

Operational Speeds

OPERATION		MATERIAL		SPEEDIAL SETTING	OPERATION		MATERIAL		SPEEDIAL SETTING	
GENERAL SAWING		WOOD		R	D R I L L I N G	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		Up to 1/8"		SOFT METAL		FAST
JOINTING		WOOD		R		1/8" - 1/4"				W
DISC SANDING	WOOD	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	Up to 1/16"		MILD STEEL		FAST		
DRUM SANDING		WOOD AND PLASTICS		K		1/16" - 1/8"				U
ROUTING		WOOD		ROUT-SHAPE		1/8" - 1/4"				L
SHAPING						1/4" - 3/8"				G
CARVING						3/8" - 1/2"				B
MORTISING		SOFT WOOD		Q	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	5/8" - 3/4"				A	
		SOFT METAL		S	Up to 2"		W O O D	ROUGHING		C
		PLASTICS		M				SHAPING		N
POLISHING (LAMBSWOOL)		U	FINISHING					T		
JIG SAWING SABER SAWING		HARD METAL		U	2" - 4"			ROUGHING		B
		SOFT METAL		S				SHAPING		M
		PLASTICS		Q				FINISHING		Q
JIG SAW FILING, SANDING		HARD METAL, BONE, PLASTICS		A	4" - 6"			ROUGHING		SLOW
		HARD WOOD, SOFT METAL		JIG SAW				SHAPING		J
		SOFT METAL, PLYWOOD, PRESSED WOOD		L				FINISHING		M
JIG SAW FILING, SANDING		SOFT METAL		S L O W	6" - 8"			ROUGHING		SLOW
		HARD METAL					SHAPING		F	
		WOOD					FINISHING		J	
		PLASTICS					ROUGHING		SLOW	
CUTTING WITH ABRASIVE CUT-OFF WHEEL		HARD METAL		FOLLOW INSTRUCTIONS ON WHEEL OR PACKAGE	8" - 10"		SHAPING		C	
		SOFT METAL					FINISHING		D	
		PLASTICS					ROUGHING		SLOW	
GRINDING		METAL		SLOW	Over 10"		SHAPING			
POWER HONING		TOOL SHARPENING					FINISHING			
PLUG CUTTING		WOOD					Q	ROUGHING		L
DRILLING WITH TUBE		GLASS		SLOW	UP TO 2" WITH CARBIDE TIPPED TOOLS		SHAPING		P	
							FINISHING		P	