

SHAPED WHEELS MINIMUM DIAMETER 60 mm

WORKING PARAMETERS FOR CNC MACHINES

POSITION	FUNCTION	Feed - mm/min			*Increment mm	rpm	DEKTON	
		SYNTHETIC	MARBLE	GRANITE			Feed mm/min	rpm
pos. 0	Stock-removal	500-1000		500-600	0,3-0,5	4500-5000	400	4500
pos. 1	Shaping	1000-1500	1000-2000	1000-1500	0,3-0,5	4500-5000	500	4500
pos. 2	Honing	1000-1500	1000-2000	1000-1500	0,2-0,3	4500-5000	700	4500
pos. 3	Finishing	1000-1500	1000-2000	1000-1500	0,05-0,1	2500-4500	800	2600

POSITION	FUNCTION	Feed - mm/min			*Increment mm	rpm	Adaptive increment mm/m	DEKTON	
		SYNTHETIC	MARBLE	GRANITE				Feed mm/min	rpm
pos. 4	Pre-polishing	500-1000	500-1000	500-1000	0,3	1500-3000	0,01	1000	2500
pos. 5	Polishing	500-1000	500-1000	500-1000	0,3	1500-3000	0,01	1000	2500
pos. 6	Final buff			500-1000	0,3	1500-3000	0,01	1000	2500

* Use the increment, as indicated in the schedule, when setting the diamond wheels using their true diameter only



SHAPED TOOLS FOR INSIDE PROFILING MINIMUM DIAMETER 20 mm

WORKING PARAMETERS FOR CNC MACHINES

POSITION	FUNCTION	Feed - mm/min			Increment mm	rpm		Feed mm/min	rpm
		SYNTHETIC	MARBLE	GRANITE				DEKTON	
pos. 1	Profiling	800-1200	800-1200	800-1200	0,2-0,4	6000-8000		500	6000
pos. 2	Honing	800-1200	800-1200	800-1200	0,1-0,3	6000-8000		250	6000
pos. 3	Finishing	800-1200	800-1200	800-1200	0,05-0,1	6000-7000		100	6000

POSITION	FUNCTION	Feed - mm/min			Increment mm	rpm	Adaptive increment mm/m	Feed mm/min	rpm
		SYNTHETIC	MARBLE	GRANITE				DEKTON	
pos. 4	Pre-polishing	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01	300	3000
pos. 5	Polishing	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01	300	3000
pos. 6	Final buff	500 - 1000	500 - 1000	500 - 1000	0,3	3500	0,01	300	3000



FINGER BITS

WORKING PARAMETERS



MATERIALS	FORWARD SPEED mm/min	DIAMETER (mm)	ROTATION SPEED rpm
DEKTON	150	20 (5 segments)	4000-5000
CERAMIC	250	20 (5 segments)	6000-8000
GRANITE/SYNTHETIC	250	22 (7 segments)	7500-8000
GRANITE	200-500 200-500	24 (5 segments) 25 (6 segments)	5500 5700
MARBLE	500-2000	16-20	5000-6000

RIMS FOR PASSAGE CUTTING



Working parameters on manual machines, on all materials

8000-12000

FLAT LINE

WORKING PARAMETERS

	POSITION	ROTATION SPEED rpm	FORWARD SPEED ON FLAT SURFACE mm/min	PRESSURE	INCREMENT mm
SINTEX	pos. 0	4500	600	-	0,5
	pos. 1	4500	1000	-	0,3
	pos. 2	4500	1000	-	0,2
RUBBER	GR 500	800	3000	18%	-
	GR 1000	800	3000	18%	-
	GR 2000	800	3000	18%	-
	BUFFER*	800	3000	18%	-
	pos. 3	1000	1500	-	-
	pos. 4	1000	1500	-	-
	pos. 5	1000	1500	-	-
	pos. 6	1000	1500	-	-

*Use the buffer only for black granite

TOOLING FOR RECESS DRAINS FOR CNC MACHINES - SINTEX



TOOLING FOR RECESS DRAINS FOR CNC MACHINES - RUBBER

