

RECOMMENDED KNIFE MARKS PER INCH

Knife finish ranges are generally recommended according to wood species:

Wood	Knife Marks Per Inch
Ash	11 to 14
Basswood	8 to 12
Beech	12 to 14
Birch	12 to 14
Cedar	13 to 16
Cherry	8 to 12
Chestnut	12 to 14
Cottonwood	8 to 12
Cypress	8 to 12
Elm, Hard	10 to 13
Fir	8 to 12
Gum Hemlock	9 to 13
Hickory	8 to 12
Mahogany	12 to 15
Maple	12 to 14
Oak	14 to 16
Oak Qtd.	12 to 14
Pine, Yellow	12 to 14
Pine, White	9 to 13
Pine, Ponderosa	9 to 13
Poplar	9 to 13
Redwood	8 to 12
Spruce	8 to 12
Sycamore	11 to 14
Walnut	12 to 14

*To find your knife marks per inch, use this formula:
Multiply the number of knives (Z) by the spindle speed
(RPM) and then divide by the feed rate expressed in
inches per minute.*

$$Z \times \text{RPM} \div \text{in/min} = \text{knife marks per inch}$$