



## Tools list 2013-I STONE CUTTING

### Steel core informative list - granite & marble

Ø - mm	Thickness mm	Bore	Number of slots				Type
			C1	C1	C2-C2P-C4	C2-C2R-C2L	
240	1,6	60	15		15	17	N-G-T
290	1,8	60	18		18	21	N-G-T
340	2,2	60	21		21	25	N-G-T
390	2,5	60	24		24	28	N-G-T
440	2,8	60	26		26	32	N-G-T
490	2,8	60	30		30	36	N-G-T
540	3,5	60	32		32	40	N-G-T
590	3,5	60	36		36	42	N-G-T
615	3,5	60	36		36	42	N-G-T
640	4,0	60	38		38	46	N-G-T
690	4,0	60	40		40	50	N-G-T
715	4,0	60	40		40	50	N-G-T
740	4,5	80	42		42	54	N-G-T
790	4,5	80	46		46	57	N-G-T
815	4,5	80	46		46	57	N-G-T
840	4,5	80	48		50	57	N-G-T
884	5,0	80		64		64	N-G-T
934	5,0	80		64		64	N-G-T
984	5,0	100		70		70	N-G-T
1034	5,0	100		72		72	N-G-T
1084	5,5	100		74		74	N-G-T
1184	5,5	100		80		80	N-G-T
1232	6,0	100		84		84	N-T
1282	6,0	100		88		88	N-T
1332	6,0	100		88		88	N-T
1382	6,5	100		92		92	N-T
1482	6,5	100		100		100	N-T
1582	7,0	100		104		104	N-T
1682	7,0	100		112			N-T
1782	7,0	100		120			N-T
1982	8,0	100		128			N-T
2082	8,0	100		132			N-T
2182	8,0	150		132			N-T
2282	8,0	150		138			N-T
2482	9,0	150		140			N-T
2682	9,0	150		140			N-T
2982	9,3	150		160			N-T
3482	9,5	150		180			N-T

### Legenda

**C1 ( Ø 240 mm-840 mm)**

**C1 ( Ø 884 mm-3482 mm)**

**C2-C2P ( Ø 240 mm-840 mm)**

**C2-C2R-C2L ( Ø 240 mm-1582 mm)**

Large slots - useful space for brazing: 40 mm

Large slots - useful space for brazing: 24 mm

Narrow slots - useful space for brazing : 50 mm

Narrow slots - useful space for brazing : 40 mm

**N**

**G**

**T**

Normal steel core

Silent steel core - sandwich

Silent steel core - laser cut

# Tools list 2013-I STONE CUTTING

## Peripheral speed - granite & marble

		Peripheral speed ( m/sec)							
		25	30	35	40	45	50	55	60
<b>granite</b>									
<b>marble</b>									
<b>sandstone</b>									
<b>slate</b>									
<b>travertine</b>									
<b>Blade diameter (mm)</b>		Revolution per minute of the shaft ( RPM)							
250		1911	2293	2675	3057	3439	3822	4204	4586
300		1592	1911	2229	2548	2866	3185	3503	3822
350		1365	1638	1911	2184	2457	2730	3003	3276
400		1194	1433	1672	1911	2150	2389	2627	2866
450		1062	1274	1486	1699	1911	2123	2335	2548
500		955	1146	1338	1529	1720	1911	2102	2293
600		796	955	1115	1274	1433	1592	1752	1911
700		682	819	955	1092	1228	1365	1501	1638
800		597	717	836	955	1075	1194	1314	1433
900		531	637	743	849	955	1062	1168	1274
1000		478	573	669	764	860	955	1051	1146
1100		434	521	608	695	782	869	955	1042
1200		398	478	557	637	717	796	876	955
1300		367	441	514	588	661	735	808	882
1400		341	409	478	546	614	682	751	819
1500		318	382	446	510	573	637	701	764
1600		299	358	418	478	537	597	657	717
1800		265	318	372	425	478	531	584	637
2000		239	287	334	382	430	478	525	573
2500		191	229	268	306	344	382	420	459
2700		177	212	248	283	318	354	389	425
3000		159	191	223	255	287	318	350	382
3500		136	164	191	218	246	273	300	328

