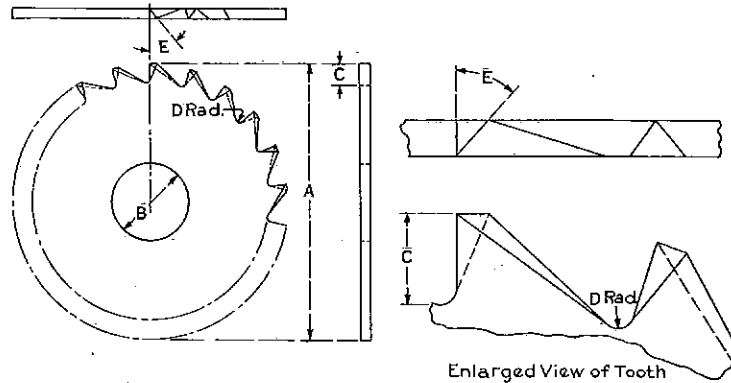




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G-E Commutator Grooving Saws

The illustration below shows an improved high-speed steel saw which is now available for grooving commutators. Previously, the commutator grooving saws were punched from sheet steel and hardened. The new high-speed steel saw is cut from a solid bar, hardened, ground, and sharpened.



High Speed Steel 22-tooth Grooving Saw
A = 1 1/8 In. B = 3/8 In. C = 1/16 In. D = 1/8 In. E = 40 Deg.

ADVANTAGES

High Speed Steel

A high-speed steel saw will hold a cutting edge longer than one made from ordinary steel. The proper method of treating the steel has been determined by many years of experience with commutator grooving saws in General Electric factories.

Grinding

The saws are accurately ground to uniform thickness, care being taken that this operation overcomes any warpage which may have resulted in the hardening process. The grinding operation produces a saw which is absolutely true. It is possible with a true saw to remove only the mica without cutting into the copper.

Sharpening

The sharpening of the teeth provides keen cutting edges which will cut the mica rather than break it. It is essential that the mica be cut to uniform depth in order to eliminate any sharp edges or depressions which may accumulate dust or oil.

While the cost of this new saw is considerably more than that of the punched type previously supplied it is much more economical in the long run.

The new G-E commutator grooving saw

- (1) Will groove more commutators
- (2) Can be resharpened many times
- (3) Saves the operator's time in changing saws
- (4) Saves the segments by cutting the minimum amount of copper
- (5) Saves the mica by making a uniform cut.

In order to obtain the best results, the arbor must run perfectly true and without play. It is also important that the spacing collars used on the arbor be accurately faced and fit the shaft closely. Every precaution is observed in the manufacture of these saws to make them run true. It is therefore suggested that operators using these saws inspect the grooving machines on which they are used.

Ask our nearest office for further information

General Electric Company, Schenectady, N. Y.

SALES OFFICES IN ALL LARGE CITIES

Thickness in Inches	CATALOGUE NUMBER	
	High-speed Steel Saw	Obsolete Punched Saw
0.020	2672300 P-1	147229
0.025	2672300 P-2	122061
0.030	2672300 P-3	147230
0.035	2672300 P-4	259031
0.040	2672300 P-5	259032



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