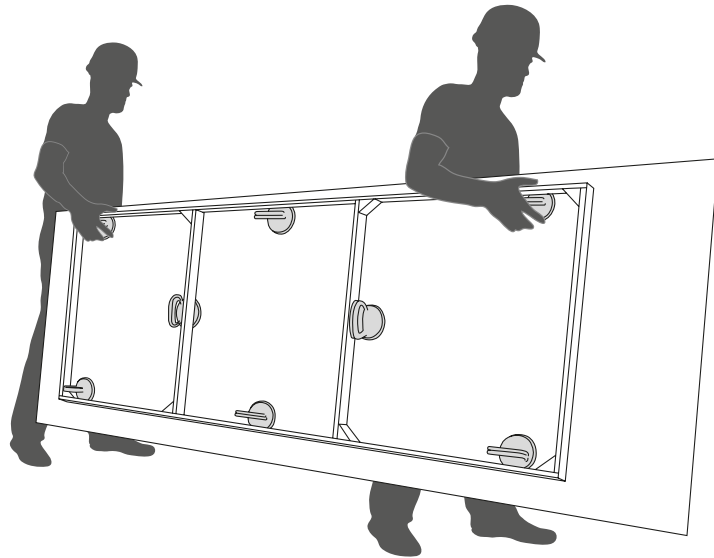
When using a single clamp system, fix the ends of slab with jacks to a  $\frac{3}{4}$ " thick plank. Supporting plank must be positioned to the rear of MYTOP slab. When moving, pay attention to avoid sudden changes of direction.



Positioning of the clamp

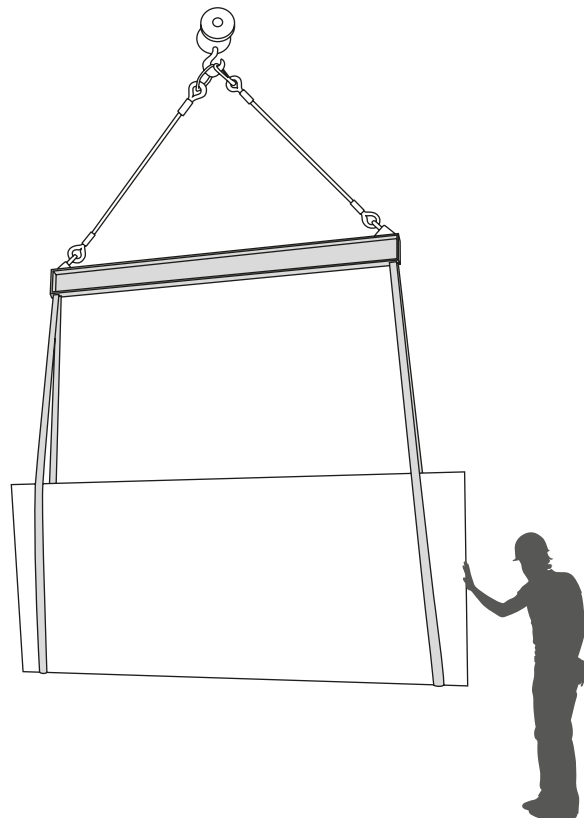
## MANUAL HANDLING

Due to heavy weight of MYTOP slabs, manual transporting is not recommended. Only when is necessary, 4 operators can hand MYTOP single slab, using a suction cups frame, with slab moved long side in vertical position.



## MULTIPLE SLABS

Multiple slabs can be moved using rubber coated canvas slings. The sling of the slabs must take place at the two ends of the long side, balancing the weight equally. During handling, oscillations and sudden changes of direction must be avoided. Never use metal chains, steel cables or metal slings.



