

## Operational Speeds

OPERATION		MATERIAL		SPECIAL SETTING	OPERATION		MATERIAL		SPECIAL SETTING					
GENERAL SAWING		WOOD		R	<b>D</b>	Up to 1/4"		WOOD		S				
HEAVY RIPPING		WOOD		O		1/4" - 1/2"				P				
DADOING — MAGNA DADO		WOOD		MAGNA DADO		1/2" - 3/4"				M				
DADOING — 6" DADO ASSY.		WOOD		R		3/4" - 1"				K				
SAWING (SPECIAL BLADE)		PLASTICS		L		Over One Inch				SLOW				
MOLDING		WOOD		R		<b>R</b>	Up to 1/8"		SOFT METAL		FAST			
JOINTING		WOOD		R			1/8" - 1/4"				W			
DISC SANDING	W	COARSE PAPER		E			1/4" - 3/8"				S			
		MEDIUM PAPER		DISC SAND			3/8" - 1/2"				O			
		FINE PAPER		K			1/2" - 5/8"				K			
	PLASTICS		F	5/8" - 3/4"					I					
	METAL		K	<b>L</b>	Up to 1/16"		MILD STEEL		FAST					
DRUM SANDING		WOOD AND PLASTICS			K		1/16" - 1/8"				U			
ROUTING							1/8" - 1/4"				L			
SHAPING		WOOD			ROUT-SHAPE		1/4" - 3/8"				G			
CARVING						3/8" - 1/2"				B				
MORTISING	SOFT WOOD		Q		<b>G</b>	Up to 1/8"		PLASTICS		FAST				
	HARD WOOD		L			1/8" - 1/4"		HARD RUBBER		S				
WIRE BRUSHING	COARSE	METAL				D	1/4" - 3/8"				L			
		WOOD (SCULPTURED EFFECTS)				L	3/8" - 1/2"				G			
	FINE	METAL				Q	1/2" - 5/8"				F			
BUFFING	HARD METAL		U	<b>L</b>		5/8" - 3/4"				A				
	SOFT METAL		S			<b>A</b>	Up to 2"		<b>W</b>	ROUGHING		C		
	PLASTICS		M				2" - 4"			SHAPING		N		
POLISHING (LAMBSWOOL)	HARD METAL		U				4" - 6"			FINISHING		T		
	SOFT METAL		S				6" - 8"			ROUGHING		B		
	PLASTICS		Q		8" - 10"		SHAPING			M				
JIG SAWING SABER SAWING	HARD METAL, BONE, PLASTICS		A		<b>T</b>		6" - 8"			<b>O</b>	FINISHING		Q	
	HARD WOOD, SOFT METAL		JIG SAW				8" - 10"				ROUGHING		SLOW	
	SOFT METAL, PLYWOOD, PRESSED WOOD		L				Over 10"				SHAPING		J	
JIG SAW FILING, SANDING	SOFT METAL		<b>S</b>				<b>U</b>	ROUGHING			<b>R</b>	FINISHING		SLOW
	HARD METAL			SHAPING				C						
	WOOD			FINISHING		D								
	PLASTICS			ROUGHING		SLOW								
CUTTING WITH ABRASIVE CUT-OFF WHEEL	HARD METAL		<b>I</b>	<b>N</b>		Up to 3"		<b>G</b>	ROUGHING			L		
	SOFT METAL					SHAPING			P					
PLASTICS		FINISHING				S								
GRINDING	METAL				ROUGHING				D					
	TOOL SHARPENING				SHAPING				F					
POWER HONING	TOOL SHARPENING				FINISHING				I					
PLUG CUTTING	WOOD				Q	<b>N</b>	Up to 3"		<b>P</b>	ROUGHING		SLOW		
DRILLING WITH TUBE	GLASS				SLOW		Over 3"			SHAPING		G		
										FINISHING		P		
							UP TO 2" WITH CARBIDE TIPPED TOOLS		NON-FERROUS METAL		ROUGHING	SLOW		
								SHAPING	G					
								FINISHING	P					