

Somma Tool Company INC.

CUTTING TOOLS • TOOL HOLDERS • WORK HOLDERS • & ACCESSORIES FOR SCREW MACHINES, SWISS, & CNC LATHES

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Resharpener Instructions for Saberloy H.S.S. Cut-Off Blades

Saberloy is a proprietary steel used for its superior cutting performance. To maintain this superior performance, we recommend the following resharpener procedure.

- Use side of the wheel to resharpen, not the periphery.
- Do not let the edge get too hot.
- Do not allow the edge to air cool - quench often while grinding.
- Wet surface grinding is preferred over dry grinding such as on a pedestal grinder.
- The front angle should not exceed more than 2° more than the rake angle.

Grinding Wheel Suggestions:

- Ideally a regrind should be no more than .025" of length. If more is needed to remove a large chip, rough-in on a wet grinder using a soft 46 grit wheel (for example: WA46 J8 V1)
- We recommend a vitrified wheel (Norton grade **38A60-JVBE-11V9**) Flare Cup Wheel for good stock removal with a finish that should be acceptable for most applications.
- For a fine finish, we recommend a CBN wheel (Radiac# **CBN150R100BO**) 1/8" 11v9 5" x 1-3/4" flare cup style.