

TABLE SAW BLADES

Flat Top Grind (FTG) teeth plow through the wood. They're primarily used on rip blades, where a fast feed rate is important to prevent overheating and bottom-side tear-out isn't an issue because the cut runs parallel to the wood fibers.

Alternate Top Bevel (ATB) teeth cut like knives, scoring the wood to minimize tear-out. Bevel angles vary: Increasing the angle improves cut quality but reduces durability. ATB teeth are used on crosscut, general-purpose and some rip blades.

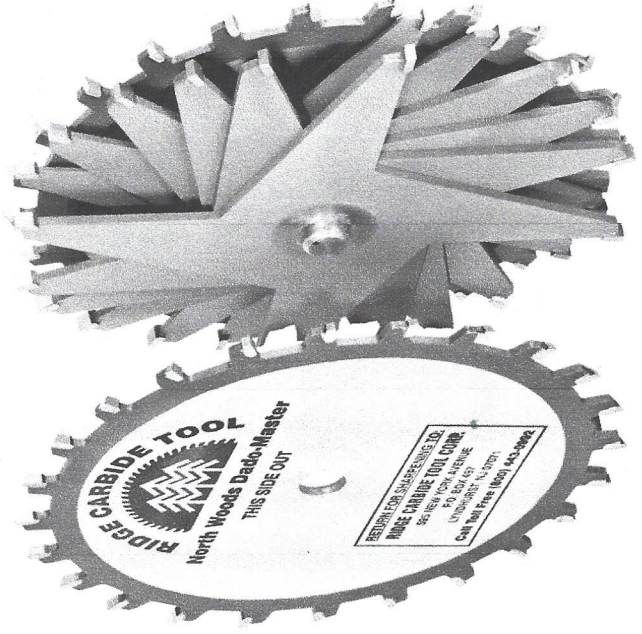
High-Angle Alternate Top Bevel (Hi-ATB) teeth have steep bevel angles (30 to 40 degrees) to cut melamine perfectly without tearing out the paper-thin face veneers. This tooth configuration is also great for hardwood plywood. These steeply beveled teeth are less durable than regular ATB teeth, though.

Alternate Top Bevel/Raker (ATB/R) This configuration groups crosscutting teeth and ripping teeth in five-tooth clusters. Designed for both ripping and crosscutting, it's featured on 50-tooth combination blades.

Triple-Chip Grind (TCG) teeth have beveled corners. On the blade, they alternate with FTG teeth. TCG teeth don't have scoring bevels, so they're very durable. They're used on glue-line rip blades and blades for melamine board, laminates and other manufactured materials when tooth durability is most important.

Job	Blade Choices	Comments
Ripping solid wood	24-tooth FTG	This "rip" blade cuts fast but coarse. It's good for initial rough-sizing of pieces.
Crosscutting solid wood and general plywood sawing	40-tooth ATB or 50-tooth ATBR combination blade	Cuts slower but cleaner. Premium-quality blades require little or no cleanup.
Joinery	40-tooth to 80-tooth ATB or 50-tooth ATBR combination blade	Blades with more teeth generally cut cleaner, but a top-quality 40-tooth blade may cut better than a mediocre 80-tooth blade.
Sawing MDF, melamine, and particleboard	40-tooth ATB or 50-tooth ATBR combination blade	A premium-quality blade will create glue-ready joints cutting across or with the grain.
Sawing plastic laminate, nonferrous metal, and plastics	40-tooth to 80-tooth ATB or TCG	ATB blades tend to cut cleaner but dull faster than TCG blades.
	80-tooth TCG	ATB blades can be used instead but may blunt quickly in these dense materials.

FTG, flat-top grind; ATB, alternate-top bevel; ATBR, alternate-top bevel with raker; TCG, triple-chip grind.



DADO BLADE SET