

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 (2)	1200 (2)	1000 (2)
Wood, Plastic	generally 1000 (2)			
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 (2)			

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

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.

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Table of Contents Emco Unimat 4 User Guide

1. Understanding the eBook Emco Unimat 4 User Guide
 - The Rise of Digital Reading Emco Unimat 4 User Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Emco Unimat 4 User Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Emco Unimat 4 User Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Emco Unimat 4 User Guide
 - Personalized Recommendations
 - Emco Unimat 4 User Guide User Reviews and Ratings
 - Emco Unimat 4 User Guide and Bestseller Lists
5. Accessing Emco Unimat 4 User Guide Free and Paid eBooks
 - Emco Unimat 4 User Guide Public Domain eBooks
 - Emco Unimat 4 User Guide eBook Subscription Services
 - Emco Unimat 4 User Guide Budget-Friendly Options
6. Navigating Emco Unimat 4 User Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Emco Unimat 4 User Guide Compatibility with Devices
 - Emco Unimat 4 User Guide Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Emco Unimat 4 User Guide
 - Highlighting and Note-Taking Emco Unimat 4 User Guide
 - Interactive Elements Emco Unimat 4 User Guide

8. Staying Engaged with Emco Unimat 4 User Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Emco Unimat 4 User Guide
9. Balancing eBooks and Physical Books Emco Unimat 4 User Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Emco Unimat 4 User Guide
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Emco Unimat 4 User Guide
 - Setting Reading Goals Emco Unimat 4 User Guide
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Emco Unimat 4 User Guide
 - Fact-Checking eBook Content of Emco Unimat 4 User Guide
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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