WORKING PARAMETERS

			ROTATION SPEED (rpm)			
POSITION	FUNCTION	PROGRESSION	SYNTHETIC MATERIALS	MARBLE	GRANITES	HARD GRANITES, GRES AND CERAMICS
Pos. 0 (stock-removal)	straight edge		10000	10000	10000	10000
	sink cut-out		10000	10000	10000	10000
	steps		till tracer point contact	till tracer point contact	till tracer point contact	till tracer point contact
The motion of the tool shall be linear, using light and constant pressure						
Pos. 1 (profiling)	straight edge		10000	10000	10000	10000
	sink cut-out		10000	10000	10000	10000
	steps		till tracer point contact	till tracer point contact	till tracer point contact	till tracer point contact
The motion of the tool shall be linear, using light and constant pressure						
Pos. 2 (honing)	straight edge		5000	10000	10000	10000
	sink cut-out		3000	5000	5000	5000
	steps		till tracer point contact	till tracer point contact	till tracer point contact	till tracer point contact
The motion of the tool shall be linear, using light and constant pressure						
Pos. 3 (finishing)	straight edge		3000	10000	10000	10000
	sink cut-out		2300	3000	3000	3000
	steps		2 – 3	2 – 3	2 – 3	2 – 3
The motion of the tool shall be linear, using light and constant pressure						
Pos. 4 (pre-polishing)	straight edge		not required	3500	3500	3500
	sink cut-out		not required	2300	2300	2300
	steps			3 – 4	3 – 4	5 – 6
The motion of the tool shall be linear, using light and constant pressure						
Pos. 5 (polishing)	straight edge		2300	3500	3500	3500
	sink cut-out		2300	2300	2300	2300
	steps		3 – 4	3 – 4	3 – 4	5 – 6
The motion of the tool shall be linear, using light and constant pressure						
Pos. 6* (final buff)	straight edge		2300	3500	3500	3500
	sink cut-out		2300	2300	2300	2300
	steps		3 – 4	3 – 4	3 – 4	5 – 6
The motion of the tool shall be linear, using light and constant pressure						

*The use of the orange wheel is upon user's preference, depending on the different materials