

Re-sharpening manual for “SF saw blade”

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1. Notice

The coating processing has been done to this “SF saw blade”.

Therefore, the method of the re-sharpening is also different from the past, and the performance is not demonstrated enough if it does not follow this instruction manual.

2. A point of difference

	“ SF saw blade”	Usual saw blade
A part of re-sharpening	Just face	Face and top
Order of re-sharpening	1. Face grinding Notice: Do not grind the top.	1. Face grinding 2. Top grinding
Grinding wheel	We recommend our original. SD400K115/800J100BPF We can deliver to you.	Normal
Grinding machine	Vollmer CHC, CHP	Vollmer CHC, CHP

3. Method of re-sharpening

1) Clean the saw blades before re-sharpening carefully.

Caution: Do not use an iron brush (the coating will be damaged).

2) Please prepare our recommended wheel.

Our recommended wheel is only for coated saw blade. (SD400K115/800J100BPF)

An accurate re-sharpening becomes possible by using this.

An enough performance cannot be demonstrated by causing trouble on the coating surface when re-sharpening with the usual grinding wheel.

3) Grinding depth is 0.2mm

It is 0.2mm generally good though the amount of the grinding depends on the use state.

4) The feeding speed is 1/2 against the past.

r.p.m of grinding wheel is same as usual condition.

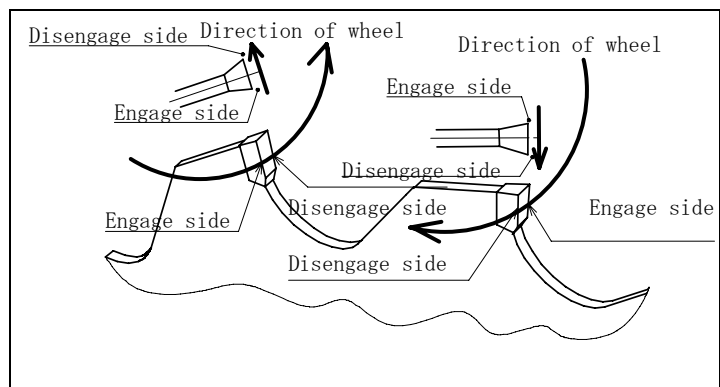
However, feeding speed of wheel reduce 1/2 against usual condition, if it is possible.

0.7mm/sec is recommended.

5) Direction of wheel rotates

Please make each 1 tooth an alternation (normal rotation and reversal) and grind as shown in a right picture.

The re-sharpening quality improves considerably by doing so.



6) Please give the grinding coolant enough on the grinding point.

The grinding crack is generated easily by the grinding scorch when the grinding liquid is insufficient. And, the chipping is occurred, and cutting life decreases.

7) State after re-sharpening

Please grind so that face may become a straight line. If the grinding wheel stops on the way, an excellent cutting quality is not obtained.

