



Wire Tension- 260KG or 573 Pounds

Wire Speed Chart

Linear Wire Speed For Break in

- 1st Cut at 24 m/sec
- 2nd Cut at 25 m/sec
- 3rd Cut at 26 m/sec

The ideal speed for cutting after break in is normally 26-27 m/sec for all cuts but is slightly dependent on material and type of saw!



Wire Arc- 7-9 CM, if wire is exceeding this slow down CM/H cutting speed!

PLEASE USE THIS SPEED CHART BELOW TO DETERMINE CUTTING SPEED IN CM/H. USE AS A STARTING POINT AND POSSIBLY INCREASE OR DECREASE SPEEDS DEPENDING ON WIRE ARC!!!!

| <p><u>Class 2 stone</u> (Grey, Black, White, Pink, and Brown)</p> | <p><u>Class 3 Stone</u> (Red, Blue, and Multicolor)</p> | <p><u>Class 4 Stone</u> (Gold)</p> | <p><u>Class 5 Stone</u> (Quartzite)</p> |
|--|--|--|---|
| <p><u>Speed CM/H</u> 1.6 divided by length of the block in meters!</p> | <p><u>Speed CM/H</u> 1.4 divided by length of the block in meters!</p> | <p><u>Speed CM/H</u> 1.1 divided by length of the block in meters!</p> | <p><u>Speed CM/H</u> .6 divided by length of the block in meters!</p> |

Example 1: You are cutting a block of Class 2 stone that measures 8 feet long. Convert 8 feet to meters which is 2.43 meters. Then take 1.6 from the chart above and divide that by 2.43. That gives you .658 so your speed would be 65-66 cm/h

Example 2: You are cutting a block of class 5 stone that measures 4 feet long. Convert 4 feet to meters which is 1.21 meters. Then take .6 from the chart above and divide that by 1.21. That gives you .495 so your speed would be 49-50 cm/h

PLEASE CALL YOUR MILES SUPPLY REP FOR SERVICE OR TROUBLE SHOOTING!!!