



**Production Parameters and Technical Drawing**

STONE

**Segmented Corner Breaker (45 or Double 45)**

Position	RPM	Feed	Removal
0	5500	Up to 3000	>3mm

**Diamond Tools – 120mm OD (Edge Tools)**

Position	RPM	Feed	Removal
1	5500	Up to 3000	>1mm
2	5500	Up to 6000	>.4mm
3	5500	Up to 6000	>.3mm
4	5500	Up to 3000	>.2mm <.1mm

**Diamond Tools – 60mm OD(Sink Tools)**

Position	RPM	Feed	Removal
1	6000	Up to 3000	>1mm
2	6000	Up to 6000	>.4mm
3	6000	Up to 6000	>.3mm
4	6000	Up to 3000	>.2mm <.1mm

**Rubber Polish**

Position	Color	Grit	RPM	Feed
1	Yellow	800	2500	1200
2	Blue	1500	2500	1200
3	Orange	3000	2500	1200

**NEW! Flash Resin Polish**

Position	Color	Grit	RPM	Feed
1	Yellow	800	2500	1200
2	Blue	1500	2500	1200
3	Orange	3000	2500	1200

**Shape AK31-42**

