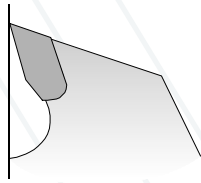
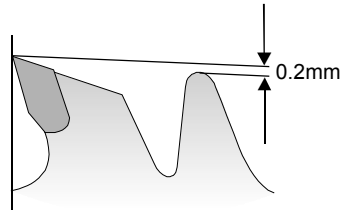


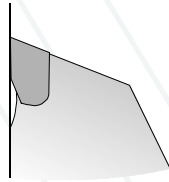
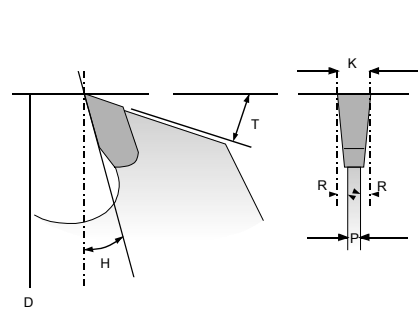
## TOOTH GEOMETRY



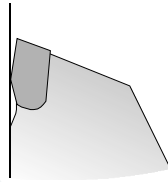
**POSITIVE HOOK**



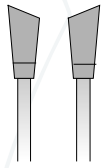
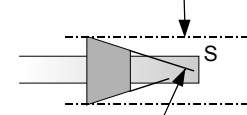
**ANTI KICK BACK**



