

**WORKING SPEEDS**

How good Total Output

mm/min

Material	up to 3/8"	3/8 - 1/2"	1/2" - 1 1/8"	1 1/8" - 2"
<b>TURNING</b>				
Steel	1000/1	800/1	600/2	500/3
Free metal	2000/1	1600/1	1000/2	800/2
Wood, Plastic	generally 1000/1			
<b>THREAD CUTTING</b>				
All types of materials	generally 500/1			
<b>FACE &amp; LANE SAWING</b>				
Steel	generally 500/1			
Free metal	generally 800/2			
Wood, Plastic	generally 1000/2			
<b>CIRCULAR SAWING</b>				
Steel	generally 500/1			
Free metal	generally 800/2			
Wood, Plastic	generally 1000/2			

\* The figure in brackets refers to the corresponding numbered table settings (Page 28)

SETTING	Feed	Rev./Turning
<b>DRILLING</b>		
Drill cutting up to 3/8" dia.	100	0
up to 3/4" dia.	80	0
up to 1" dia.	60	1
Material diameter and blade feed 1 1/8" dia.	50	1
<b>DRILLING OF HOLES</b>		
For heavy metal groups, double		
up to 1/2" dia. drill	100	0
1/2 - 3/4" dia. drill	100	0
3/4 - 1" dia. drill	80	1
1" - 1 1/4" dia. drill	50	1
<b>GRINDING</b>		
Grinding wheel 1 1/2" dia. for tool grinding		
Coarse grinding	500	1
Fine grinding	500	1
Cup grinding wheel	500	1
Grinding pin 3/8" dia.	370	0
Toolbit grinding pin	500	0
<b>GRINDING WITH SAND</b>		
Steel and free metal	80	0

**BUT WELDING AND STEEL**

These speeds apply when the tool is in proportion to the total width of the work. Because of the work period, characteristics of the work the speed increases with the machine turning of the tool and decreases with heavier loading. The units given in the table are mean average values.

1. S.P.M.	Tooling	Feed	Depth	2. S.P.M.	Tooling	Feed	Depth
① 365				② 685			
③ 850				④ 2600			
⑤ 1750				⑥ 6000			
⑦ 2600				⑧ 500			
⑨ 1100				⑩ 2000			
⑪ 155				⑫ 300			

Diagram 28

On the basis of an example we will show you how to calculate a working speed.

We require two values:

- 1.) Material (Aluminium, brass, steel, cast metal, etc.)
- 2.) Thickness of material (diameter or thickness of workpiece)

For our example we will use a 1/2" rod of **ALU** diameter.

Under "DRILLING OF HEAVY METALS" and "DRILLING THICKNESS OF STEEL (S.P.M.)" a speed (number of revolutions) of 1000 p.m. is given in the table above. With the second figure, in this case an 8, we look up in the speed table above the necessary table setting and with the help of the Diagram we then set the speed on the machine.

# Emco Unimat 4 User Guide

**N Noddings**



**Emco Unimat 4 User Guide:**

Emco Unimat 4 User Guide: Bestsellers in 2023 The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous engrossing novels captivating the hearts of readers worldwide. Lets delve into the realm of top-selling books, exploring the captivating narratives that have captivated audiences this year. Emco Unimat 4 User Guide : Colleen Hoover's "It Ends with Us" This heartfelt tale of love, loss, and resilience has gripped readers with its raw and emotional exploration of domestic abuse. Hoover masterfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids captivating storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens crafts a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These top-selling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of compelling stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a brilliant and gripping novel that will keep you speculating until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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web apr 3 2023 the experiment described above can be summarized in a graph called a heating curve figure below figure 11 16 1 11 16 1 in the heating curve of water the temperature is shown as heat is continually added changes of state occur during plateaus because the temperature is constant

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web mar 29 2013 heating curves imagine that you have a block of ice that is at a temperature of 30 °C well below its melting point the ice is in a closed container as heat is steadily added to the ice block the water molecules will begin to vibrate faster and faster as they absorb kinetic energy

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web the cooling curve a plot of temperature versus cooling time in figure pageindex 4 plots temperature versus time as a 75 g sample of steam initially at 1 atm and 200 c is cooled although we might expect the cooling curve to be the mirror image of the heating curve in figure pageindex 3 the cooling curve is not an

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web once all of the material has solidified at the time indicated by point c the cooling will continue at a rate determined by the heat capacities of the two solids a and b the composition and of course the geometry of the experimental set up by measuring cooling curves for samples of varying composition one can map the entire phase

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web heating and cooling curves are graphs they plot a substance s temperature y axis against heat x axis for heating curves we start with a solid and add heat energy for cooling curves we start with the gas phase and remove heat energy cooling and heating curves have five segments let s study each one by looking at heating ice to

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web for water this temperature is 100 c because the boiling point for water is 100 c different substances have different melting points and boiling points but the shapes of their heating curves are very similar for example this is the heating curve for iron a metal that melts at 1538 c and boils at 2861 c cooling curves

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