

Stone Fabrication

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Summary of Fabrication Steps

- 01 Inspection & slab layout
- 02 Fabrication of stone
- 03 CNC charging pocket
- 04 Confirm critical pocket dimensions

⚠ Note: Do not remove stone from CNC and complete job until pocket dimensions are verified.

- 05 Apply countertop bracket

Fabricating with FreePower follows the standard process for stone moving through your shop, there are just a few added steps.



Stone Fabrication: Step 1

Inspection & Slab Layout

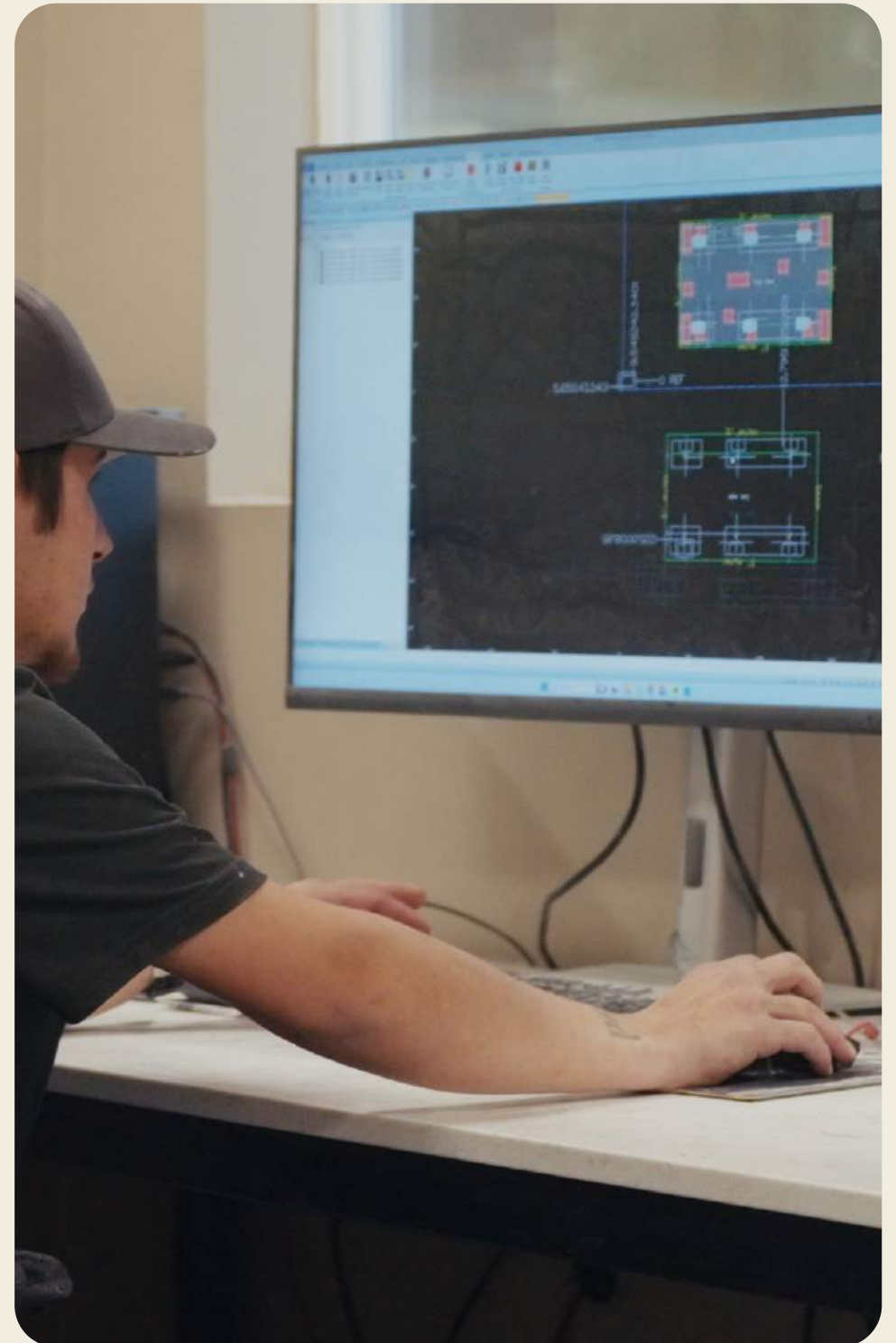
Placement of FreePower chargers

- Map out the location of the wireless charging zones based on *Charging Halo Placement Guidelines*
- Follow the same measurement and documentation procedures used to cut out a sink
- Confirm set backs, X & Y coordinates of charging zones, and complete your shop drawings

Confirm translucency of stone

During inspection, always manually confirm the translucency of the stone. Even if the stone is in our *Translucency Database*, stone consistency may vary based on a number of factors.

