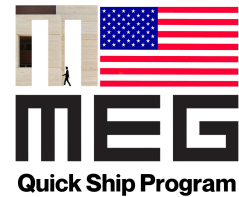


FACTORY PROCESSING GUIDELINES



Beam Saw

Boom Pressure	Feed Speed	RPM	Hook	Teeth	Type
8 Bars	29 m/m	3,600	+15°	72	TCG Triple Chip Grind

CNC Guidelines Recommended Speeds

Stonewood panels can be fabricated with computerized numeric control (CNC) machines.

Panel Thickness	Cutter Speed	Feed Speed	Comments
8, 10, 13mm	14,000–18,000 rpm	2.54–3.81 m/m 100–150 in/min	Cutter and feed speed vary by thickness and suitable finish results

The above recommendations must be monitored throughout the fabrication process to ensure optimal results.

CNC Drilling

Diameter Inch	Revolutions	Feed
1/4 - 3/8"	4,000–5,000 /min	50 in/min

Chamfer

- Panels arrive with .015" chamfer edge
- Factory cut edges **MUST** be re-chamfered to .015"
- Use 45° bit Hand Router test with scrap piece to set and test router depth to match factory chamfer