



MULTIWIRES/MONOWIRE

Parameters for starting a new wire(s)

(with soft granite doing 3 cuts if possible)

- 1st cut at 28 m/sec of linear speed wire
- 2nd cut at 29 m/sec
- 3rd cut at 30 m/sec

And increase till the ideal speed is reached: m/sec (30/31)

Use chart below for cm/h feed rates

Parameters of sawing 37 b/mt ø 8.3/8.7 mm						
Granite	Soft 1/2/3		Medium 4/5		Hard 6/7	
mq/h	0,8 to 1,2		0,6 to 0,9		0,4 to 0,7	
Block Length	linear speed m/sec	Cutting speed cm/h	linear speed m/sec	Cutting speed cm/h	linear speed m/sec	Cutting speed cm/h
2.00	30/31	40 to 60	30/31	30 to 45	30/31	20 to 35
2.25	30/31	35 to 52	30/31	26 to 40	30/31	17 to 31
2.50	30/31	32 to 48	30/31	24 to 36	30/31	16 to 28
2.75	30/31	30 to 43	30/31	21 to 32	30/31	14 to 25
3.00	30/31	26 to 40	30/31	20 to 30	30/31	13 to 23
3.25	30/31	24 to 36	30/31	18 to 27	30/31	12 to 21
3.50	30/31	22 to 34	30/31	18 to 25	30/31	11 to 20

PLEASE CALL YOUR MILES SUPPLY REP FOR SERVICE OR TROUBLESHOOTING

THANK YOU