

## Grinding Wheels for HSS Circular Saw Blades

### Introduction

HSS(high speed steel) circular saw blades are used for cutting metal and non-metal materials. The grinding process consists of tothing, sharpening, chamfering, grinding of chipbreaker slots. Good grinding wheel plays an very important role in saw blade's quality.

### Application

Used for manufacturing new HSS circular saw blades and re-sharpening used HSS circular saw blades, on Loroch, Weinig, Schneeberger, UT.MA, Walter, Wadkin, Foley, SCMI, United, Tigra, Andi, Tempo, Nielson machines etc.

### Features

Excellent self-sharpness, no burning, perfect surface finish, higher cut rate, better form retention, long using life, excellent accuracy.

### Case

Machine: Loroch

Wheel: 14F1 200 x 8 x 32 x 2 x 6 CBN150

Workpiece: HSS circular saw blade 300mm

Wheel speed: 60m/s

Coolant: Oil

Feed rate: 12 teeth/min



Tooth grinding wheel



Chipbreaker grinding wheel