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
The Effect of Planning and Sanding on Surface Roughness of Massive Wood

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Abstract: In this study the effects of wood species cutting direction, number of blades, sander grade and feed rate on the surface roughness of planned and sanded massive wood have been investigated. Choses wood species were beech (*Fagus orientalis* Lipsky) and yellow pine (*Pinus Sylvestris* L.) which are mostly used in furniture and carpentry industry in Turkey. "MITUTOYA SURFEST-402" (KOSGEB, Ankara, TURKEY) stylus scanner machine was used to evaluate the surface roughness. Fourty eight samples were performed and each sample was divided in to 8 equal region. Two measurements were performed perpendicular to fibers along the length of 20 mm. Sample length was taken 2,5 mm and the roughness values were determined at a sensitivity level of $\pm 0,01 \mu\text{m}$. More smooth surfaces (low roughness) were obtained in the tangential direction to annuals rings in both species. At the species level, low roughness values were observed in beech compared wiht pine. Surface roughness decreased with increasing number fo blades in planning, and with increasing number of sander grade in sanding. On the other hand, roughness increased with increasing feed rate.

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