

## 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)    |
| Flame treated          | 800(7)            | 1000(8)     | 1000(10)      | 600(5)    |
| Wood, Plastic          | generally 1000(8) |             |               |           |
| THREAD CUTTING         |                   |             |               |           |
| All types of materials | generally 800(7)  |             |               |           |
| FACE & LARGE SAWING    |                   |             |               |           |
| Steel                  | generally 500(4)  |             |               |           |
| Flame metal            | generally 600(5)  |             |               |           |
| Wood, Plastic          | generally 800(7)  |             |               |           |
| CIRCULAR SAWING        |                   |             |               |           |
| Steel                  | generally 500(4)  |             |               |           |
| Flame metal            | generally 600(5)  |             |               |           |
| Wood, Plastic          | generally 1000(8) |             |               |           |

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

| <b>MILLING</b>                               | Speed | Belt setting |
|----------------------------------------------|-------|--------------|
| Shank milling up to 3/8" dia.                | 1000  | 10           |
| up to 3/4" dia.                              | 800   | 9            |
| up to 3/2" dia.                              | 600   | 7            |
| Model circular saw blades from 1 1/8" dia.   | 500   | 6            |
| <b>GRINDING OF STEEL</b>                     |       |              |
| for heavy 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            |
| Cup grinding wheel                           | 5000  | 7            |
| Grinding pin 3/8" dia.                       | 3750  | 9            |
| Insulator 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 total 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>6000 |           |       |      |
| ⑨<br>1700 |           |       |      | ⑩<br>2000 |           |       |      |
| ⑪<br>155  |           |       |      | ⑫<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 steel rod of 3/8" diameter.

Under "GRINDING OF HEAVY METAL" and "GRINDING, THICKNESS OF (Steel 3/8")" a speed (number of revolutions) of 1670 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

**Yi-Tong Ma**



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