

TECHNICAL HINTS

Achieving an optimal efficiency of our tools is possible only when using the right parameters of grinding: feed, depth, speed. It is inadmissible to use our products contrary to their application.

Table 1

Speed	100	125	150	200	250	300	350	400	450	500	Ø mm
700 rpm	4	5	5	8	9	11	13	15	17	19	m/sec
850 rpm	4	6	6	9	11	13	15	18	20	22	m/sec
950 rpm	5	6	7	10	12	14	16	19	22	25	m/sec
1200 rpm	6	8	10	12	16	19	22	25	28	31	m/sec
1400 rpm	7	9	11	15	18	22	26	29	33	36	m/sec
1600 rpm	8	11	13	17	21	25	29	33	36	42	m/sec
1800 rpm	9	12	14	19	24	28	33	37	42	47	m/sec
2000 rpm	10	13	15	21	26	31	37	42	47	52	m/sec
2200 rpm	12	14	17	23	29	34	40	46	52	57	m/sec
2400 rpm	13	15	19	25	31	37	43	50	56	62	m/sec
2600 rpm	14	17	20	27	34	40	47	54	61	68	m/sec
2800 rpm	15	18	22	29	37	44	51	58	65	73	m/sec
3000 rpm	16	20	24	31	40	47	55	63	70	78	m/sec
3200 rpm	17	21	25	33	42	50	58	67	75	83	m/sec

The following scopes of speed are recommended

Tools made of abrasive unwoven fabric

20÷25 m/sec,

Other materials: (fabric, sisal, wire etc.)

Cutting off

20÷25 m/sec,

Polishing

35÷42 m/sec,

Initial polishing

32÷38 m/sec,

Grinding

30 m/sec