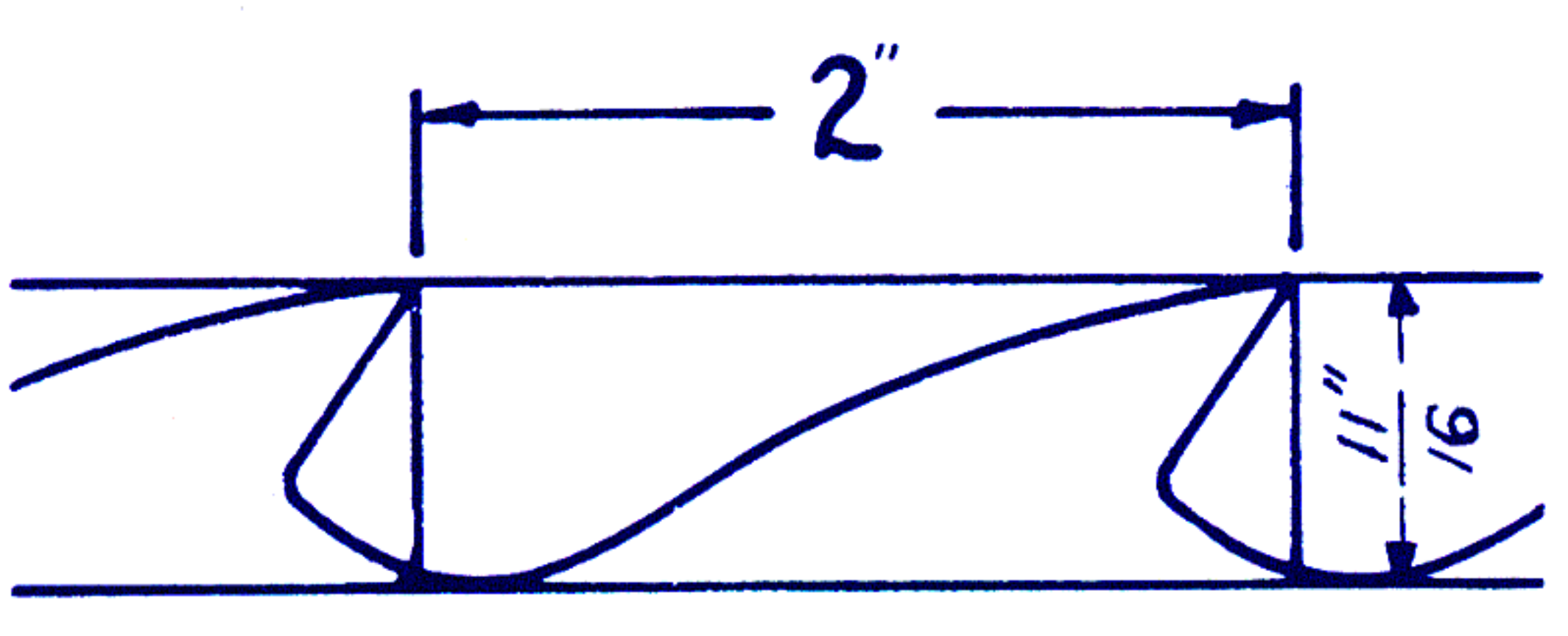