## Saw blade : application guideline for marble

### Stone classification: example of marble and limestone

A	B	C	D
Compact / Low abrasive	Compact / Medium abrasive	Medium porous / Medium abrasive	Porous / Abrasive
Biancone	Blue Crystal	Arabescato	Dolomia
Botticino	Galala	Carrara	Hauteville
Comblanchien	Marfil	Ekeberg	Travertine
Jura	Perlato	Macacreme	Vratza
Lioz	Pink Portugal	Onyx	
Nero Marquina	Serpentino	Pierre Blue	
Rosso Alicante	Tinos	White Crystal Turkey	
Rosso Verona	Trani		

## Definitions

Compact	Difficult (hard) to cut
Porous	Easy (soft) to cut

## Tools list 2013-I STONE CUTTING

### Saw blade : specification guideline for marble

Ø	Material	Application	Power machine	Ø	Type
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### Bridge cutter ( including cross cutter )

300 to 800	<b>A+B</b>	Easy cutting	Low -High	All	<b>M0</b>
	<b>B+C+D</b>	Universal for medium abrasive and mix materials	Low -High	All	<b>M1</b>
	<b>C+D</b>	Universal for abrasive materials	High	350-400	<b>M2</b>
	<b>D</b>	Long life For abrasive materials	High	600-700-800	<b>M3</b>

Ø	Material	Application	Power machine	Ø	Type
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### Block Saw machines

900 to 3500	<b>A</b>	Easy cutting	Low	All	<b>M10</b>
	<b>A+B</b>	Universal, for compact and medium abrasive	High	All	<b>M20</b>
	<b>B+C</b>	Universal, for medium to abrasive materials	Low -High	All	<b>M30</b>
	<b>C+D</b>	Long life For abrasive materials	Low -High	All	<b>M50</b>
	<b>D</b>	Long life For abrasive materials with quartz inclusion	High	All	<b>M70</b>

## Saw blade : specification guideline for marble

Ø	Material	Application	Power machine	Ø	Type
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### Horizontal for block cutter

400 to 500	<b>A+B+C</b>	Universal for medium abrasive and mix materials	High		<b>M2H</b>
	<b>C+D</b>	Universal for abrasive materials	High		<b>M3H</b>

Ø	Material	Application	Power machine	Ø	Type
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### Splitting machine

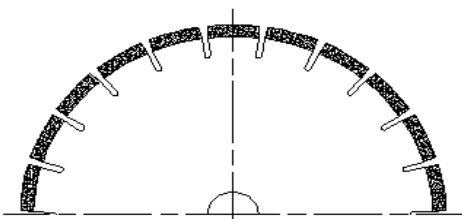
625 to 850	<b>A</b>	Easy cutting	High		<b>M1S</b>
	<b>A+B+C</b>	Universal for medium abrasive and mix materials	High		<b>M2S</b>
	<b>C+D</b>	Universal, for medium to abrasive materials	High		<b>M3S</b>

Material	Application			Type
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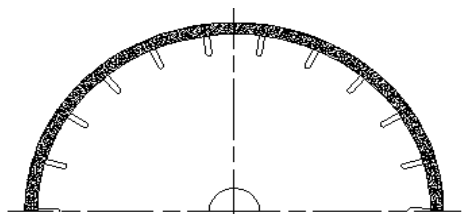
### Gang saws

	<b>A+B</b>	Easy cutting			<b>BCHS0</b>
	<b>B+C+D</b>	Universal for medium abrasive and mix materials			<b>BCHS1</b>
	<b>C+D</b>	Universal, for medium to abrasive materials			<b>BCHS2</b>
	<b>D</b>	Long life For abrasive materials			<b>BCHS3</b>

