

Grinding Manual



ECO Saw Blade (T.C.T. Saw Blade)

A New Dimension of Performance

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Number of pages: 1

Top grinding

Grinding Wheel: SDC 200/600 N 100 DT 15-7.2

Wheel feed speed 1.2 mm/sec.

Stock removal 0.1-0.3 mm

Face grinding

Grinding Wheel:

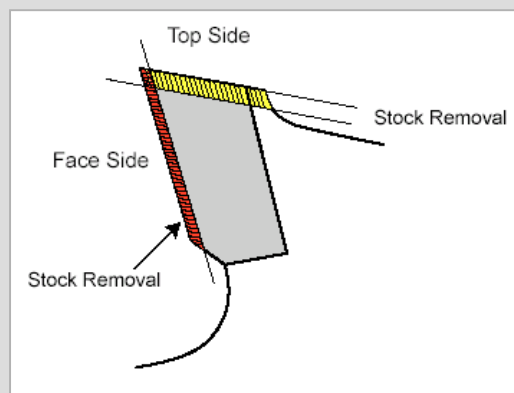
SDC 140 N 125 BA41
(drill type, 6 mm diameter)

Wheel feed speed:

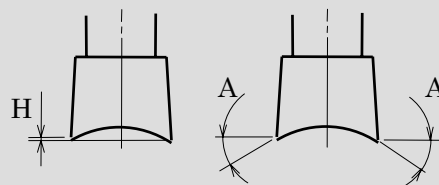
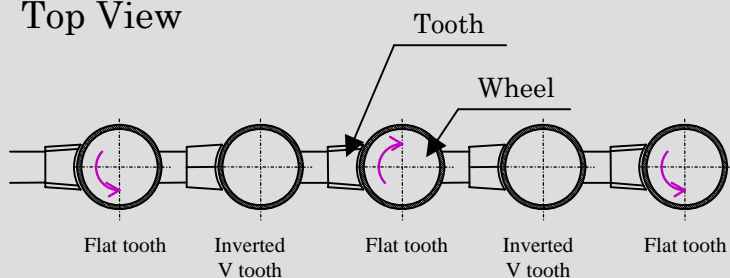
1.0 mm/sec.

Stock removal:

0.1-0.2 mm



Top View



For best performance we recommend to alternate the direction of rotation of the grinding wheel at for the flat teeth

- The difference H shown in the figure above should not exceed 0.05mm
- The difference in of the angle A should not exceed 2 degrees.

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
- Make sure to recess the gullet area and the back of the tooth
- Interpretation of grinding wheel specifications can be found at www.asahi.co.jp or contact Kanefusa

For further information, please contact Kanefusa or a dealer in your area. All contact addresses are listed on our website or email to our Headquarter at sales-ex@kanefusa.co.jp