

It now must be ANNEALED to prevent breaking.

#### **ANNEALING:**

Release jaw clamps and move T-Crank to the right on anneal position. Distance between jaws is now approximately 5/8". Reclamp saw blade with weld centered between jaws. This permits annealing the blade the proper distance on each side of the weld. Set heat switch on "LOW" position and anneal weld by operating weld switch "INTERMITTENTLY" until blade is dull red.

Do not overheat by holding button in too long. This causes weld to become weakened or brittle, and causes blade breakage.

#### **REMOVING WELDING FLASH:**

Use Grob R-5 filing fixture for removing welding flash.

Place blade in filing fixture with teeth facing operator, and Clamp securely. (See Fig. 2.) Use mill bastard file, moving in line with saw blade. (DO NOT file crossways as this will injure blade teeth).

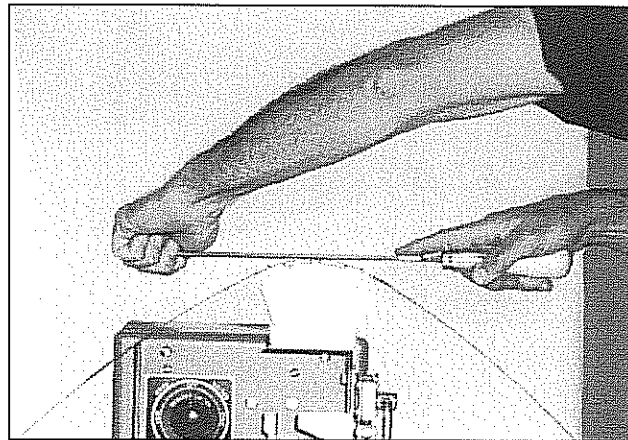


Fig. 2  
R-5 FILING FIXTURE

When weld is filed flush, remove blade and examine weld for any high spots by sliding a Grob Single piece saw guide over the weld. IT MUST SLIDE FREELY.

Run a file across the back of blade at weld to remove sharp edges.

RE-ANNEALING after flash is removed will assure a stronger weld.

If grinder unit is used to remove weld flash, do not undercut the blade as this will weaken it.

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