



Operating Parameters for Vincent Tyrolit

120mm CNC Wheels for Granite and Engineered Stone working parameters

| Position | Type | Phase | Feeding Speed | | Stock Removal | Spindle Speed RPM |
|------------|--------------|-----------------|------------------------------------|------------------------------------|---|-------------------|
| | | | Granite cl. 1-3 | Granite cl.4-5 | | |
| Finger Bit | Segments | Rough Shaping | 300-350 mm/min 12-14 inch/min | 250-300 mm/min 10-12 inch/min | - | 4200-4800 |
| 0 | Segments | Profile Shaping | 500-600 mm/min 20-23 inch/min | 400-500 mm/min 16-20 inch/min | Max 0.5 mm/min Max 0.02 inch/min | 4500-4600 |
| 1 | Slotted | Roughing | 800-1000 mm/min 31-39 inch/min | 700-900 mm/min 28-35 inch/min | 0.3-0.4 mm/min 0.011-0.016 inch/min | 4500-4600 |
| 2 | Slotted | Profiling | 1300-1500 mm/min 51-59 inch/min | 1200-1400 mm/min 47-55 inch/min | 0.2-0.3 mm/min 0.008-0.011 inch/min | 4500-4600 |
| 3 | Slotted | Finishing | 1300-1500 mm/min 51-59 inch/min | 1200-1400 mm/min 47-55 inch/min | 0.1-0.15 mm/min 0.004-0.006 inch/min | 4500-4600 |
| 4 | White | Good Finishing | 700-800 mm/min 28-31 inch/min | | ZERO Pressure (max 0.05-0.1 mm/min 0.002-0.004 inch/min) | 2500-2600 |
| 5 | Blue | Polishing | 800-900 mm/min 31-35 inch/min | | | 2700-2800 |
| 6 | Orange | Final Buff | 900-1000 mm/min 35-39 inch/min | | | 3000 |
| IV | Rough | Polishing | 1200-1500 mm/min 47-59 inch/min | | Dynamic Comensation | 1200-1500 |
| V | Fine | Final Buff | 1200-1500 mm/min 47-59 inch/min | | | 1200-1500 |
| 4 | Winner Resin | | 1000-1400 mm/min 40-55 inch/min | | Set by hand | 2500 |
| 5 | Winner Resin | | | | | 2500 |
| 6 | Winner Resin | | | | | 2500 |