

WORKING SPEEDS

Motor speed: Rated Output

RPM in p.m.

Material	up to 3/8"	3/8 - 1/2"	1/2" - 1 1/8"	1 1/8" up
TURNING				
Steel	1000 (1)	800 (1)	400 (2)	300 (1)
Easy metal	2000 (1)	1600 (1)	1000 (2)	400 (2)
Wood, Plastic	generally 1000 (1)			
THREAD CUTTING				
All types of materials	generally 300 (2)			
FEED or LARGE SAWING				
Steel	generally 300 (1)			
Easy metal	generally 400 (2)			
Wood, Plastic	generally 1000 (2)			
CIRCULAR SAWING				
Steel	generally 300 (1)			
Easy metal	generally 400 (2)			
Wood, Plastic	generally 1000 (1)			

* the figure in brackets relate to the corresponding numbered belt settings (Page 28)

MILLING	Speed	Belt setting
Shank milling up to 3/8" dia.	1100	10
up to 3/4" dia.	800	9
up to 1 1/8" dia.	400	7
Model diameter and blades from 1 1/8" dia.	300	5
GRINDING OF STEEL		
for heavy metal spacers, double		
up to 1/8" dia. with	1000	8
1/8 - 3/8" dia. with	1100	10
3/8 - 1 1/8" dia. with	800	9
1/8 - 1/4" dia. with	300	5
GRINDING		
Grinding wheel 3 1/2" dia. for tool grinding		
Coarse grinding	2000	11
Fine grinding	2000	7
Cup grinding wheel	2000	7
Grinding pin 3/8" dia.	2700	8
Insulator grinding pin	2000	8
GRINDING WITH SAND		
Steel and easy metal	800	9

BELT SETTING AND SPEEDS

These speeds apply when the tool is in proportion to the rated output of the motor. Because of the wear (period), characteristics of the motor the speeds increase with the machine running at its best and decrease with heavier loading. The speeds given in the tabulation are mean (average) values.

1. p.m.	machines	type	model	1. p.m.	machines	type	model
① 365				② 645			
③ 850				④ 2600			
⑤ 1750				⑥ 6000			
⑦ 2600				⑧ 1600			
⑩ 1100				⑪ 2000			
⑫ 155				⑬ 300			

Diagram 32

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 steel rod of 3/8" diameter.

Under "GRINDING OF HEAVY METAL" and "GRINDING, THICKNESS OF (Steel 3/8")" a speed (number of revolutions) of 1600 r.p.m. is given in the tabulation. With the second figure, in this case on ⑧, we look up in the speed tabulation the necessary belt setting and with the help of the Diagram we then set the speed on the machine.

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Huangqi Zhang



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