PRECISION ACCRETECH BLADE

NICKEL BOND BLADES

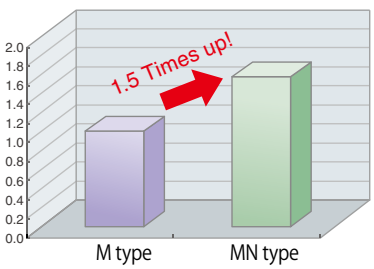
MN type

ACCRETECH
TOKYO SEIMITSU

Evolutionary version of standard type in response to the needs of ultra-thin blade. MN type has realized the rigidity of more than 1.5 times succeeding the standard bond lineup and enables the high-speed cutting.

- Based on the standard type, rigidity was upgraded to its limit and cutting straightness was improved.
- Realized a high quality cutting surface by controlling the amount of grit protrusion on the lateral face of the blade.
- Decrease in the grit shedding on lateral face of blade to prevent blade deformation.
- Lessening adhesion of cutting powder to the blade surface.
- Cutting ability improvement due to the special slits.

Processing example Nickel blade (MN type)



Rigidity comparison

MN type has rigidity of more than 1.5 times succeeding the standard bond line, which enables the high-speed cutting by ultra-thin blade in increasingly demands.

Current type, MN Type

Green sheet processing example

Prevent blade deformation caused by grit dropping abnormally; minimize adhesion of cutting powder to the blade. MN type enables cutting in good condition even if the intermediate dress frequency is decreased.

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■ Specification and Notation

1A8	S		
Shape	Slit		
D	8/16	-	MMN
Grit type	Grit size		Type

■Concentration

H	High
M	Standard
S	Low

■Slit

S	Standard type
SN	Slant type

■ Dimension and Notation

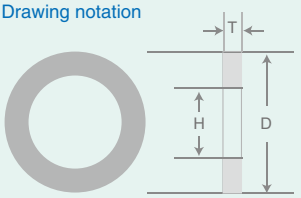
56D	0.05T	40H	2d	1W	16N
O.D.	Blade thickness	I.D.	Depth of slit	Width of slit	No. of slit

■ Production Range

O.D./D +0.1/-0	Blade thickness/T(mm) ±0.005 *1	I.D./H(mm) H6	Depth of slit/d (mm)	Width of slit/W (mm)	No. of slit/N
50≦D<58	0.04≦T≦0.4 *2	40	–	–	–
58≦D<62	0.05≦T≦0.4		By blade exposure	0.5, 1, 2, 3	8, 16, 32, 64
62≦D<80	0.08≦T≦0.4	40≦H≦88.9			
80≦D≦100	0.1≦T≦0.4				

*1 #325 is ±0.01.
*2 0.025~0.05 is ±0.003.

Drawing notation



■ Production Range

Grit size (um)	Mesh size	Concentration		
		H	M	S
8/16	1000	●	●	
8/20	800	●	●	●
12/25	700	●	●	●
20/30	600	●	●	●
30/40	500	●	●	●
40/60	400	●	●	●

■ Production Range

Grit size (um)	Mesh size	Blade thickness (mm)				
		0.05<T <0.06	0.06<T <0.08	0.08<T <0.1	0.1<T <0.12	0.12<T <0.2
8/16	1000	●	●	●	●	●
8/20	800	●	●	●	●	●
12/25	700		●	●	●	●
20/30	600			●	●	●
30/40	500				●	●
40/60	400					●

■ Ordering the product

When ordering our product, please refer to our catalog and let us know the details of the product as below.

1) Shape and size/ Detailed blade shape and precision etc.
2) Specifications/ Desired specification as well as the current in-use blade etc.
3) Cutting work and condition/ Machine in use, RPM, feed speed, coolant flow rate etc.

■ Precautions

In order to use the product safely and to bring out the best of the blade's performance, please make sure to thoroughly read the specifications and other related materials of the product.

* The catalog is subject to change without notice.
* The catalog is not to guarantee the product quality.

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