



Sanding Speed Guide

Wood, lacquer, processed wood boards, mineral fiber boards and melamine			
Narrow Belts	min	Cutting Speed v_c (m/s)	max
		Recommendation	
Solid wood, hard	10	20	24
Solid wood, soft	10	12	24
Veneer			
- Lever stroke sanders	10	12	20
- Edge sanders	6	10	12
- Profile sanders	6	8	12
Lacquer, general	4	8	12
- Nitro cellulose	2	4	8
- Polyester, clear	6	8	12
- Polyester, pigmented	6	10	12
- PU	4	8	12
- Acrylic, pigmented	8	10	12
- Acid cured lacquer	6	8	12

Wood, lacquer, processed wood boards, mineral fiber boards and melamine			
Wide Belts	min	Cutting Speed v_c (m/s)	max
		Recommendation	
Solid wood	12	20	24
Veneer	10	20	24
Plywood	10	20	24
Filler	6	8	10
Lacquer	2	6	12
Particle board/MDF	12	22	36
Mineral fiber boards	12	22	26
Melamine	8	12	20

The above recommendations are a guide only. Individual requirements may vary.
Please contact your Sales Representative for tailored advice to suit your sanding requirements.



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Metal			
Narrow & Wide Belts	Cutting Speed v_c (m/s)		
	min	Recommendation	max
Carbon steel	29	35	39
Tool steel (forging parts)	20	30	30
Stainless steel	20	30	30
Grey cast iron	30	35	40
Brass and bronze	27	35	37
CrNi-base alloy	16	22	28
Aluminium, Al-alloy	28	35	40
Titan (dry grinding)	4	8	12
Titan (wet grinding)	10	12	15

Glass, china, ceramics, leather, rubber, cork, felt, plastic			
Narrow & Wide Belts	Cutting Speed v_c (m/s)		
	min	Recommendation	max
Glass	8	13	18
Crystal-glass (lead glass)	15	20	25
China, ceramics	10	13	17
Leather, rubber, cork, felt	20	25	30
Plastics			
- Duroplastic	18	22	26
- Plastic (dry grinding)	6	10	12
- Plastic (wet grinding)	8	15	18

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