

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 (2)	1000 (2)
Wood, Plastic	generally 1000 (3)			
THREAD CUTTING				
All types of materials	generally 500 (2)			
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 (3)			

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

SETTING	Speed	Belt setting
DRILLING Drill milling up to 1/8" dia. up to 3/8" dia. up to 3/4" dia. Metal circular saw blades from 1 1/8" dia.	1000	10
	800	9
	600	7
	500	5
GRINDING OF STEEL for heavy metal approx. double up to 1/8" dia. with 1/8 - 3/8" dia. with 3/8 - 3/4" dia. with 3/4 - 1 1/4" dia. with	1000	9
	1000	10
	800	9
	500	5
GRINDING Grinding wheel 3 1/2" dia. for tool grinding Coarse grinding Fine grinding Cut grinding wheel Grinding pin 3/8" dia. Tool grinding pin	2000	11
	2000	7
	2000	7
	2000	9
	2000	9
	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 1600		⑨ 850			
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 1600 r.p.m. is given in the tabulation. With the second figure, in this case on ⑧, 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

M Mark



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