

WORKING SPEEDS

Motor speed: Rated Output

RPM in p.m.

Material	up to 3/8"	3/8 - 3/4"	3/4" - 1 1/8"	1 1/8" up
TURNING				
Steel	1000 (1)	800 (1)	600 (2)	500 (1)
Easy metal	2000 (1)	1600 (3)	1200 (4)	1000 (2)
Wood, Plastic	generally 1000 (3)			
THREAD CUTTING				
All types of materials	generally 500 (2)			
FEED or 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 (3)			

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

MILLING	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 diameter and blades from 1 1/8" dia.	500	5
GRINDING OF STEEL		
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
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 rated output of the motor. Because of the wide variety of 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			
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 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

Raffaela Di Napoli



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web where does the setting take place for this story q which character put a spell on ranita q what was felipe looking for at the beginning of the story q what step did ranita have to take in order for the spell to be broken q what

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web scene 1 1 curtains open in a forest clearing men are frantically searching the ground from a nearby stone well ranita watches but remains unnoticed 2 man 1 frustrated keep looking if we don t find that golden arrow 3 man 2 we ll be on tortillas and water for the next month 4 men grumbling all agree enter felipe

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promise next she almost gets caught and cooked felipe refuses to let the frog eat off his plate and to sleep next to a frog then he refuses to kiss the frog at the end of the story felipe is turned into a frog

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