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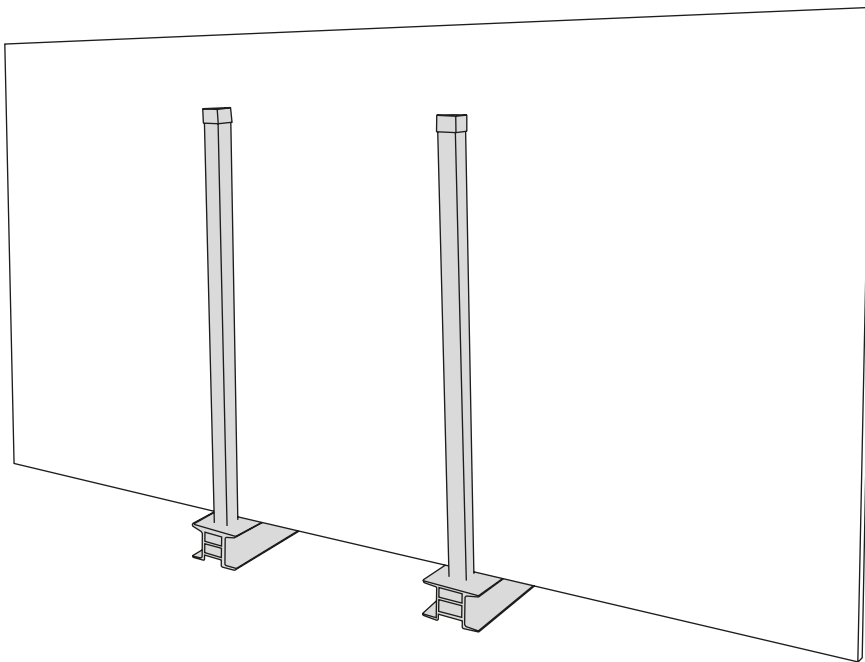
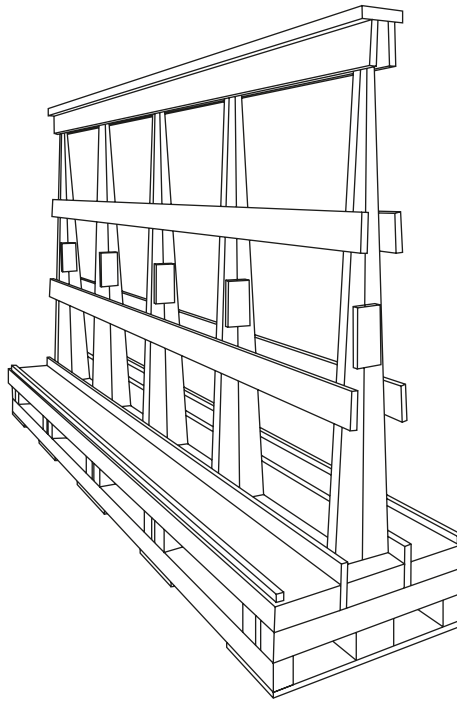
## 09 HANDLING AND STORAGE

### STORAGE

MYTOP slabs can be placed in their original a-frames, or vertically stored length-side on trestles, racks or beams.

Downer long edges must be arranged on soft support. In this case a full wood-rubber support must be placed on the rear of first slab. During a-frame emptying phases, MYTOP slabs must be uniformly drawn from both sides of the a-frame, keeping the weight balanced on both.

MYTOP slabs can also be stored outdoor.



# 10 PROCESSING

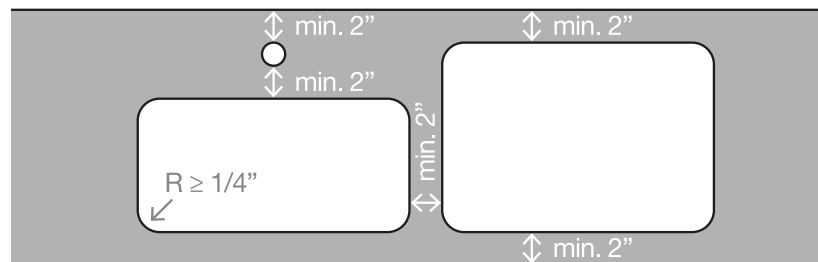
Before starting any process, MYTOP slab must be cleaned and visually inspected, to verify it complies to quality requirements.