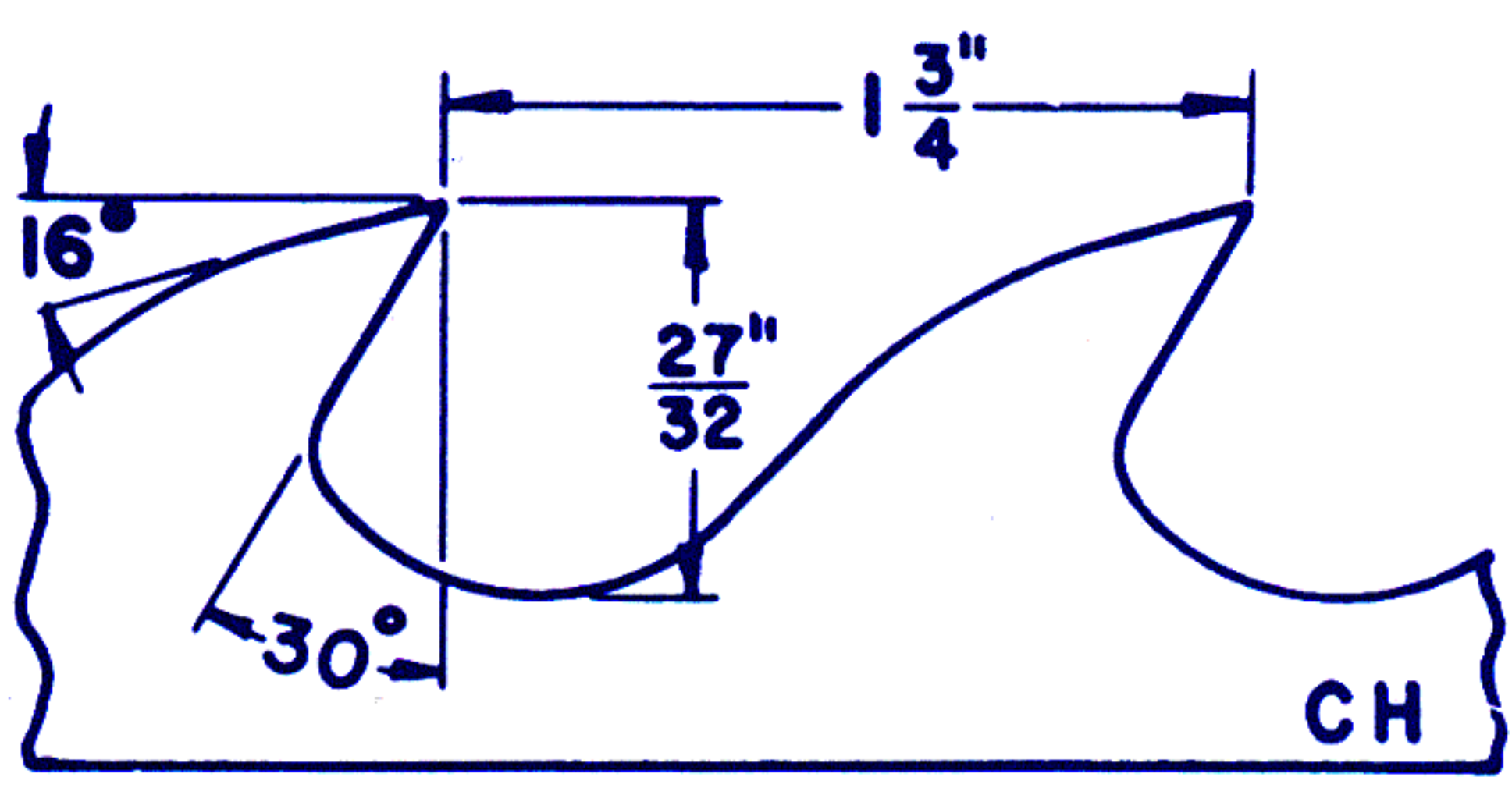
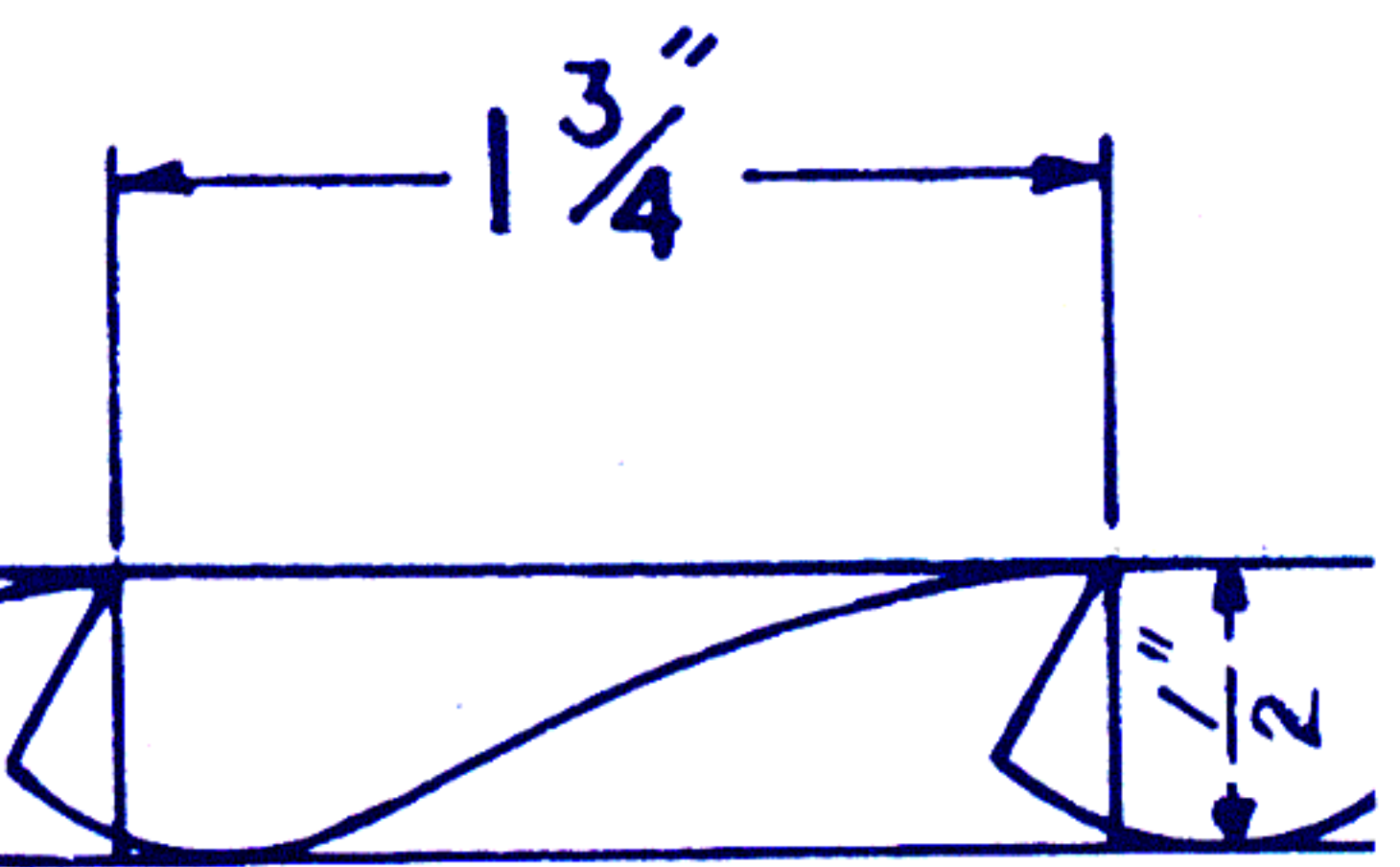
