

## Usage of the fret slotting table saw blade

Work always in compliance with current safety regulations.

This saw blade is made for use on table saws - cutting fret slots only. Please check the machines manual if this blade can be used on your machine.

Cut only flat boards – when you want to add a radius – do this after cutting the slots.

Setup your table saw so that teethes of the blade look against the movement of the fret board – as normal.

The blades bore is for standard 30mm flanges – use reducing rings if applicable.

Check your saw blade is clean, sharp and well tightened. Check clogging of the teeth and clean them regularly (resin remover (e.g. potassium hydroxide)). Too much smoke is always an indication that there is something wrong. But there is always some smoke. Restart the machine only when issues are found and solved.

Use a shooting board to transport the fretboard over the table saw blade.

Check that the indexing pin and all other metals (e.g. from the template) are out of reach of the blade when you cut. The pin can be installed 5mm offset left or right from the blade – not directly over it.

Adjust the height to the dedicated slot depth – maximum 3,5mm. A classical fret board needs only 2mm.

Switch on the machine and double check if everything OK.

Use a dust collector to suck off the saw dust and smoke.

Make a test cut first and check the depth.

Use a feeler gauge to check the resulting width. When you use a 0,6mm blade – the cut should be 0,6mm – maybe 0,65mm.

Cut only one time through the board – back and forth will damage the accuracy of the width. Lift it over to return and then go to the next kerf. Attention to the turning cutting blade!

Several parameters are to be determined for a perfect fret board:

- Cutting depth (normal is between 2,0-3,5mm check with your frets and drawing drawing)
- Feed (normal is 3-6 seconds for one cut in a 60mm wide fret board). Of cause adapt the speed to the type of wood you use etc.
- Speed of spindle (2800 1/min / max. 6000 1/min)
- Concentricity tolerance (wobble of the blade should be below 0,05mm – check stability of the machine, bearings etc. if out of tolerance)
- The fret board should be moved 100% right angled and tight fit via a shooting board over the blade.
- The outer 10mm of the blade are especially hollow-ground and can be re-sharpened 15-20 times until the flat area is down to app. 4mm.