No claims are accepted for fabricated or installed slab, when defects were present upon delivery. Before processing, we recommend to perform preliminary test on samples slab in order to set appropriate utensil and machining parameters. MYTOP slabs are provided FULLSIZE non-rectified. Before start processing, cut the perimeter of slab removing from the outer edges.

Useful workable area will be of 1600x3200mm. MYTOP slab can be processed using water-based machinery, equipped with good condition tools suited for porcelain stoneware. When using a diamond disc, pay attention to reduce speed of 50%, both at the beginning and end of cutting process. Working bench must be clean, solid, resistant and perfectly flat. Cnc's suction cups must be placed under entire slab, with particular care for the areas beside holes (sinks & hobs hole). Processed slab must be handled with care, particularly when openings or inner holes are present. Fabricated slab must be moved avoid bending or twisting of slab.

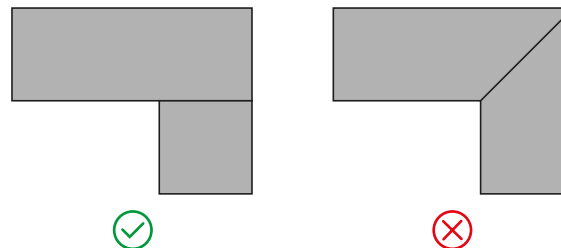
## CUTOUTS PROCESSING

Maintain a minimum distance of 2" from outer edge with holes, and between tap's hole and sink, grooves and between adjacent openings. All cutout corners must have a minimum radius diameter of 1/4".



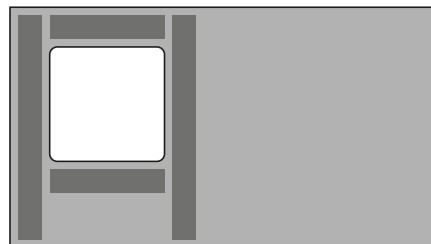
## HORIZONTAL JUNCTIONS

L shaped tops must have the junction made with 2 units fitted in a straight pattern. Joint in between must be filled with silicone or epoxy glue. Diagonal junctions are not recommended. Minimum distance from walls should be 3mm. When fabricating a L shaped top using a single unit, internal corner must have a radius of 1/4".



## BACK REINFORCEMENTS

Installation of straight edge countertops must be planned supporting the fabricated top on the whole perimeter of cabinet and across sinks and hobs. All mitered frontal edges must be reinforced pairing back angles with MYTOP bars, full bed bonded with flexible adhesives. Gaps (such holes, hobs or tap's hole), must be reinforced with MYTOP strips to be fixed on the slab rear side. Never use a back reinforcement with different thermal expansion, (such quartz, wooden, stones), that may cause damages to the top and mitered edges.



## OVERHANGS

For countertops without back panel support, overhang recommended width should not be more than 6"- 8". When installing countertops with holes, overhang width must be reduced to 3"- 4". Any wider spans should be installed with a back support or fixed to a back structure.

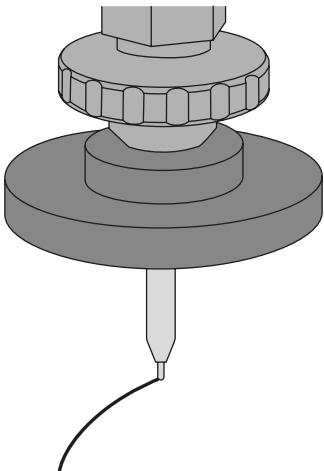
# 10 PROCESSING

## WATERJET

### Machining parameters

Waterjet	Cutting			Drilling	
Slab's thickness	Speed (mt/min)	Pressure (Bar)	Abrasive (gr/min)	Pressure (Bar)	Abrasive (gr/min)
1/2"	0,7 - 1,0	3000 - 3500	350	900	150 - 200

- Working bench must be levelled, straight, in good conditions and clean.
- MYTOP slab must be firmly fixed to working bench.
- Processing starts with a perimetral cut, removing 3/4", from outer edges.
- Minimum radius of all inner corners must be 1/8".
- Pressure and abrasive feed must be reduced when drilling holes and mitering profiles
- When cutting openings, first start making an inside hole and then proceed towards to perimeter.
- At the end of processing, rinse MYTOP fabricated slabs with clean water.