⚠ Note: Stone translucency varies, and you should always confirm with a flashlight before any permanent fabrication step.



Fabrication of Stone

- 01 Cut down stone to size
- 02 Prepare edge details
- 03 CNC
 - Optional: Back gauge the surface for guaranteed stone thickness.
 - Route edge detail as needed
 - Route charging pockets [see next page for more details](#)
 - Route sink holes after charging pockets

⚠ Note: Always route charging pockets before sink holes to avoid weakening stone.



Charging Pocket Routing

Requirements for zeroing out the routing bit

- Zero out for each new slab
- Zero out if a single slab has more than 3 pockets

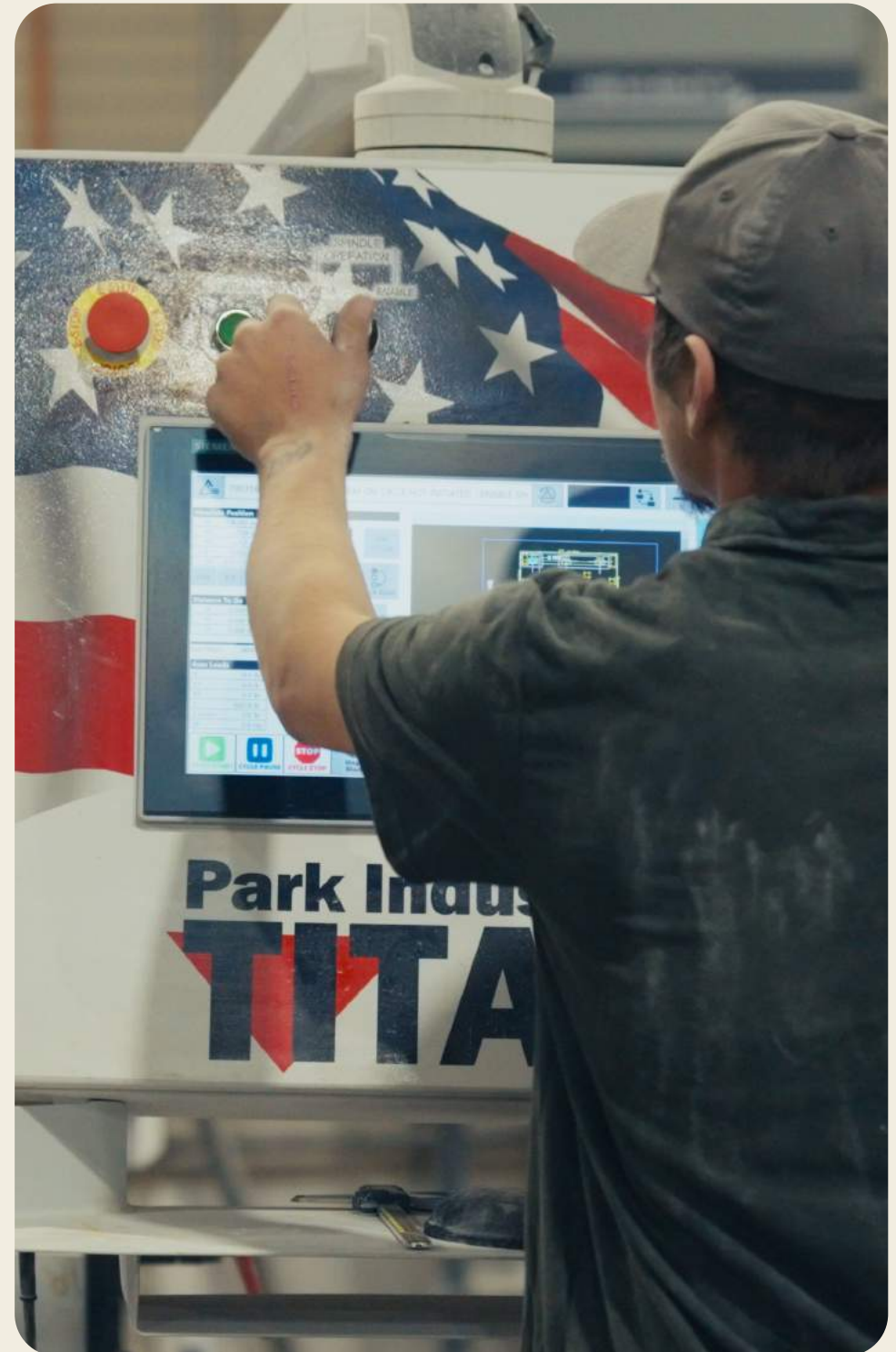
Programming your CNC

- 01 **Program position of charging pockets**
The center line and set back radius are based on your measurements
