

# Grinding Manual

KANEFUSA

## SF-Saw Blade (HC-UP tipped Saw Blade)

A New Dimension of Performance

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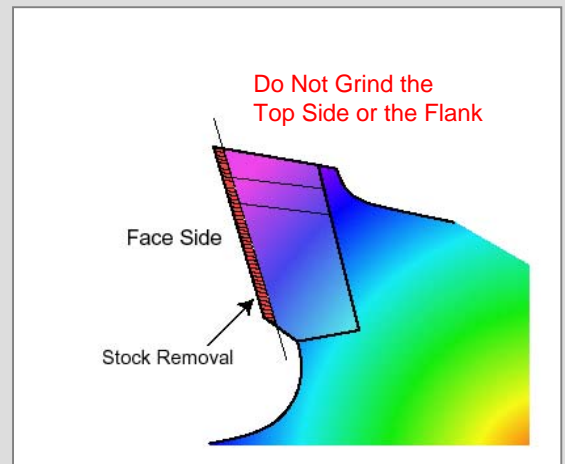
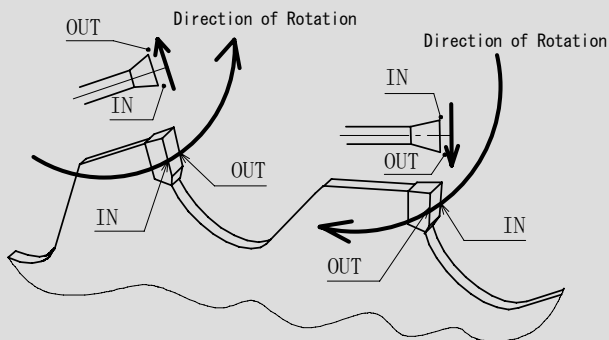


### Top grinding

**Do not sharpen the top and the flank of the SF-Saw Blade**

### Face grinding

Grinding Wheel: SD800N100BPF1.5  
Wheel feed speed: 0.7 mm/sec.  
Stock removal: 0.05-0.5mm



For best tool life we recommend to change the direction of rotation on any other tooth.

### 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
- Interpretation of grinding wheel specifications can be found at [www.asahi.co.jp](http://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

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](mailto:sales-ex@kanefusa.co.jp)

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