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Feed values for MKD diamond tools divided into 3 quality groups. Surfaces Q1 - Q3

Revolution	Q1	Q2	Q3	Q1	Q2	Q3
	Feed rate mm/min.	Feed rate mm/min.	Feed rate mm/min.	Feed rate mm/Sek.	Feed rate mm/Sek.	Feed rate mm/Sek.
18,000	189	337	450	3	5	7
24,000	252	450	600	4	7	10
32,000	336	600	800	5	10	13
40,000	420	750	1,000	7	12	16
55,000	577	1,031	1,375	9	17	22
60,000	630	1,125	1,500	10	18	25
80,000	840	1,500	2,000	14	25	33

Cutting depth in X und Y :	0,25 bis max. 0,5 mm
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The specified values correspond to average milling values and are only a decision aid there.
Deviations both down and up are possible and also from machine to machine.
The guideline values should only prevent a tool breakage.

Please pay attention to!

The tool is a finishing diamond for low chip removal, so it always has to be with one precutter tool milled before. Before using the Diamond tools as last clean up the swarfes from precutter, you always get a better surfaces.

If you have a electronic hight scanner for your tool, please note that the diamond can not scanned with this, you need to do it manual.