

Grinding Manual



Sash Pro (T.C.T. Saw Blade)

Stable Saw Blade (T.C.T. Saw Blade)

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Flank grinding

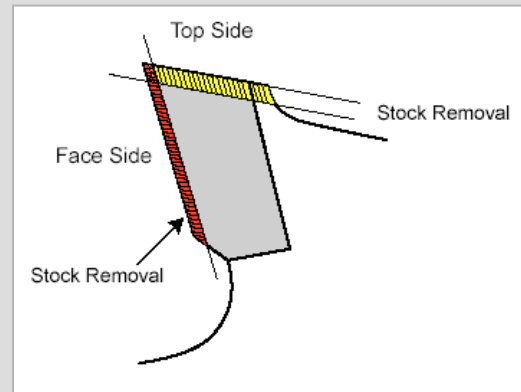
Grinding Wheel: SDC200P125BMD16
Wheel feed speed: 1.7mm/sec.
Stock removal: 0.5mm

Face grinding

Grinding Wheel: SDC325N85PBC55-1.0
Wheel feed speed: 1.0mm/sec.
Stock removal: 0.05-0.5mm

Top grinding

Grinding Wheel: SDC 200/600 N 100 DT 15-7.2
Wheel feed speed: 1.2mm/sec.
Stock removal: 0.1-0.5mm



General Comments and Recommendations

- Wet grinding, oil or water, is self-evident
- Make sure not to change the tooth angles (angles are mentioned on our saw blade and box)
- Make sure to remove all wear, only a sharp edge delivers a good cut quality and long edge life
- Interpretation of grinding wheel specifications can be found at www.asahi.co.jp or contact Kanefusa

Conversation Table Mesh - FEPA

Mesh:	170	200	230	270	325	400	600	1000	1500
FEPA:	D91	D76	D64	D54	D46	M40	M25	M16	M10