- 02 **Zero out routing bit**
Measure z height of routing bit and update tool data
- 03 **Upload DXF**
DXF file provides CNC with X / Y dimensions and corner radiuses
- 04 **Configure routing tool style**

How many tools will be used:	Enter Number
RPMs:	4250
Feed rate:	120 IPM
Incremental drop:	1/16"
Tool direction:	Inside to outside

- 05 **Run simulation, confirm placement of pockets, & then let it run**

⚠ Note: CNC setup and programming is the most critical step of the fabrication process. It must be handled with precision to ensure exact dimensions.



Stone Fabrication: Step 4

Confirm Critical Dimensions

Do not remove stone from CNC bed and complete job until critical dimensions are verified.

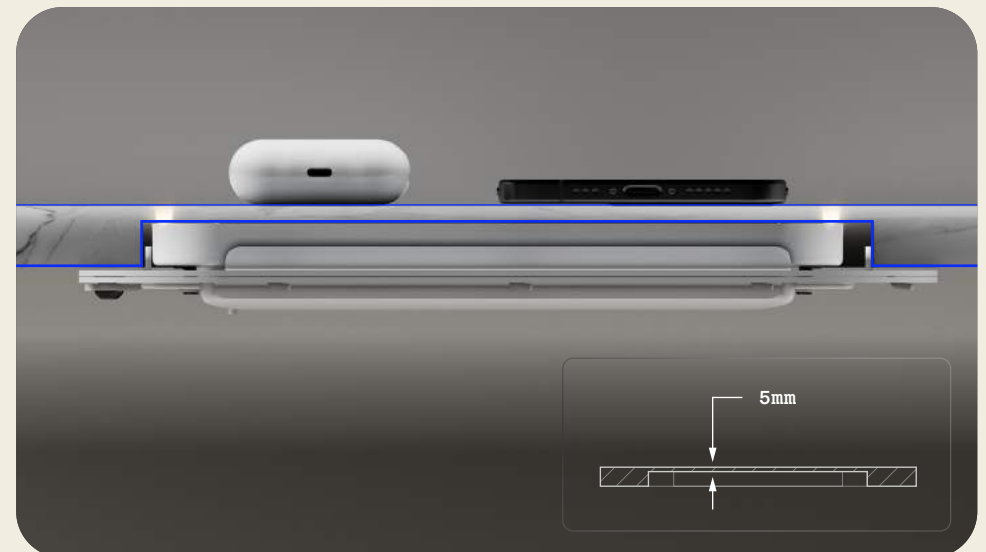
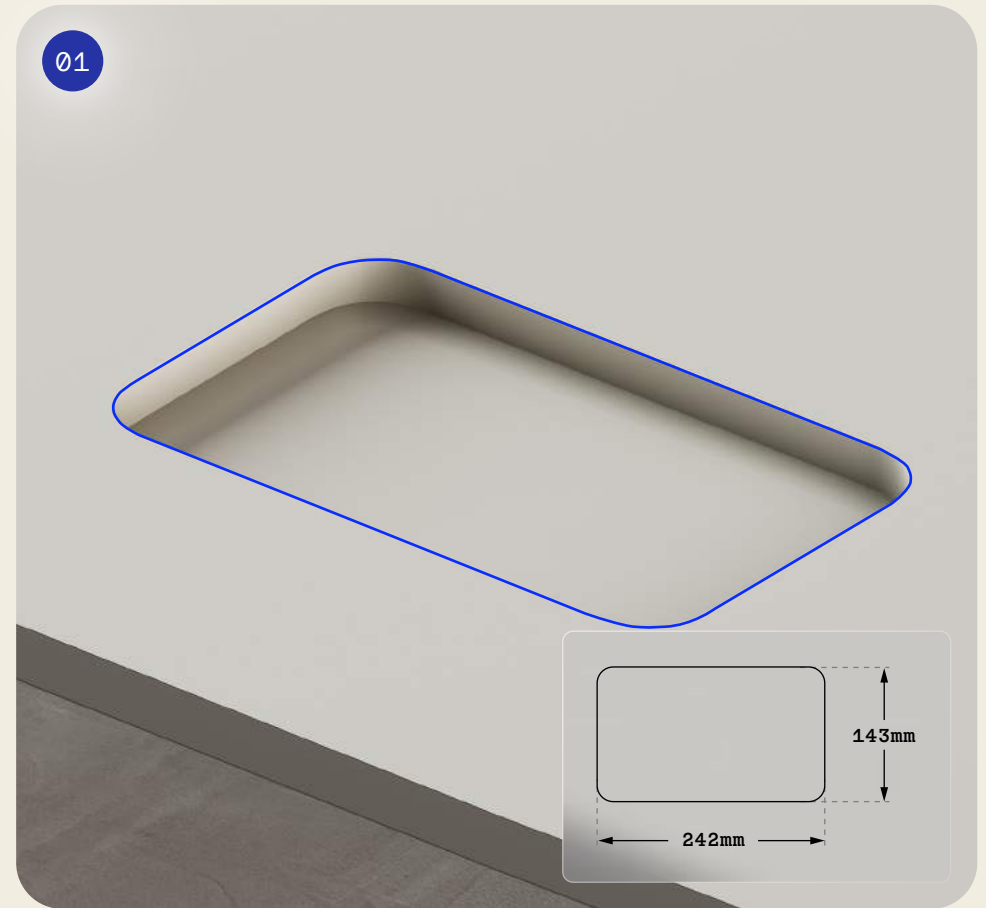
01 **Pocket X & Y: 242mm x 143mm** (+/- 2mm)

