

## 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 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	5
<b>GRINDING OF STEEL</b>		
for heavy metal approx. double		
up to 1/8" dia. with	1000	9
3/8 - 3/4" dia. with	1000	10
3/8 - 3/4" dia. with	800	9
3/8 - 3/4" dia. with	500	7
<b>GRINDING</b>		
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
<b>GRINDING WITH SAND</b>		
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 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 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

**J Rink**



## **Emco Unimat 4 User Guide:**

The Top Books of the Year Emco Unimat 4 User Guide The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous engrossing novels enthralling the hearts of readers worldwide. Lets delve into the realm of bestselling books, exploring the engaging narratives that have enthralled audiences this year. Emco Unimat 4 User Guide : Colleen Hoover's "It Ends with Us" This touching tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Uncover the Best : Taylor Jenkins Reid's "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reid's compelling storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens' "Where the Crawdads Sing" This mesmerizing coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, entrancing readers with its evocative prose and mesmerizing setting. These top-selling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of captivating stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and suspenseful novel that will keep you wondering until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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