

Machining and sanding

Machining

- **Tungsten-carbide** tool edges provide the best results at feed-speeds of 12 metres per minute (m/min).
- Tools made from **cobalt-base alloys** strengthened with tungsten and molybdenum (known as stellite alloys) give a better quality result at higher speeds, such as 24 m/min.
- **For mouldings**, lower feed speeds are recommended to reduce the risk of torn grain and soft tissue roughness, which are more likely at higher feed-speeds.
- **When profiling**, for example when producing a tongue and grooved profile, lower feed speeds are recommended. Tear-out occurs where bundles meet the surface at an angle rather than align parallel to the surface.
- If the material is **prone to grain or soft tissue roughness**, use lower feed speeds.
- **Cross-cutting** negative cutting angle blades and positive cutting angle blades also provide good results.
- **Rip sawing** straight blades provided a better result than bevelled blades, where the board is cut longitudinally. Straight blades produce fewer splinters and tear-out.

Sanding

Cocowood can be sanded to a smooth finish at a range of speeds, although better results are achieved at a speed of 12 m/min than at 18 m/min.