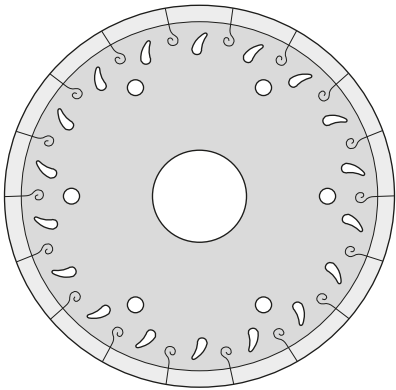


## DISC CUTTING

### Machining parameters

Bridge saw	Straight cut	Mitering cut	Disc diameter	Disc speed
Slab's thickness	Speed (mt/min)	Speed (mt/min)	mm	RPM
1/2"	1,0 - 1,5	0,7	300	2500
1/2"	1,0 - 1,5	0,7	350	2200
1/2"	1,0 - 1,5	0,7	400	1900

- Use only porcelain stoneware diamond discs.
- Cutting process starts decreasing infeed and outfeed speed of 50%
- To adjust disc's revolutions, we recommend a miling machine provided with frequency variator.
- Tools must be cooled by water when cutting.
- All cutouts must have previously drilled holes (with a minimum diameter of 3 mm)
- When cutting at 45°, make sure to limit vibration by using extra-thick diamond discs and reducing speeds of 50%. The obtained upper edges, must be chamfered.
- The disc's rotation must always be oriented in the same direction of slab's cutting.
- When doing an L cut, start drilling an hole at the inner angle (bit diameter 1 / 4") , then proceed straight cut.

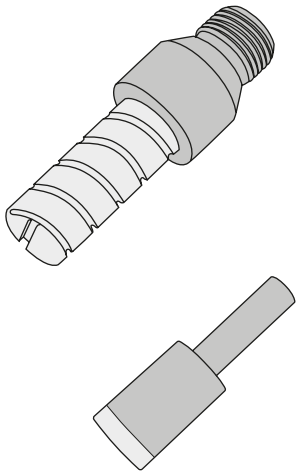


# CNC MACHINE

## Machining parameters

Cnc	RPM	Speed
		mm/min
Core bit	4500 - 5500	500
Finger bit	4500 - 5500	100 - 200

- Cnc machine is mostly used to create recesses for sinks and hobs, for edges finishing, for edges and holes drilling and for flush-mounted tops fabrication.
- Cnc must be provided with diamond tools, suitable for porcelain stoneware.
- Suctions cups on the working bench must cover below the entire slab and near the area that will be removed after cut.
- During processing utensil must be colled with water.
- When doing cutouts, first drill inside holes with a diamond bit, then cut perimeter with incremental finger bit, reducing speed to 50% when approaching the end of cut. Finish the profiles by bevelling upper angles and polishing straight borders.
- All inner corners require a minimum bit of 1 / 2”.
- Never use swinging option when using finger bit.



# 11 EDGES FABRICATION

The different type of edges (straight edges or mitered edges) are obtained both by automatic machinery or by hand. Curved edges must be bevelled by a 5-axis grinder cnc machine. Upper angles must always be chamfered of 1 / 8" minimum.

