

SHAPED TOOLS FOR INSIDE PROFILING WITH CNC MACHINES

WORKING PARAMETERS

POSITION	FUNCTION	FORWARD SPEED mm/min			INCREMENT mm	SPINDLE ROTATION SPEED rpm
DIAMOND WHEELS		SYNTHETIC	MARBLE	GRANITE		
pos. 1	Profiling	800-1200	800-1200	800-1200	0,2-0,4	5000-6000
pos. 2	Honing	800-1200	800-1200	800-1200	0,1-0,3	5000-6000
pos. 3	Finishing	800-1200	800-1200	800-1200	0,05-0,1	5000-6000

POSITION	FUNCTION	FORWARD SPEED mm/min			INCREMENT mm	SPINDLE ROTATION SPEED rpm	ADAPTIVE INCREMENT mm/m
POLISHING WHEELS		SYNTHETIC	MARBLE	GRANITE			
pos. 4	Pre-polishing	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01
pos. 5	Polishing	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01
pos. 6	Final buff	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01