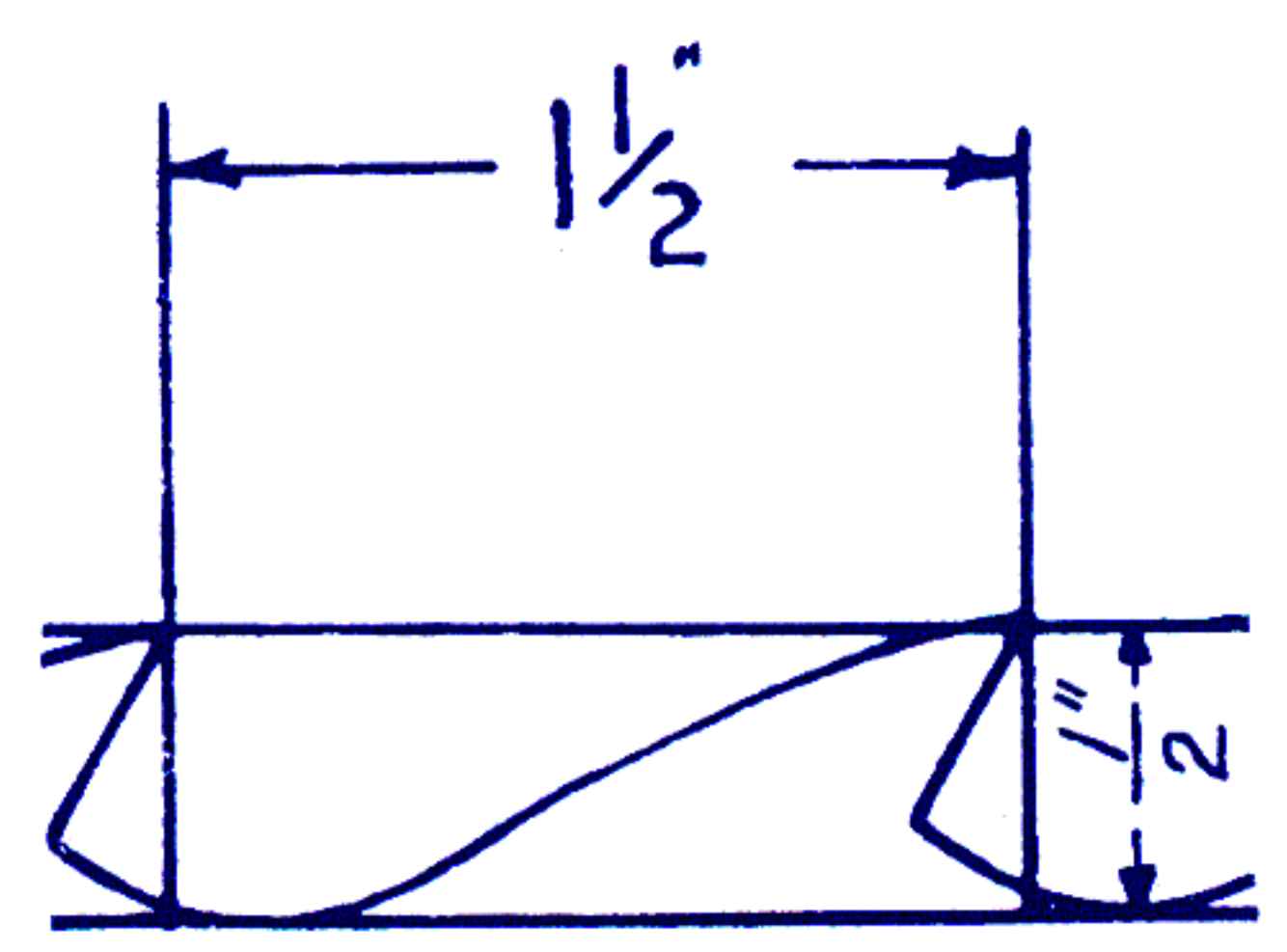


