

WORKING SPEEDS

Motor speed: Total 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)
Easy metal	2000(11)	1600(8)	1200(6)	1000(5)
Wood, Plastic	generally 1000(8)			
THREAD CUTTING				
All types of materials	generally 800(10)			
FACE & LARGE SAWING				
Steel	generally 500(1)			
Easy metal	generally 1000(2)			
Wood, Plastic	generally 1000(2)			
CIRCULAR SAWING				
Steel	generally 500(1)			
Easy metal	generally 1000(2)			
Wood, Plastic	generally 1000(2)			

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

GRINDING	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
GRINDING OF STEEL		
for heavy metal approx. double		
up to 1/2" dia. with	1000	9
1/2 - 3/4" dia. with	1000	10
3/4 - 1 1/4" dia. with	800	9
1 1/4 - 1 1/2" dia. with	500	7
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.	2000	9
Tool grinding pin	2000	9
GRINDING WITH SAND		
Steel and easy metal	800	9

BELT SETTING AND SPEED

These speeds apply when the tool is in proportion to the total output of the motor. Because of the belt (series) characteristics of the motor the speeds increase with the machine turning at its best 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
① 365				② 685			
③ 850				④ 2600			
⑤ 1750				⑥ 6000			
⑦ 2600				⑧ 6000			
⑨ 7100				⑩ 2000			
⑪ 155				⑫ 300			

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 steel rod of 3/8" diameter.

Under "GRINDING OF HEAVY METAL" and "GRINDING, THICKNESS OF (Steel 30-300)" 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

Lei Huang

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