

## WORKING SPEEDS

Motor speed: Rated Output

mm/s.p.m.

| Material               | up to 3/8"        | 3/8 - 3/4" | 3/4" - 1 1/8" | 1 1/8" up |
|------------------------|-------------------|------------|---------------|-----------|
| TURNING                |                   |            |               |           |
| Steel                  | 1000(10)          | 800(7)     | 600(5)        | 500(4)    |
| Flame treated          | 800(7)            | 1000(8)    | 1000(10)      | 600(5)    |
| Wood, Plastic          | generally 1000(8) |            |               |           |
| THREAD CUTTING         |                   |            |               |           |
| All types of materials | generally 500(3)  |            |               |           |
| FACE & LARGE SAWING    |                   |            |               |           |
| Steel                  | generally 500(3)  |            |               |           |
| Flame metal            | generally 600(5)  |            |               |           |
| Wood, Plastic          | generally 1000(8) |            |               |           |
| CIRCULAR SAWING        |                   |            |               |           |
| Steel                  | generally 500(3)  |            |               |           |
| Flame metal            | generally 600(5)  |            |               |           |
| Wood, Plastic          | generally 1000(8) |            |               |           |

\* the figure in brackets relate to the corresponding numbered belt settings (Page 26)

| <b>GRINDING</b>                              | Speed | Belt setting |
|----------------------------------------------|-------|--------------|
| Work milling up to 3/8" dia.                 | 1000  | 10           |
| up to 3/4" dia.                              | 800   | 9            |
| up to 3/2" dia.                              | 600   | 7            |
| Work circular saw blades from 1 1/8" dia.    | 500   | 5            |
| <b>GRINDING OF STEEL</b>                     |       |              |
| for flame metal approx. double               |       |              |
| up to 1/8" dia. with                         | 1000  | 9            |
| 1/8 - 3/8" dia. with                         | 1000  | 10           |
| 3/8 - 3/4" dia. with                         | 800   | 9            |
| 3/4 - 1 1/4" dia. with                       | 500   | 7            |
| <b>GRINDING</b>                              |       |              |
| Grinding wheel 3 1/2" dia. for tool grinding |       |              |
| Coarse grinding                              | 5000  | 11           |
| Fine grinding                                | 5000  | 7            |
| Cut grinding wheel                           | 5000  | 7            |
| Grinding pin 3/8" dia.                       | 3750  | 9            |
| Tool grinding pin                            | 5000  | 9            |
| <b>GRINDING WITH SAND</b>                    |       |              |
| Steel and flame metal                        | 800   | 9            |

## BELT SETTING AND SPEED

These speeds apply when the tool is in proportion to the rated output of the motor. Because of the wide variety of characteristics of the motor the speeds increase with the machine turning of its load and decrease with heavier loading. The speeds given in the tabulation are mean (average) values.

| 1. p.m.   | machining | steel | wood | 1. p.m.   | machining | steel | wood |
|-----------|-----------|-------|------|-----------|-----------|-------|------|
| ①<br>365  |           |       |      | ②<br>685  |           |       |      |
| ③<br>850  |           |       |      | ④<br>2600 |           |       |      |
| ⑤<br>1750 |           |       |      | ⑥<br>6000 |           |       |      |
| ⑦<br>2600 |           |       |      | ⑧<br>5000 |           |       |      |
| ⑩<br>1100 |           |       |      | ⑪<br>2000 |           |       |      |
| ⑫<br>155  |           |       |      | ⑬<br>300  |           |       |      |

Diagram 30

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 flame rod of 3/8" diameter.

Under "GRINDING OF FLAME METAL" and "GRINDING, THICKNESS OF (Steel 3/8")" a speed (number of revolutions) of 1000 r.p.m. is given in the tabulation. With the second figure, in this case on ⑤, 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.

# Emco Unimat 4 User Guide

**Xiaolong Qi**



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