

# Grinding Manual

KANEFUSA  
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**Timber Max** (T.C.T. Saw Blade)

**Yield Pro** (T.C.T. Saw Blade)

A New Dimension of Performance

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## Flank grinding

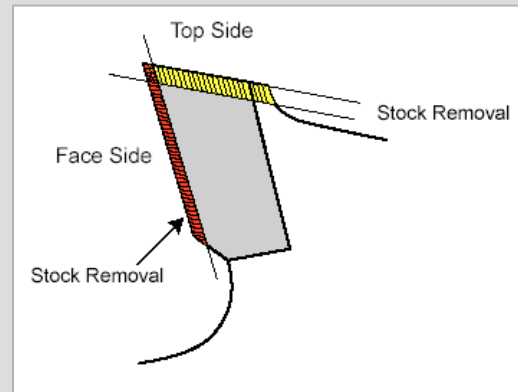
Grinding Wheel: SDC200P125BMD16  
Wheel feed speed: 1.7mm/sec.  
Stock removal: 0.5mm

## 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
- 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](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)