

Resharpener Instructions

for saw blades with trapezoidal grind, series 281, 282 and 295

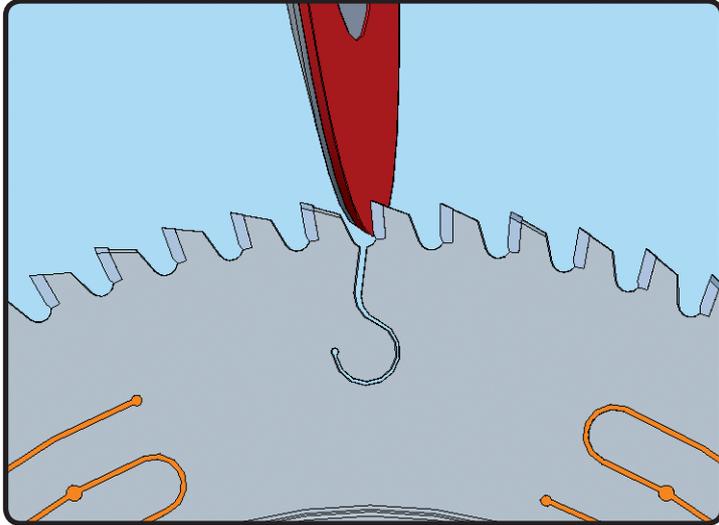
The blades must be sharpened as soon as they become dull, maintaining the original tooth angles.

Carry your saw blades in the original box and handle with care.

Always use the correct grinding wheels and plenty of cooling liquid for sharpening.

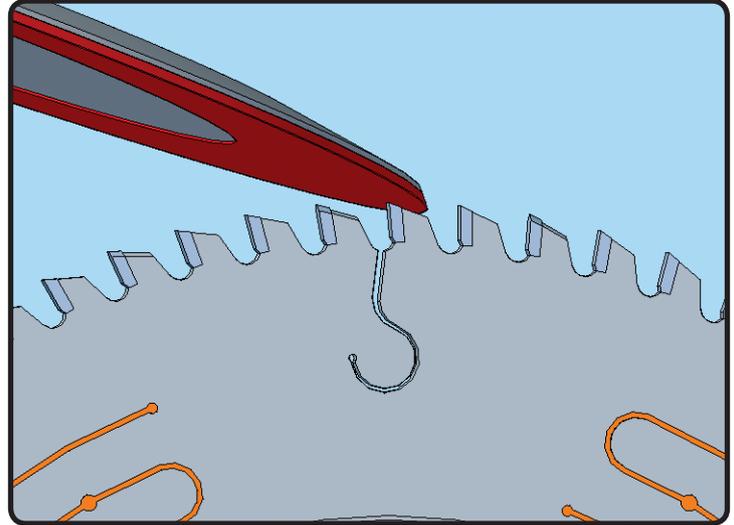
Before sharpening clean the blades using the CMT Cleaner, Formula 2050 in order to remove resin and glue on the blade body.

NEVER GRIND THE SIDE OF THE TEETH!



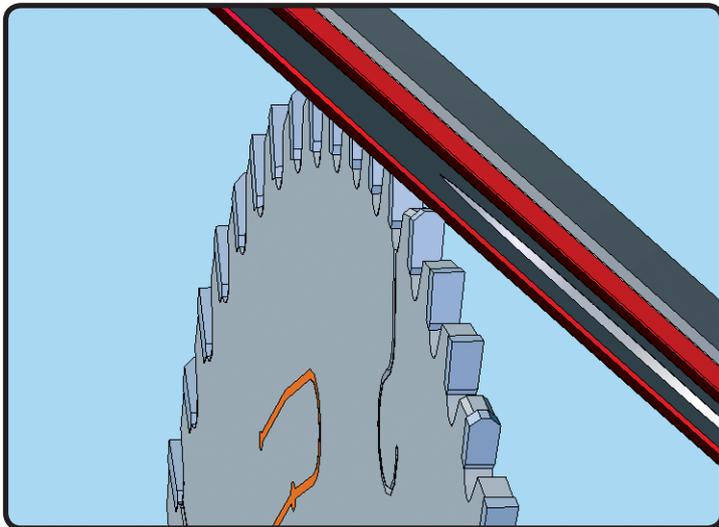
STEP 1. HOOK ANGLE (FACE)

Wheel Rotation: Rpm 3000
Tickness removal: 0.10mm
Feed speed: 4mm/sec
Diamond wheel type: D46 | 125 | K850 RA
Always grind in one direction from top to bottom (never from bottom to top)



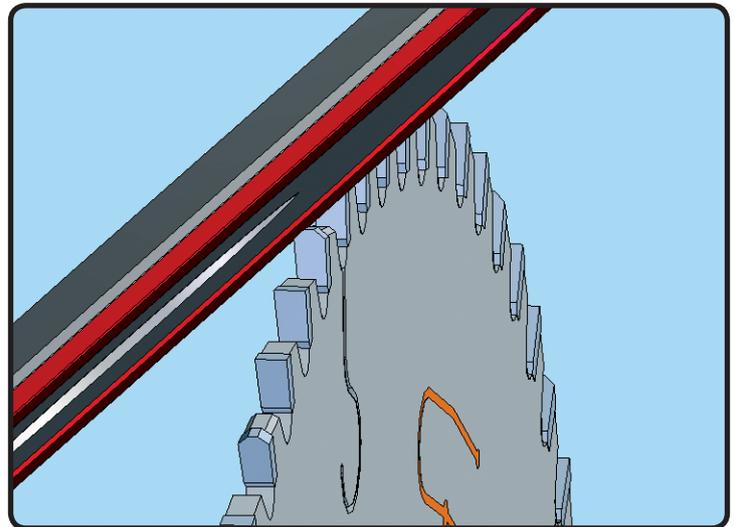
STEP 2. BACK CLEARANCE ANGLE (TOP FLAT)

Wheel Rotation: Rpm 3000
Tickness removal: 0.10mm
Feed speed max: 4mm/sec
Diamond wheel type: D126/D54 | 125/75K | 450RA



STEP 3. BACK CLEARANCE ANGLE (TOP, RIGHT CHAMFER)

Wheel Rotation: Rpm 3000
Tickness removal: 0.10mm
Feed speed max: 4mm/sec
Diamond wheel type: D126/D54 | 125/75K | 450RA



STEP 4. BACK CLEARANCE ANGLE (TOP, LEFT CHAMFER)

Wheel Rotation: Rpm 3000
Tickness removal: 0.10mm
Feed speed max: 4mm/sec
Diamond wheel type: D126/D54 | 125/75K | 450RA

Drawings are not to scale.

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