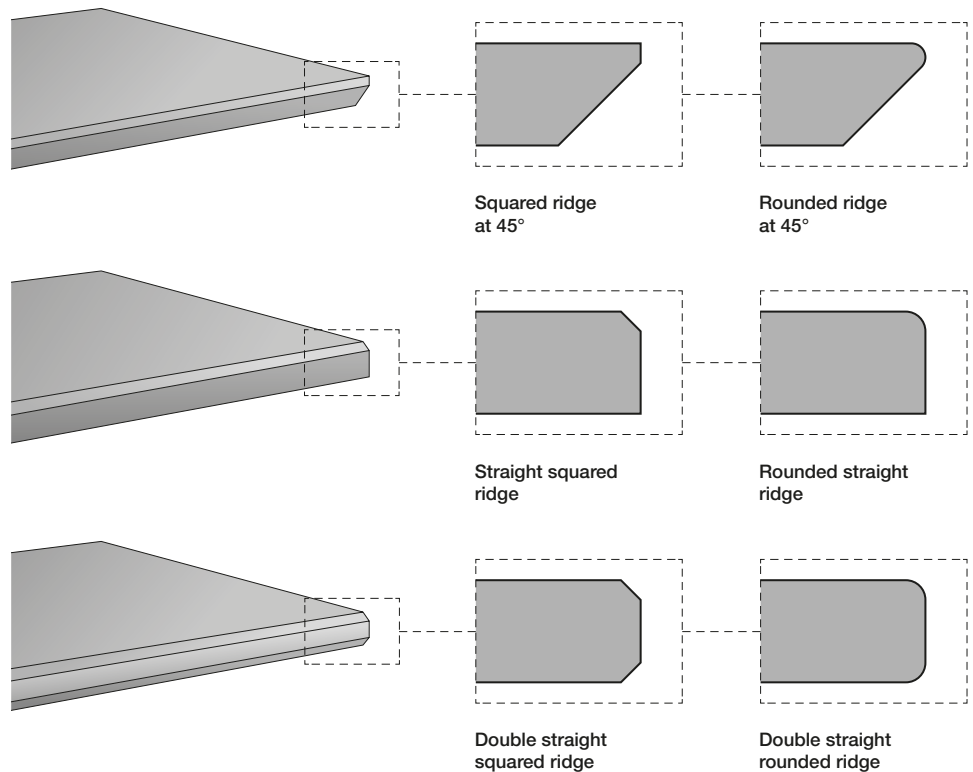
## STRAIGHT EDGES

When doing straight edges, upper angles (both squared or rounded) must be chamfered of 1/8" minimum.

Bullnose or half bullnose edges can be fabricated by cnc provided with different grinders.

All visible edges along kitchen top or sink openings, can be treated with protective products.

Edges polishing can be obtained using a sequence of abrasive increasing diamond grinders, or by cnc machine.



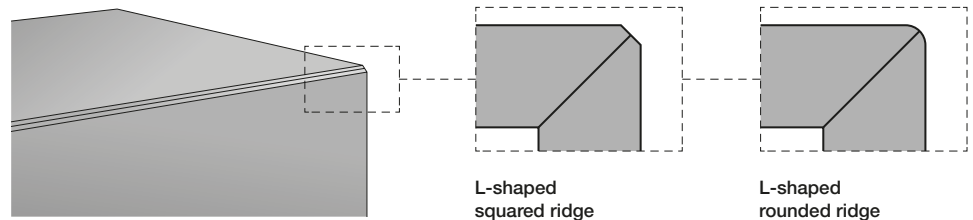
## MITERED EDGES

Laminated mitered edges can be planned for several applications such as baffles of different heights, for recesses, for continuous joints or when creating an integrated ceramic sink.

When cutting mitered edges, to avoid sharp edges, stop cutting line 1mm away from end piece.

Mitered edges must be glued with epoxy 2 components adhesives, performing the installation and comply with hardening time of adhesive.

End the fabrication bevelling the upper obtained edge of 1/8". All mitered frontal edges must be reinforced pairing back sides with MYTOP bars.