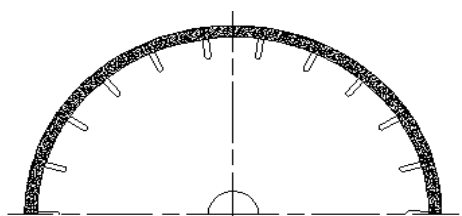
## Shape recommendations - diam 300-800 Marble



- Core : C2 N - G (standard - SDW low noise )
- Bore : 60/50
- Segment : 40 X 7
- Diam all
- Universal use



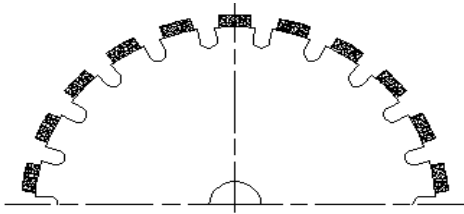
- Core : C2L N - G (standard - SDW low noise )
- Bore : 60/50
- Segment : 44 X 7
- Diam 350 - 400
- Good finishing - Universal for cross cutting



- Core : C2J N - G (standard - SDW low noise )
- Bore : 60/50
- Segment : 42 X 10 turbo
- Diam 350 - 600
- Good finishing - Long life



## Shape recommendations - diam 900-2000 Marble

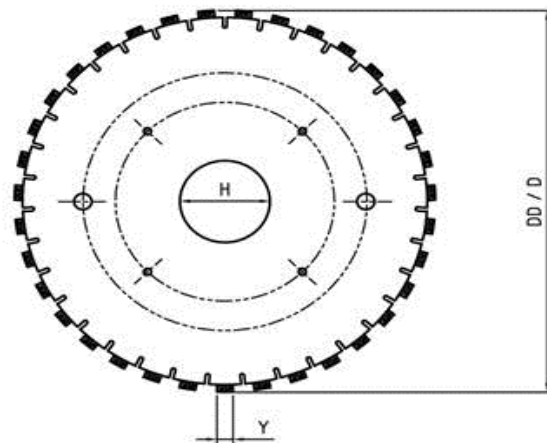
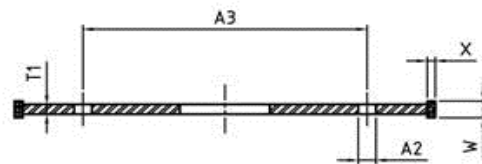


- Core : C1 N (standard - SDW low noise)
- Bore : as per request
- Segment : 24 X 10 - Parallel - ZNr 3
- Segment : 24 X 10 - Universal - Price/l.m. - ZNr 3
- Diam all
- Universal use

Retipping of cores is not recommended and in any case it depends on the use, the work modes and the cutted materials  
At the discretion of the customer and under his responsibility the decision to re-use the core

**Required parameters for the definition of the complete blade:**

- Central hole diameter/reduction
- Drawing of the machine attachment
- Model of the machine
- Machine manufacturer name



## Saw blade application guide for granite

### Stone classification: example of granite

Class 1	Class 2	Class 3	Class 4	Class 5
Wear factor 1	Wear factor 1,4	Wear factor 1,8	Wear factor 2,5	Wear factor 4
Andesite	Giallo Veneziano	Africa Juparana	Baltic Brown	African Red
Nero Impala	Blue Ice	Angola Blue	Baltic Green	Rosso Assoluto
Nero Assoluto	Juparana Firenze	White Sardo	Dakota Red	Luserna
Nero Badajoz	Blue Pearl	Ghiandone	Grigio Perla	Verde Bamboo
Nero Orientale	Verde Bahia	Gneiss	Multicolor Red	Verde Marinace
Nero Tijuca	Golden Forest	Golden Crystal	Imperial Red	Rosso Marinace
Labrador Dark	Ivory Brown	Kashmir Gold		
Black galaxy	Black Angola	Rosa Porrigno		
	Kashmir White	Serizzo		
		Silver Pearl		

## Definitions

Soft	Class 1 , 2
Hard	Class 4 , 5
Mix	Class 1 , 2 , 3 - Class 4 and 5 less than 15%



