



Operating Parameters for Vincent Tyrolit

77mm 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	2750
5	Winner Resin					2750
6	Winner Resin					2750