

This manual describes all the processing phases to be carried out on the Lapitec kitchen worktop for installation of the Lapitec Chef induction system.

The related technical drawing and video can be downloaded from the following link: [www.lapitec.com/en/lapitec-academy](http://www.lapitec.com/en/lapitec-academy).

## Package contents

- 1 Lapitec Chef induction unit
- 2 Steel support brackets with 3M™ VHB™ GPH-110GF doubled-sided tape
- 2 User interface ceramic glasses
- 1 Paper template for positioning brackets on the kitchen worktop
- 1 3M™ VHB™ Cleaner wet wipe with isopropyl alcohol
- 1 3M™ Primer 94 pen
- 1 User manual

## Machine processing phases

### Surface engravings on the upper side of the slab for controls and mat positioning

- The position of the engravings must not be changed for any reason, in order to avoid problems with touch sensor operation
- The shape and depth of the engravings can be modified according to the aesthetic tastes of the designer
- It is recommended to use PCD granite engraving tools with the following settings:
  - Spindle revolutions: 7500-10000 rpm
  - Feed rate: 80-120 mm/min
  - Removal: max 1.5 mm

### Slotted holes for user interfaces: 2 holes

- It is recommended to use the Lapitec router for incremental cutting with the following settings:
  - Diameter: 10 mm
  - Spindle speed: 7000 rpm
  - Feed rate: 300-400 mm/min
  - Removal: 0.5-1 mm or the use of water jet machines

### Milling of the two interface rebates for housing the panels: 2 rebates

- It is recommended to use the Lapitec flush-mount tool with the following settings:
  - Diameter: 10 mm
  - Spindle revolutions: 7000 rpm
  - Feed rate: 300-400 mm/min
  - Removal: max 0.5 mm to avoid surface chipping

### Milling of the rebate on the underside of the slab for housing the induction unit (this operation is only necessary for slabs with thicknesses of 20 and 30 mm)

- The rebate must bring the induction unit housing area to a thickness of 12 mm with a tolerance of -0/+1mm
- It is recommended to use the Lapitec stubbing wheel tool with the following settings:
  - Diameter: 50 mm
  - Spindle revolutions: 4500-5000 rpm
  - Feed rate: 300 mm/min
  - Removal: max 1 mm
  - Make an entrance with a wide ramp

## Notes for machining operations:

- During the operation, use abundant and well directed water on the outside and inside of the tool
- The tool's machining parameters may vary depending on the manufacturer
- Refer to the manufacturer's data sheet to define the appropriate machining parameters

## Manual processing phases

### Installation of side brackets to support the induction unit: 2 brackets

- Use the paper template supplied
- Place the paper template on the back of the slab so that the holes of the interfaces on the top correspond exactly to the related ones on the paper template
- Using a pencil, draw the positions of the two brackets following the holes on the paper template
- Clean the traced areas with a 3M™ VHB™ Cleaner wet wipe soaked in isopropyl alcohol
- Apply 3M™ Primer 94 on the traced areas to help the double-sided tape bond
- Peel off the top film of the 3M™ VHB™ GPH-110GF double-sided tape that is already bonded to the brackets
- Bond the brackets following the steps below:
  - Align the long side of the bracket to the traced position
  - Rotate the bracket on the long side until it is fully bonded within the traced position as shown in the video
  - Apply pressure along the entire bracket

### Installation and sealing of panels: 2 panels

- Apply neutral silicone around the entire perimeter of the base of the rebate. This operation is very important because perfect sealing prevents the passage of liquids through the interface.
- Place the panel taking care to centre it on the edge
- Leave everything to dry for at least 24 hours
- Clean the area with diluent
- Check visibility from underneath the panel with a light source as shown in the video and then remove any silicone residues from the bush-hammered part. This operation is very important to ensure the display is perfectly visible.

### Cleaning and finishing

- Dip a fine-tipped tool, e.g. a writing instrument as shown in the video, into the Biocare and apply a sufficient amount to cover the entire engraved area without excess or overflow
- Wait for 1 minute and clean with paper soaked in diluent
- Repeat the previous two steps three times on all engravings
- Completely clean the worktop according to the cleaning instructions in section 5 of the user manual

**N.B.:** For further details please refer to the latest version of the user manual available in the Downloads section of the website [www.lapitec.com](http://www.lapitec.com)