WORKING PARAMETERS

DIAREX diamond blade K4+

for ceramic and stoneware

diameter ø	rpm (1/min)
350 mm	2.850 - 3.000
400 mm	2.500 - 2.600
450 mm	2.200 - 2.300

thickness	feed speed straight cuts (m/min)	feed speed mitrecuts (m/min)
12 mm	2,0 - 3,5	0,8 - 1,2
20 mm	1,5 - 2,5	0,7 - 1,0
30 mm	1,0 - 1,5	0,5 - 0,8



König Tool Tipp

- Basic requirement is an optimum water supply and high water pressure
- Regularly check water supply and water quantity
- The water should hit core and segments at an angle of approx. 45°
- Feed rate for plunge cuts in Z-axis: 0,02 - 0,05 m/min