Common Tooth Profiles



Tooth Shapes/Grinding

The water jet/laser cutting process along with a CNC grinder allows us to produce any tooth shape including variable pitch and variable depth. We can generate a computerized tooth pattern for your approval prior to manufacturing. The same program will be used in our CNC grinders to assure you the same tooth shape time after time.

Frost Notch

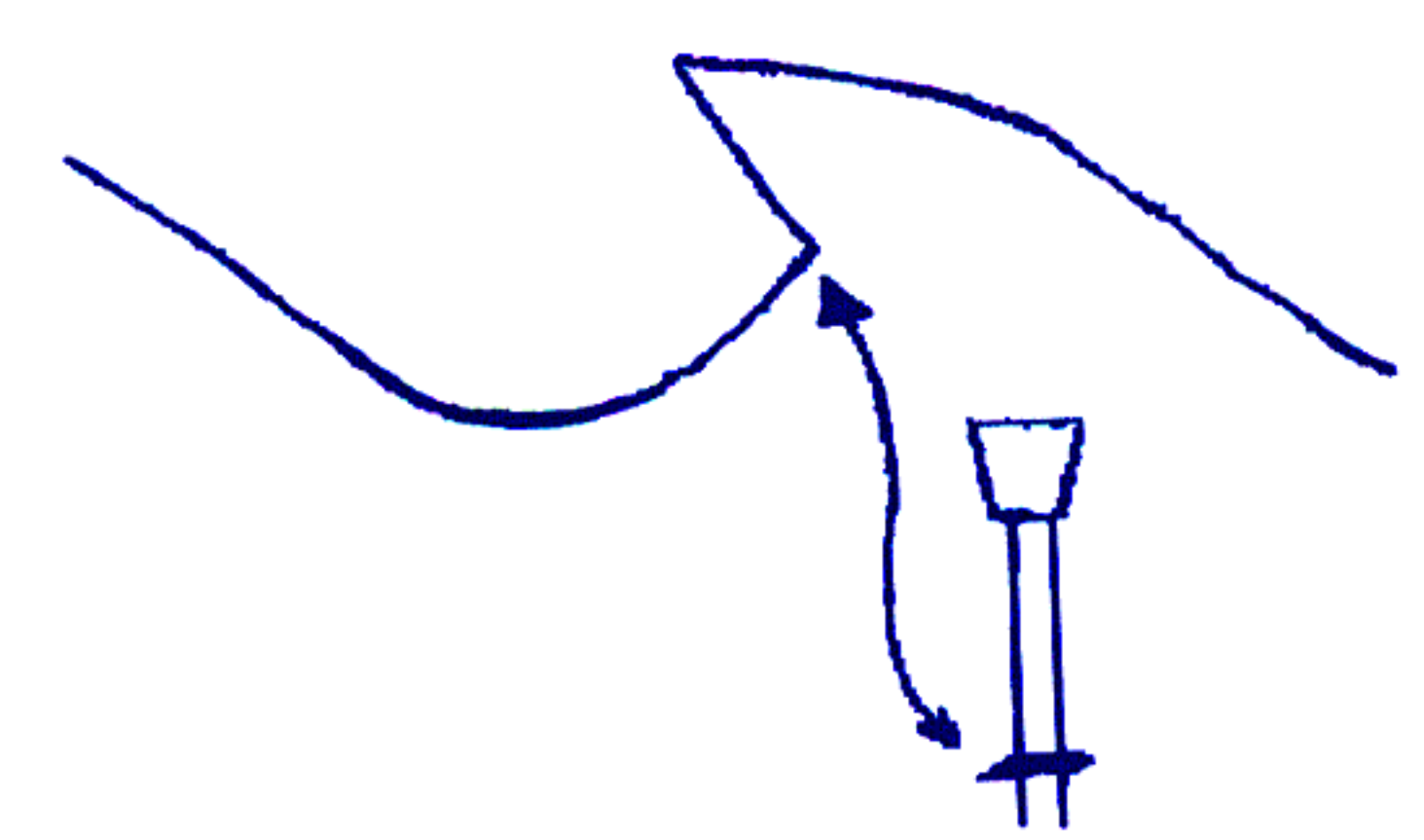
There are basically *two types of frost notches* being used in the industry today. Both are drawn below. Style #1 is formed in the grinding process by either putting a groove into the standard size wheel or using a two-wheel assembly with a thin spacer between