

## WORKING SPEEDS

Motor speed: Rated 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)    |
| Easy metal             | 2000(11)          | 1600(8)    | 1200(6)       | 1000(5)   |
| Wood, Plastic          | generally 1000(8) |            |               |           |
| THREAD CUTTING         |                   |            |               |           |
| All types of materials | generally 800(10) |            |               |           |
| 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(2) |            |               |           |

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

| <b>GRINDING</b>                              | Speed | Belt setting |
|----------------------------------------------|-------|--------------|
| Work milling up to 3/8" dia.                 | 1000  | 10           |
| up to 3/4" dia.                              | 800   | 9            |
| up to 3/2" dia.                              | 600   | 7            |
| Work circular saw blades from 1 1/8" dia.    | 500   | 5            |
| <b>GRINDING OF STEEL</b>                     |       |              |
| for heavy metal approx. double               |       |              |
| up to 1/2" dia. with                         | 1000  | 9            |
| 1/2 - 3/4" dia. with                         | 1000  | 10           |
| 3/4 - 1 1/4" dia. with                       | 800   | 9            |
| 1 1/4 - 1 1/2" dia. with                     | 500   | 7            |
| <b>GRINDING</b>                              |       |              |
| Grinding wheel 3 1/2" dia. for tool grinding |       |              |
| Coarse grinding                              | 2000  | 11           |
| Fine grinding                                | 2000  | 7            |
| Cut 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<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 10-111)" 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

**L Towne**



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

This book delves into Emco Unimat 4 User Guide. Emco Unimat 4 User Guide is a crucial topic that must be grasped by everyone, from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into Emco Unimat 4 User Guide, encompassing both the fundamentals and more intricate discussions.

1. This book is structured into several chapters, namely:

- Chapter 1: Introduction to Emco Unimat 4 User Guide
- Chapter 2: Essential Elements of Emco Unimat 4 User Guide
- Chapter 3: Emco Unimat 4 User Guide in Everyday Life
- Chapter 4: Emco Unimat 4 User Guide in Specific Contexts
- Chapter 5: Conclusion

2. In chapter 1, the author will provide an overview of Emco Unimat 4 User Guide. This chapter will explore what Emco Unimat 4 User Guide is, why Emco Unimat 4 User Guide is vital, and how to effectively learn about Emco Unimat 4 User Guide.
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4. In chapter 3, the author will examine the practical applications of Emco Unimat 4 User Guide in daily life. The third chapter will showcase real-world examples of how Emco Unimat 4 User Guide can be effectively utilized in everyday scenarios.
5. In chapter 4, this book will scrutinize the relevance of Emco Unimat 4 User Guide in specific contexts. The fourth chapter will explore how Emco Unimat 4 User Guide is applied in specialized fields, such as education, business, and technology.
6. In chapter 5, this book will draw a conclusion about Emco Unimat 4 User Guide. This chapter will summarize the key points that have been discussed throughout the book.

The book is crafted in an easy-to-understand language and is complemented by engaging illustrations. It is highly recommended for anyone seeking to gain a comprehensive understanding of Emco Unimat 4 User Guide.

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