

Recommendation for HOMAG Sanding Machines



Hints from Professionals to Professionals!

Material to be sanded:	Hardwood	Softwood	Wood based material	Softwood veneer	Hardwood veneer large-pored	Hardwood veneer fine-pored	MDF fine sanding	Filler	Filler	High gloss lacquer	High gloss lacquer	PU lacquer	Waterborne lacquer	UV lacquer	
Abrasive belt type: (Hermes Abrasives Examples)															
	BW110	BW110 / BW114	BW110 / BW114	BW110	BW110	BW110	BS118	BW114	BW114	BS119LL / BW114	FB 637	BS119LL	BS119LL	BS119LL	
Abrasive belt speed Vc m/s	18	18	18	10 - 18	13 - 18	13 - 18	15 - 18	2 - 6	2 - 6	2 - 8	2 - 8	2 - 6	2 - 4	2 - 6	
Feed speed Vf m/min	3 - 5	4 - 6	3 - 5	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	8 - 10	
Stock removal in mm	0,6 - 0,7	0,7 - 0,9	0,6 - 0,7	0,05 - 0,10	0,05 - 0,10	0,05 - 0,10	0,05 - 0,10	0,04 - 0,07	0,04 - 0,07	0,02 - 0,05	0,02 - 0,05	0,02 - 0,05	0,02 - 0,05	0,02 - 0,05	
Recommended grit sizes	60 - 80	60 - 80	60 - 80	120 - 180	120 - 180	150 - 240	220 - 240	280 - 400	320 - 600	400 - 600	600 - 2200	320 - 400	320 - 400	280 - 400	
Abrasive grit type	Aluminium oxide	Aluminium oxide	Aluminium oxide	Aluminium oxide (Silicon carbide)	Aluminium oxide	Aluminium oxide	Silicon carbide	Aluminium oxide	Aluminium oxide	Silicon carbide	Silicon carbide	Silicon carbide	Silicon carbide	Silicon carbide	
Sanding insert density	---	---	---	0,52 / 0,68	0,52 / 0,68	0,52 / 0,68	0,52 / 0,68	0,52	0,52	0,36 / 0,52	0,36 / 0,52	0,36 / 0,52	0,36 / 0,52	0,36 / 0,52	
AGGREGATE	Calibration			Fine sanding				Intermediate lacquer sanding (requires lacquer sanding specification)							
R	✓	✓	✓	—	—	—	—	—	—	—	—	—	—	—	
C/L	✓	✓	✓	✓	✓	✓	✓	✓	—	✓	—	✓	✓	✓	
X	✓	✓	✓	✓	✓	✓	✓	✓	—	✓	—	✓	✓	✓	
H	—	—	—	✓	✓	✓	✓	✓	—	✓	—	✓	✓	✓	
Q	—	—	—	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
E/F	—	—	—	✓	✓	✓	✓	✓	—	✓	—	✓	✓	✓	