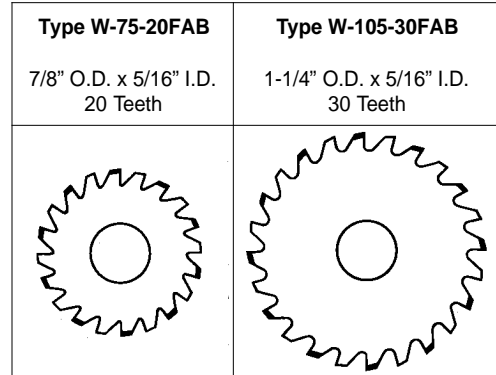


**HIGH SPEED STEEL PRECISION
RISER SLOTting / COPPER SLITTING SAWS / (JOYAL®)**

Used for slotting copper commutator risers and other materials that produce long, stringy chips.

The two styles of saws shown are for Commutator Riser Slotting. These saws are precision ground on all surfaces; dimensions are shown under the actual size illustrations at right. Formed teeth are on center, with a 15° back-off and 45° alternate bevel which is 1/3 the width of the tooth. Saws are hollow-ground to provide clearance between the periphery and the hole.



Specify Thicknesses when ordering.

M-2 High Speed Steel.

W-75-20FAB, 7/8" x 5/16", 20 TeethOW7520__ __ __ **Catalog Number** (*Specify Thickness)
W-105-30FAB, 1-1/4" x 5/16", 30 TeethOW10530__ __ __ (*Specify Thickness)

*Saws are stocked in thicknesses from .010" through .069" in .001" increments.

Thickness tolerances are +.0000" -.0002".

RESHARPENING SERVICE
Complete resharpening service is available. Prices on application.

COATING SERVICE
TiN, TiCN and other surface coatings are available. Prices on application.

**HIGH SPEED STEEL - TYPE SMF
COPPER SLITTING / RISER SLOTting SAWS**

Used for cutting rolled Aluminum and Copper — materials that produce long, stringy chips.



Ground and Landed Teeth

M-2 High Speed Steel

Hollow Ground For Side Clearance

Alternately Beveled Teeth



Alternately beveled teeth (see sketch) produce chips of less than the width of the slot being cut, eliminating the tendency of chips to clog.

NOTE:

For prices of thicknesses not shown, use next higher price in schedule (plus a slight grinding charge for smaller quantities). Other diameters, hole sizes, thicknesses, number of teeth, etc., also available on application.

**Rake Angle of Teeth:
10° Positive**

Metric Sizes Available

Thickness		O.D.	2-1/2"	3"	4"	5"	6"
		Hole	7/8"	1"	1"	1"	1"
		No. of Teeth	20	24	26	32	36
Fraction	Decimal						
3/16"	.1875"			OSMFD1562	OSMFE1875	OSMFF1875	OSMFG1875
5/32"	.1562"			OSMFE1562	OSMFF1562	OSMFG1562	
1/8"	.1250"		OSMFH1250	OSMFD1250	OSMFE1250	OSMFF1250	OSMFG1250
3/32"	.0937"		OSMFH0937	OSMFD0937	OSMFE0937	OSMFF0937	OSMFG0937
1/16"	.0625"		OSMFH0625	OSMFD0625	OSMFE0625	OSMFF0625	OSMFG0625
3/64"	.0468"		OSMFH0468	OSMFD0468	OSMFE0468	OSMFF0468	OSMFG0468
1/32"	.0312"		OSMFH0312	OSMFD0312	OSMFE0312		

Tolerances: O.D. ±.005; Thickness ±.0005; I.D. +.001 -.000
Closer tolerances available at additional cost.