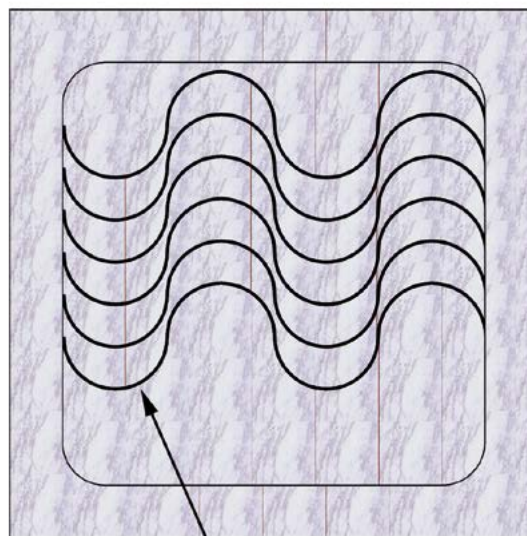
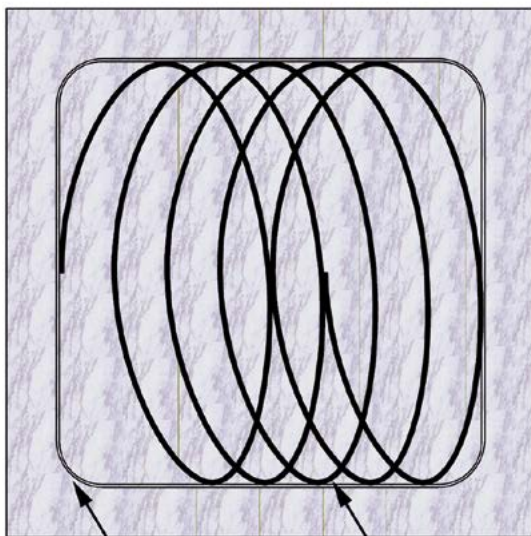


TOOLING FOR RECESS DRAINS FOR MANUAL MACHINES

POSITION		ROTATION SPEED rpm			
		Synthetic materials	Marble	Granite	Hard granites, gres and ceramics
pos. 0 (Stock-removal)	Progression x series passage numbers in progression	5000	10000	10000	10000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 1 (Profiling)	Progression x series passage numbers in progression	5000	8000	5000	5000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 2 (Honing)	Progression x series passage numbers in progression	5000	8000	5000	5000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 3 (Finishing)	Progression x series passage numbers in progression	1500	3000	3000	3000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 4 (Pre-polishing)	Progression x series passage numbers in progression	1500	3000	3000	3000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 5 (Polishing)	Progression x series passage numbers in progression	1500	3000	3000	3000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			
pos. 6* (Final buff)	Progression x series passage numbers in progression	1500	3000	3000	3000
		Perimetric x 2 -> elliptic x 3 -> undulatory x 3 -> perimetric x 1 Ensure plenty of tool lubrication			



Perimetric movement

Elliptic movement

Undulatory movement