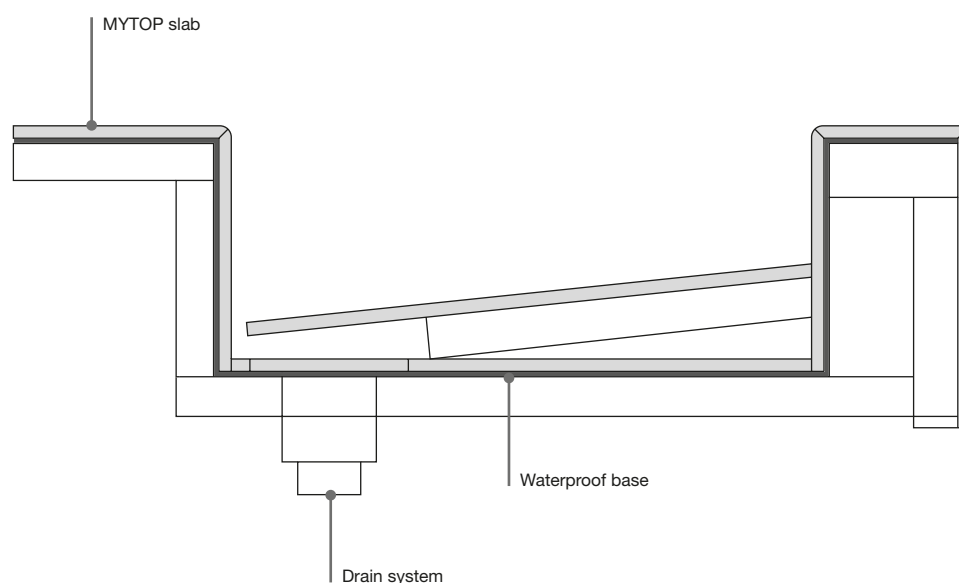


# 12 GLUING

## INTEGRATED SINK

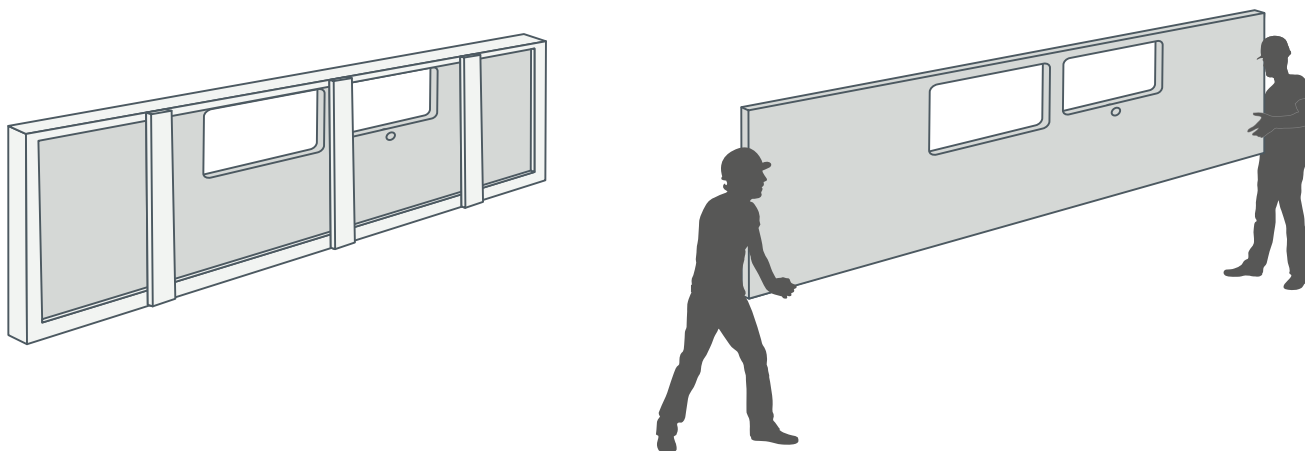
To obtain a monolithic look, MYTOP slabs can be processed to build a pre-fabricated ceramic sink, as following recommended steps:

- 1 Build the sink base with high-performance support panel, water-and heat-resistant (kerdi board, wedi, cement boards). Alternatively use standard aluminum base sinks.
- 2 Create water's slopes.
- 3 Waterproof base sink.
- 4 Coat base sink with MYTOP mitered strips, make sure that all internal holes have a round diameter of 1/4".
- 5 Bevel all upper edges.
- 6 Fix the drain system.