them. Style #2 is formed by striking the base of the tooth-face with a sharp chisel. The chisel should be held perpendicular to the plate.

It appears that both styles provide the same benefit. Both tend to accelerate the wood chip away from the bottom of the gullet, thus enabling it to be carried longer and less likely to spill into the cut. Style #2 tends to work better in horizontal applications due to its "expanded" plate thickness. The flared sides of the notch reduce the actual side clearances in the critical area at the base of the tooth-face.

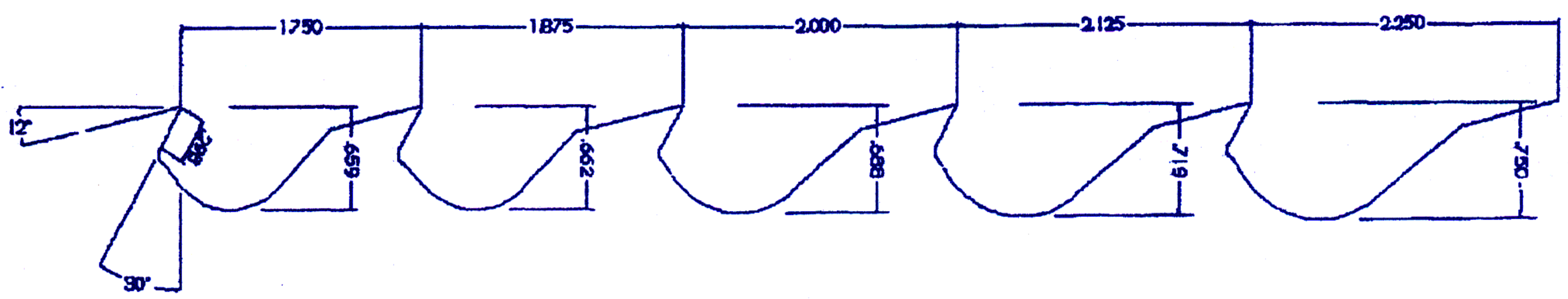
Style #1



Style #2



Example of Variable Pitch Variable Depth Gullet



12° Back 30° Hook