# STANDARD TOP GRINDS

**Blade Type:** Astra Wood, Biscuit Cutter (LAM), General Purpose (GP), Radial Overarm (RO), Std Purpose (SP), Special Purpose (SPE), Thin Kerf (TK), Thin Rim (TR)

**Alternate Top Bevel - ATB**

Each tooth has top bevel typically between 10 and 20 degrees. Two (2) teeth are required to provide a full kerf cut. Provides low cutting pressures which reduce material tearing during the cutting process and provides a fine cutting finish. Best performance cross cutting.

**Blade Type:** Double Face Laminate (DFL), Panel Saws (metric sizes)

**High Alternate Top Bevel - Hi ATB**

Identical configuration to ATB, but each tooth has top bevel of 30 degrees or more. The greater angle can cause faster wearing/dulling. Combine with Micro-5 carbide to increase time between sharpenings. Ideal for cutting of laminated materials. Provides a fine cutting finish with proper sharpening. An Alternate Face Bevel (AFB) can be added to this design upon request.

**Blade Type:** Plastic Cutting (PC), Solid Surface (DFLC)

**Beveled Alternate Top - BAT**

Similar to ATB tooth form but with chamfered high point. Option for cutting plastic materials to provide improved surface finish.

**Blade Type:** Astra Miter (ASMT), Combination (CBS), Double Face Veneer (DFV), Miter (MT)

**Alternate with Raker - AR**

Similar configuration to ATB, but every fifth (5th) tooth is a raker which assist is reducing cutting pressure and material tearing during cutting. Can be used for rip cutting and cross cutting in a variety of hard woods, soft woods, plywood and chipboard. This tooth configuration can be produced in a 2+1 or 3+1 design upon request.

**Blade Type:** Heavy Duty (HD), Groovers (GRO), Scoring Saws (Conic & Split), Slotting Cutters (EGS)

**Straight Top Grind - STR**

Each tooth will cut full kerf making this design very effective for removing material however high cutting pressures are present. Typically used for rip cutting hardwood and softwood.

**Blade Type:** Astra Non Ferrous (ASNF), Astra Panel Saws, Glue Line Rip (GL), General Purpose (GP), Non Ferrous (NF), Std Purpose (SP), Special Purpose (SPE), Thin Kerf (TK), Thin Rim (TR)

**Triple Chip Grind - TCG**

This design uses a trapezoidal tooth with 45 deg bevel on each side which performs the cutting work followed by a lower, STR tooth (raker) tooth for clean-out. Strong tooth design for cutting harder materials such as manmade laminates (single sided) and non-ferrous materials. Can be used for rip cutting and cross cutting.

**Blade Type:** Counter Top (CT), Double Face Laminate (DFL), Plex Cut (PC), Solid Surface (DFLC)

**Modified Triple Chip Grind - TC45**

This design starts with TCG configuration, but the STR (raker) tooth has small 45 degree chamfer. The addition of this chamfer, along with special clearances, provides the best possible finish on double face laminate and solid surface materials. This design provides good service life with excellent surface finish on table saws and radial arm saws.

**Blade Type:** Non Ferrous (NF)

**Triple Chip Precision Grind - TCPG**

Three-tooth pattern for cutting non-ferrous materials such as thick plate. Provides improved surface finish.

**Blade Type:** Nail Cutting (NL)

**Uniform Triple Chip Grind - UNI-TCG**

This variant of the TCG grind provides a very strong tooth shape that is less prone to chipping and is common in the pallet industry.


**Blade Type:** Double Cut Off (DCO)

**4 + 1**

Four (4) ATB teeth are followed by one (1) ATB with bevel in opposite direction. Used for Double Cut Off machines where Left Hand (LH) and Right Hand (RH) blades are used to size materials during the cutting process. Pay special attention when ordering these blades due to the RH and LH configurations.

**Custom saws, grinds, bore sizes and pinholes available upon request.**