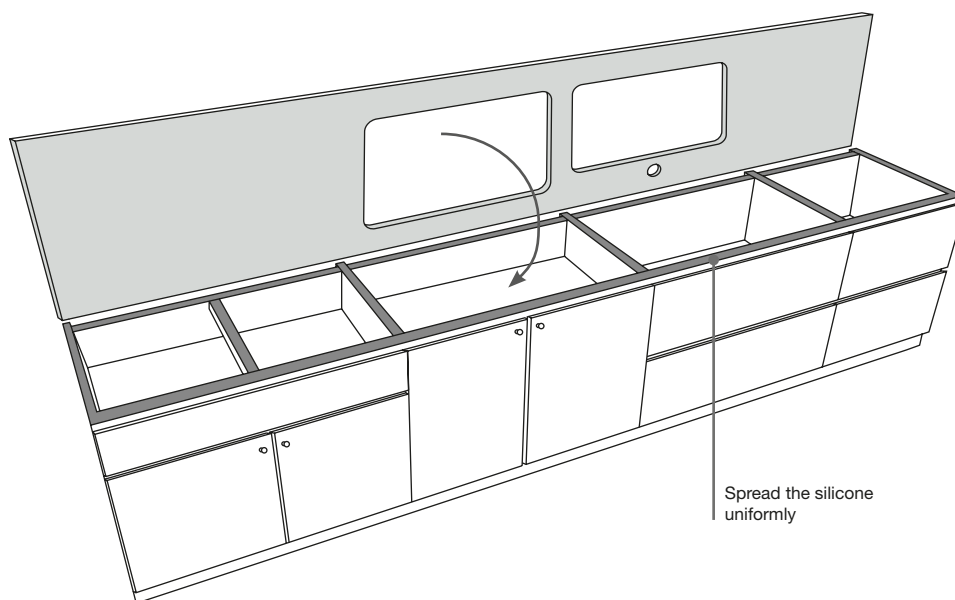
## 13 TRANSPORTATION & TOP INSTALLATION

Fabricated top must be packed in proper wood case, giving attention to protect cutouts, hobs and holes, with soft protections (such foam or rubber). When moving, it must be kept in vertical position, keeping all opening face up. Pay attention to avoid any bending or twisting. During transportation do not overlap other weights.



### TOP INSTALLATION

- Mytop slabs are self-supporting, so they do not need to be applied to back panel support. Only exception in case of fabricating overhangs exceeding 5.9".
- The cabinet base must be stable and perfectly flat.
- Top must be fixed with silicone to the cabinet all along the perimeter.
- If top is made by 2 or more units, leave a minimum joint in the junctions and fill it with silicone or epoxy grout.
- All the upper corners must have a minimum beveling of 2 mm, as well as all the edges in the junction of 2 elements (L shaped top).
- Leave a minimum distance from walls of 1/4", to be filled with silicone.
- Undermount sinks must rest on support bars fixed inside the base.



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## 14 CLEANING & MAINTENANCE

MYTOP slabs are very practical and do not require any special cleaning methods, consider the excellent resistance features to stain, heat, scratch and to abrasive agents. Daily cleaning is carried out only with the use of hot water or neutral detergents applied with sponge or cloth. The removal of particular types of stains, may require the use of specific detergents, and for this reason MYTOP technical office remains available for any information.

Of fundamental importance is the correct and timely cleaning at the end of the processing, especially for surfaces with glossy finish.

In particular, the slab must be subjected to washing with clean water and subsequent drying.

All machining residues such as putties, mastics or silicones should be removed before their final hardening.

Avoid the direct use of hydrofluoric acid or its derivatives. Do not use abrasive sponges on glossy finishes.

Thanks to



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