

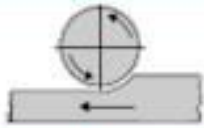
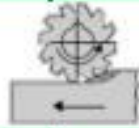



HempWood® Machining Guide

HempWood® can be machined on woodworking machines. Some operations can be carried out on metalworking machines.

Rule of thumb: Use well-sharpened tools and high cutting speed. The best performance is with carbide blades.

Cutting Speed	Feed Speed	Side Rake	Setting Angle	Material	Remarks
Sawing					For best performance use carbide coated blades
3000 – 4000 m/min	3.5 – 15 m/min	0-15 Degrees	0 - 15 Degrees	Hardened Steel	
Turning					High cutting speeds recommended
200 – 900 m/min	0.1 – 0.5 mm per rev	0-15 Degrees	5-15 Degrees	Hardened Steel	
Planing					Use standard wood working machines.
1000 – 2000 m/min	3 – 6 m/min	20 Degrees	5-20 Degrees	High Speed Steel	Carbide coated blades for best performance
Milling					High speed machines and tools with coarse pitch.
Up to 1000 m/min		5-15 Degrees	5-15 Degrees	Hardened Steel	Carbide tip for best performance
Drilling					For optimal results: fast spiral brad point drill bits; however, normal wood drills also functional
30-70 m/min	0.1 – 0.3 mm per rev			High Speed Steel	