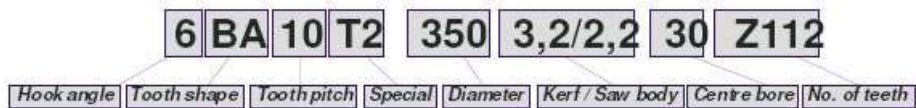


SWEDEX TYPE CODES EXPLAINED

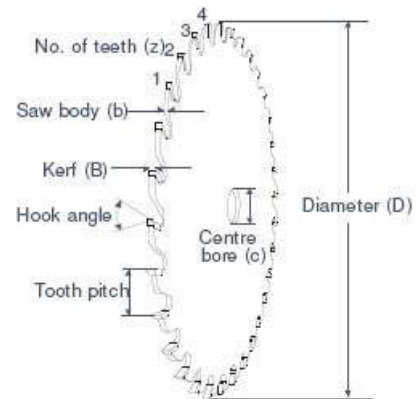
Code system



Swedex code system specifies the composition of the saw blade

- First the hook angle is specified, in this example 6 degrees.
- Negative hook angle is indicated by N, e.g. N2.
- Tooth shape is specified by two or three letters.
- Tooth pitch is the distance between two adjacent teeth.
- Special indicates different features of the saw blade, e.g. T2 states that the saw blade has smaller kerf and SP states that it is a special saw blade.
- Thereafter the diameter is specified (in mm like the other measures).
- Kerf is the width of the TCT tooth.
- Saw body is the thickness of the steel body.
- The centre bore is specified with the general tolerance H7
- No. of teeth is always written after the letter z.

In this catalogue we use the following abbreviations: diameter (D), kerf (B), saw body (b), centre bore (c), no. of teeth (z), wiper slots (RS)



HOOK ANGLE

The hook angle depends on the material, type of cutting and machine type. Some general hook angles for a range of materials are shown below.

Negative 5-10° - crosscutting of wood in pendulum and parallel saws, edge band cutting and trimmer machines using with feed.



Negative 2-5° - cutting of metals with manual feed, plastics and laminates.



6-10° - crosscutting of wood, hard plastics and veneered and laminated boards. Metal sawing with automatic feed.



5-15° - crosscutting of wood. Panel sizing of chipboards, plastics, plywood and veneered boards.



22° - ripping of dry or green wood.



25-30° - ripping and edging of green wood.

TOOTH SHAPE

Tooth shape indicates what kind of top grinding the saw blade has. Here the most common types are shown. Although there are several other types and combinations than the ones listed below.

AA. Straight teeth

For ripping wood, including multirip sawing. Can be used with high feed speeds where an average surface finish is required.



BA. Alternately beveled teeth

For ripping and crosscutting wood. Panel size sawing, e.g. of plywood. Gives good finish.



BAE. Alternately beveled teeth with chamfer

For sawing of thin and hard plastics.



CA. Right hand beveled teeth

DA. Left hand beveled teeth

All teeth are beveled in the same direction. Gives good finish. Used for pre-sawing, scribing, tenoning, and panel sizing.



EA. Trapezoidal teeth

Roughing and finishing teeth. For sawing of coated and non-coated woodblocks e.g. chip-, fibre-, MDF- and HDF-boards. Also suitable for plastic and laminated boards.



EAM. Trapezoidal teeth

EAM for sawing of metal.

RA. Straight teeth with conical sides

Used as a scribing saw blade when fractioning boards, prior to panel sizing.



RABA. Alternately beveled teeth with conical sides

EAXH. Alternately straight and inverted V tooth, with hollow ground front

For sawing of varnished and coated boards.

