

## MAMO Sintered Stone Cutting Speed Guide

This cutting guide has been developed to provide fabricators with reliable baseline parameters for working with MAMO Sintered Stone. Due to the material's density and low porosity, correct spindle speed, feed rate, and abrasive selection are critical to achieving clean edges and preventing surface blow-out—particularly on darker colours and 20mm thickness. We recommend treating these figures as starting points and adjusting according to machine capability, tooling condition, and slab behaviour on the day.

Bridge Saw Cutting	Disc Diameter mm	RPM	Cutting Speed ( Black Colour Slab )	Cutting Speed ( other Colours Slab )
20mm Sintered Stone	350	2800-4000	500-700mm / Min	600-850mm / Min
12mm Sintered Stone			650-850mm / Min	1150-1350mm / Min

Water Jet Cutting	Pressure(MPa)	Cutting Abrasive	Cutting Speed ( Black Colour Slab )	Cutting Speed ( other Colours Slab )
20mm Sintered Stone	280-320	Mesh 80 (150-190g/Min)	300-550mm / Min	400-650mm / Min
12mm Sintered Stone			450-650mm / Min	550-750mm / Min



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### IMPORTANT NOTE

Always ensure stable support under the slab, especially when processing 20mm sheets, to minimise vibration and reduce the risk of cracking or 'blow-outs' during fabrication.