

WORKING PARAMETERS

WORKING PARAMETERS FOR CNC MACHINES

| POSITION | FUNCTION | FORWARD SPEED mm/min | | | *INCREMENT mm | SPINDLE ROTATION SPEED rpm |
|----------------|---------------|----------------------|-----------|-----------|---------------|----------------------------|
| DIAMOND WHEELS | | SYNTHETIC | MARBLE | GRANITE | | |
| pos. 0 | Stock-removal | 500-1000 | | 500-600 | 0,3-0,5 | 4500-5000 |
| pos. 1 | Shaping | 1000-1500 | 1000-2000 | 1000-1500 | 0,3-0,5 | 4500-5000 |
| pos. 2 | Honing | 1000-1500 | 1000-2000 | 1000-1500 | 0,2-0,3 | 4500-5000 |
| pos. 3 | Finishing | 1000-1500 | 1000-2000 | 1000-1500 | 0,05-0,1 | 2500-4500 |

| 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 | 1500-3000 | 0,01 |
| pos. 5 | Polishing | 500-1000 | 500-1000 | 500-1000 | 0,3 | 1500-3000 | 0,01 |
| pos. 6 | Final buff | | | 500-1000 | 0,3 | 1500-3000 | 0,01 |

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