## Tools list 2013-I STONE CUTTING

### Saw blade : specification guideline for granite

#### Bridge saw and cross cutting machines

∅	granite class	Application	Power machine	Spec	
300 to 850	All	Bridge Saw / Mansory	Universal , free cutting, granite and eng. stone	All	G0
	Mix	Bridge Saw / Multiple cross cutting	Universal, for mix granites and eng. stone	Low -Medium	G1
	Mix	Bridge Saw / Multiple cross cutting	Universal, higher lifetime, for mix granite and eng. stone	Medium-High	G2
	Soft	Bridge Saw / Single cross cutting	Universal, for soft and abrasive granites	Medium-High	G3
	All	Bridge Saw	Deep cutting, high speed (when finishing is not a priority)	All	GX

#### Block Saw machines

∅	granite class	Application	Power machine	Spec	
900 to 3500	All	Block saws	Easy cutting ; deep cutting	All	TB10
	Mix	Block saws	Universal	Low -Medium	TB20
	Mix	Block saws	Universal	Medium-High	TB30
	Soft	Block saws	For abrasive materials	High	TB40

#### Definitions for granite classes

Soft	Class 1 , 2
Hard	Class 4 , 5
Mix	Class 1 , 2 , 3 - Class 4 and 5 less than 15%
All	Class 1 , 2 , 3 , 4 , 5

## Tools list 2013-I STONE CUTTING

### Multiblade machine

∅	granite class	Application	Power machine	Spec	
1000 to 1600	<b>Hard</b>	Multiblades	Universal-on machines without inverter	All	<b>MTB1</b>
	<b>Mix</b>	Multiblades	Universal-deep cutting	All	<b>MTB2</b>
	<b>All</b>	Multiblades	Universal-on machines without inverter	All	<b>MTB3</b>
	<b>Mix</b>	Multiblades	Universal	All	<b>MTB4</b>

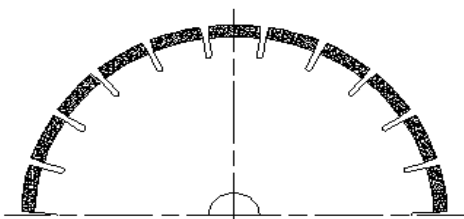
### Horizontal for multiblade machines

∅	granite class	Application	Power machine	Spec	
350 to 400	<b>All</b>	Horizontal	High speed	All	<b>GOR1</b>
	<b>All</b>	Horizontal	Universal	All	<b>GOR3</b>
	<b>All</b>	Horizontal	High lifetime	All	<b>GOR2</b>

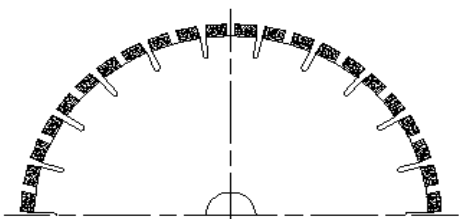
### Definitions for granite classes

Soft	Class 1 , 2
Hard	Class 4 , 5
Mix	Class 1 , 2 , 3 - Class 4 and 5 less than 15%
All	Class 1 , 2 , 3 , 4 , 5

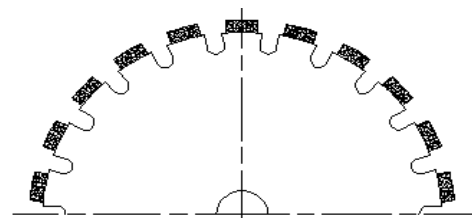
## Shape recommendations



- Core : C2 N - G - T (standard - SDW low noise )
- Bore : 60/50
- Diam 300 - 1200
- Universal use



- Core : C2P N - G (standard - SDW low noise )
- Bore : 60/50
- Diam 350 - 850
- Fast cutting



- Core : C1 N - T ( standard - silent laser cut )
- Bore : based on diameter
- Diam 900 - 3500
- Universal use

