crystals

MDPI

Supplementary Materials

Nanocellulose Bulk Material Prepared by Steam Treatment and Hot Press Molding: Material Processing and Machining Test

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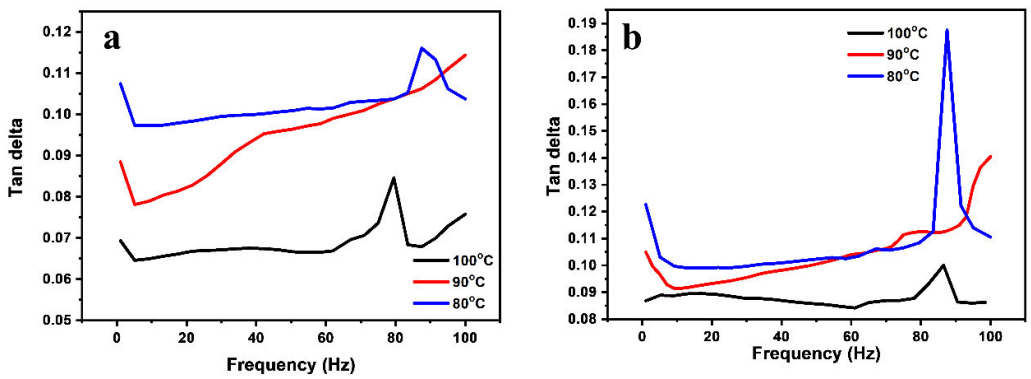

Figure S1. Frequency dependent Tan δ results: (**a**) non-steam processed bulk materials and (**b**) steam processed bulk materials fabricated at 80, 90 and 100 °C, respectively.

Table S1. Results of the machining of NC bulk materials with various conditions.

Feed Speed (mm/s)	Spindle Speed (RPM)	R_a (μm)				Max. Temp. Rise (°C)
		Top	Mid.	Bot.	Aver.	
0.32	4000	1.212	1.465	1.796	1.491 ±0.293	33.4
0.63	4000	1.974	1.495	1.863	1.777 ±0.251	34.3
1.25	1200	1.343	1.558	1.315	1.405 ±0.133	46.4
	2560	1.238	1.436	1.231	1.302 ±0.116	51.5
	4000	0.724	0.892	0.929	0.848 ±0.109	56.5
3.12	1200	2.915	3.329	3.240	3.161 ±0.218	53.8
	2560	1.622	1.361	1.267	1.417	55.4

					±0.184	
	4000	1.210	1.184	0.940	1.111 ±0.149	55.8
5.00	1200	3.968	3.828	3.072	3.623 ±0.482	40.8
	2560	2.351	2.268	1.714	2.111 ±0.346	43.8
	4000	2.263	2.223	1.947	2.144 ±0.172	53.3