






HEMPWOOD® MACHINING GUIDE

Cutting Speed	Feed Speed	Side Rake	Setting Angle	Material	Notes
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 m/min	0-15 degrees	5-15 degrees	Hardened steel	
Planing					Use standard wood working machines. Carbide coated blades for best performance.
1000-2000 m/min	3-6 m/min	20 m/min	5-20m/min	High speed steel	
Milling					High speed machines and tools with course pitch. Carbide tip for best performance.
Up to 1000 m/min		5-15 m/min	5-15 m/min	3.5-15 m/min	
Drilling					For optimal results: fast spiral brad point drill bits; however, normal wood drills also functional
30-70 m/min	0.1-3.0 m/min			High speed steel	