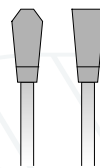
**NEUTRAL HOOK**



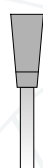
**NEGATIVE HOOK**



**ALTERNATE BEVEL (ATB)**

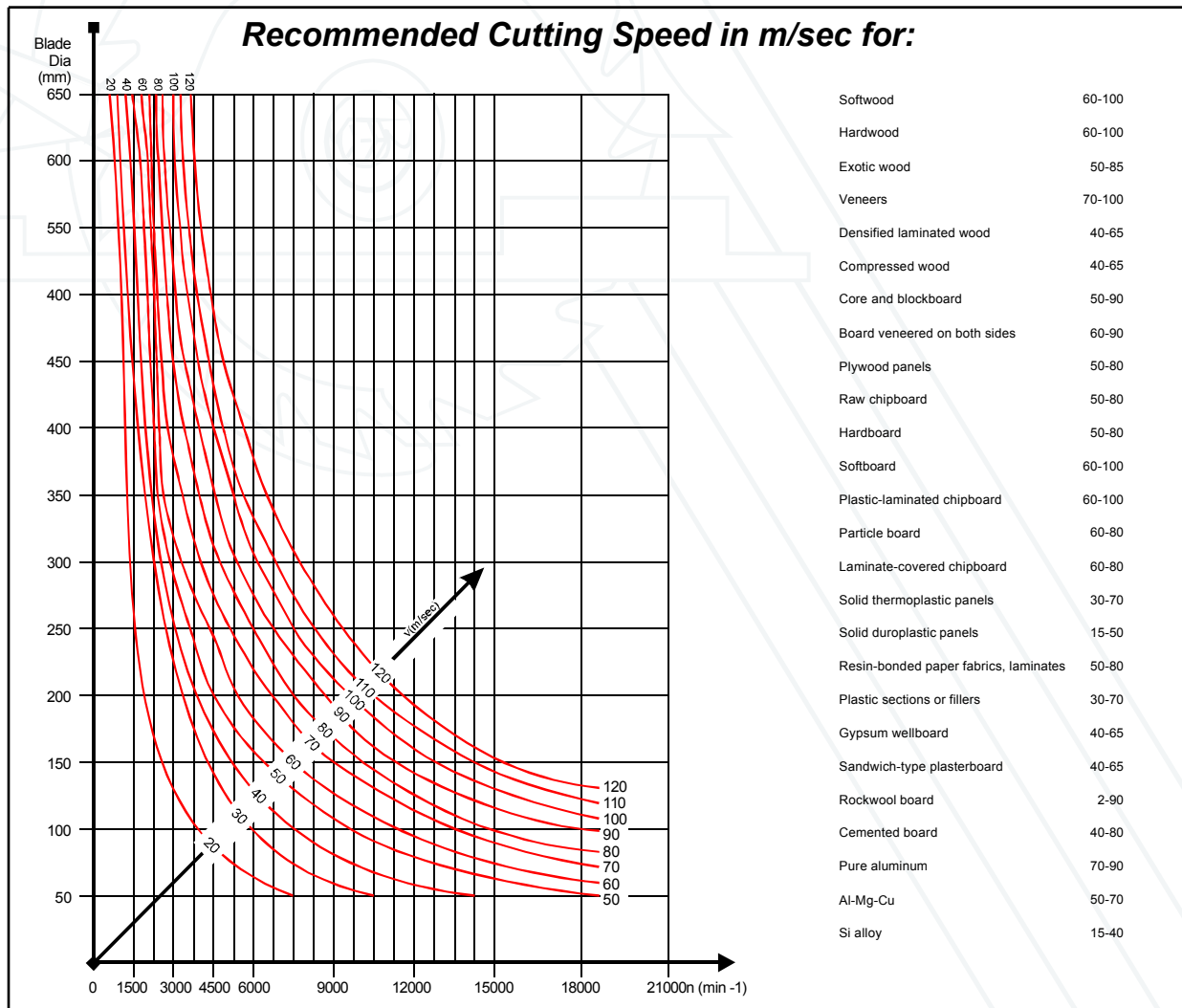


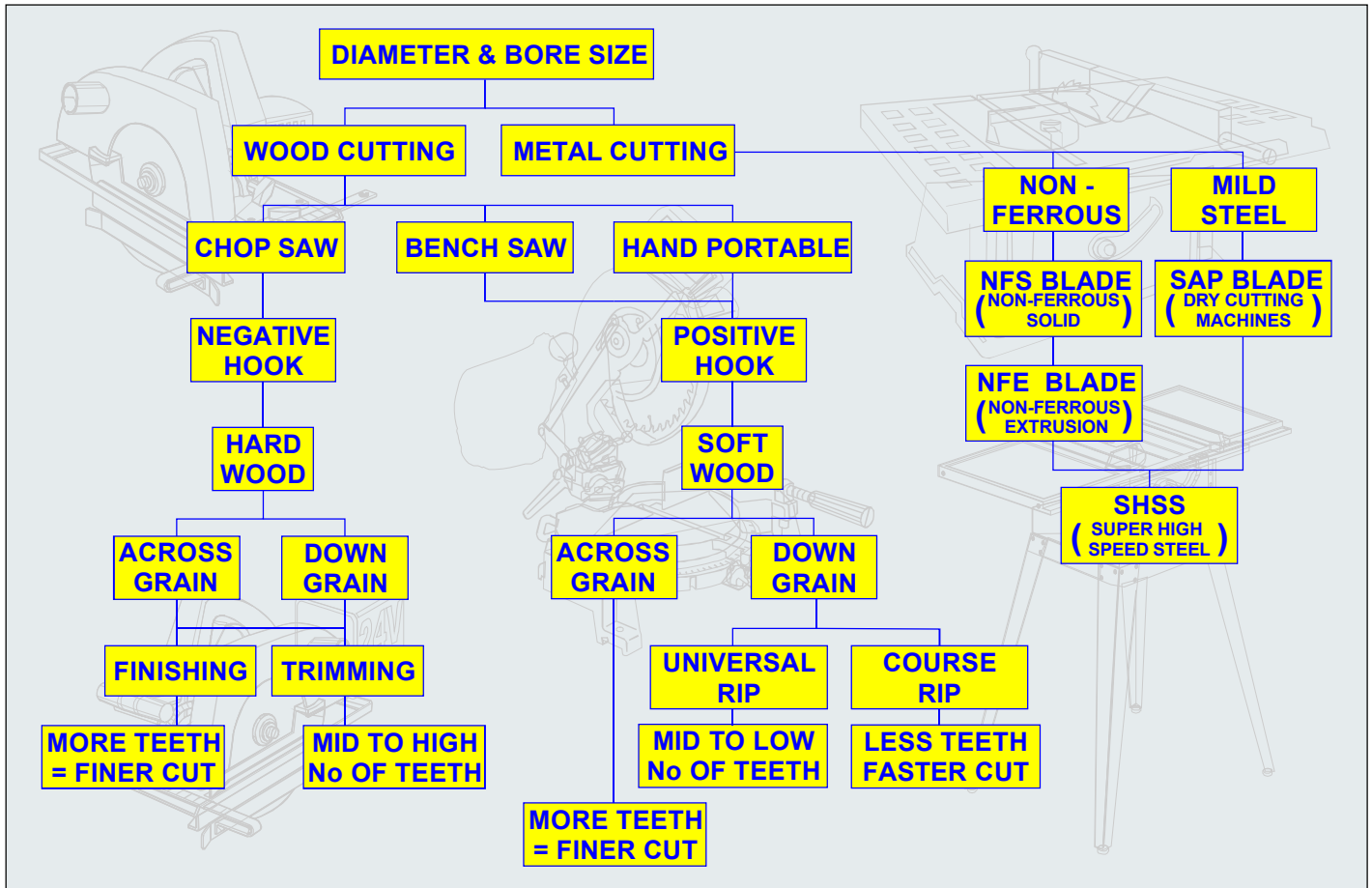
**TRIPLE CHIP (TC) OR TRAPEZOIDAL**



**STRAIGHT OR FLAT**

- P = Plate thickness**
- K = Kerf**
- H = Tooth Angle (Hook)**
- T = Top Clearance Angle**
- S = Side Angle Clearance**
- D = Diameter**
- R = Radial Clearance Angle**





## CHOOSING THE CORRECT SAW BLADE

The following information will help you purchase the correct saw blade for your machine and the materials that you are cutting.

**HOOK / RAKE** The steeper the hook angle the more aggressive the cut - i.e. It bites into the material more.

Wood cutting on portable and table saws typically requires a positive hook.

Negative hook gives resistance to feed so will not climb into the cut, this avoids “grabbing”. Ideal for cutting from above e.g. Radial Arm Saw and Mitre Saw as it pushes work piece onto the work surface.

**Standard Alternate Top Bevel (ATB)** blades are most common for wood cutting. Suitable for all types of cut,

**RIP,** Cutting with the grain (lengthways in lumber).

**CROSS,** Cutting across the grain (across lumber).

**FINE,** To get a fine finish.

**TRIPLE CHIP or TRAPEZOIDAL (TC)** blades are good for cutting plastics. When combined with negative hook they can be used for aluminum cutting and other non-ferrous metals. This type of grinding breaks the chip up which gives better swarf clearance.

### **SUGGESTIONS BEFORE MOUNTING BLADE ON MACHINE**

- 1 Be sure your machine is in perfect condition and free from end and bearing play.
- 2 Saw blade must run true on mandrel and in perfect line with fence or saw guide.
- 3 Make sure that flanges are clean and flat and blade is securely held on arbor.
- 4 Keep blade clean - free of gum, this will prevent overheating or burning of the blade body and ensure longer blade life and freer cutting.
- 5 As carbide tips are extremely hard they are also very brittle and should not be subjected to sharp blows from other hard objects. Always exercise care when handling your blade.

### **CARE AND USE OF CARBIDE TIPPED SAW BLADES.**

A general rule that should be kept in mind when cutting with carbide tipped saw blades is that the more teeth on the saw blade the smoother the finish.

When absolute splinter free cutting is desired on veneer or thin plywood, use a piece of scrap wood below the wood being cut this will support the veneer / plywood as close as possible to the edge of the saw tooth.

Transparent tape along the cutting edge where the blade leaves the material will eliminate some splintering.

Make sure collars of the blade are free from dirt and debris.

Always use a push stick on the work piece when using a saw bench.