If the *Pocket X & Y* tolerances are not maintained, the *Charging Halos* may not align on the surface, and the mounting system may not be compatible.

02 **Pocket Z Height: 5mm** (+1mm, -0.5mm)

The *Pocket Z Height* makes up the most critical FreePower tolerance. For charge performance, visibility of the *Charging Halo*, and other safety related issues, the *Pocket Z Height* must fall precisely within the specified dimension.

⚠ Note: The *Charging Pocket* must be milled with precision. Its dimensions are critical and if outside of the specified tolerance, it will void the FreePower warranty and the product will not operate as designed.



Stone Fabrication: Step 5

Apply Countertop Bracket

01 Connect Glue Protection Device

Connect the *Glue Protection Device* to the *Countertop Bracket* before placing any silicone or glue.

02 Apply silicone or glue

Glue (or silicone) should be applied to the *Countertop Bracket* in between any of the mounting holes to avoid interference.

Note: You must use silicone or glue rated for an undermount sink .

03 Orient brackets left

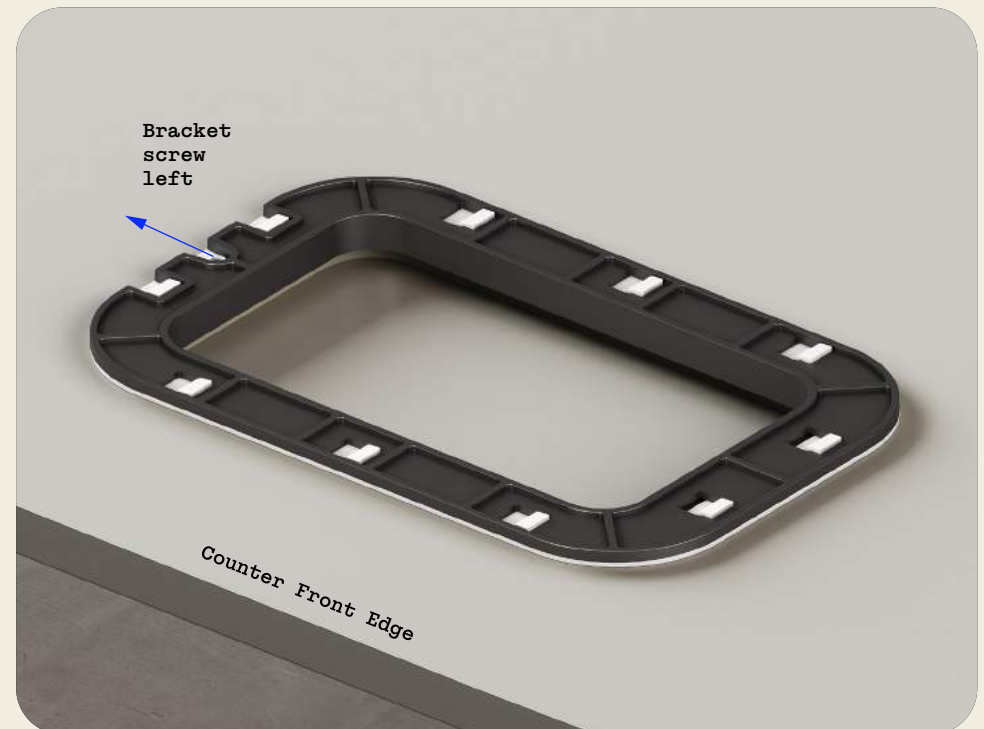
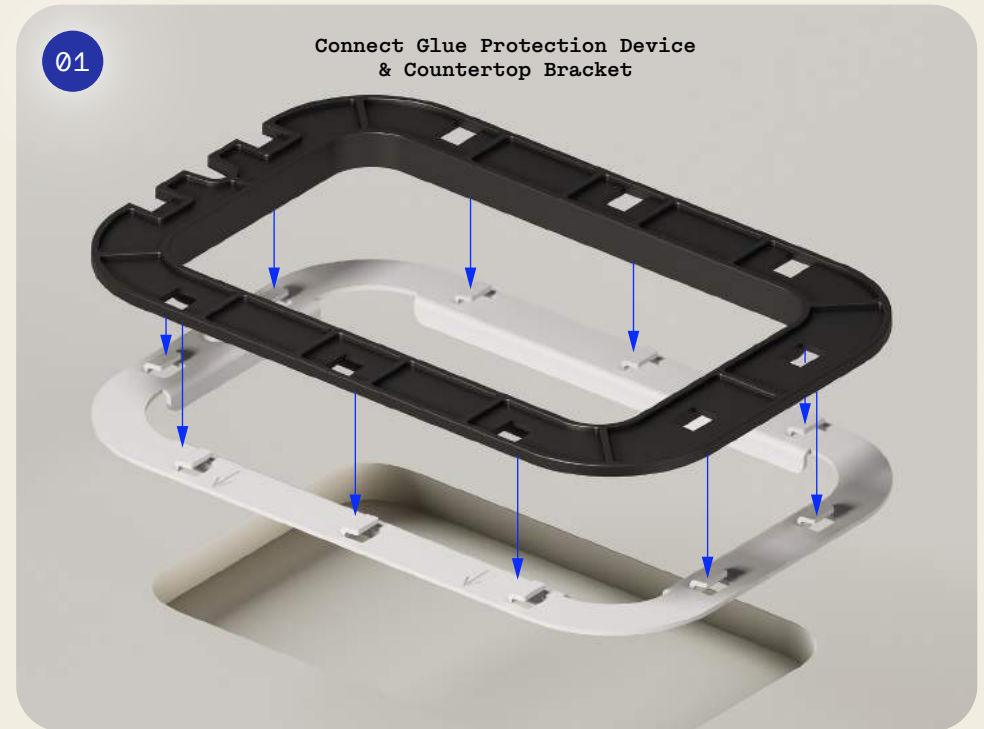
The brackets have a screw hole on one side only, you must ensure it is always facing left when looking from the front edge of the stone.

Note: Brackets must be oriented left for the wireless charger to mount into the stone and function properly.

04 Firmly press bracket into pocket

Press the brackets firmly into the pocket and leave the *Glue Protection Device* until glue has set in place.

05 Allow glue to fully dry



A hand is shown in motion, hovering over a smartphone. The smartphone screen displays a battery icon with a green bar and the text "83% Charged". A large, stylized white "FP" logo is superimposed over the phone. The background is a light-colored, marbled surface with glowing yellow energy lines radiating from the phone and the logo.

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