

GRINDER TOOL REST HEIGHT CALIBRATION



Be absolutely certain to use a vitrified grinding wheel dressed perfectly to the same size and shape as the tracing pin to be used, preferably a 4mm (2mm radius).

Use a small half round type profile template. This will help keep the wheel shaped a little better throughout all the following processes.

- Hog in one HSS knife all the way down to full contact of template.
- Redress wheel radius to match tracing pin.
- Make a second roughing pass across the knife, down to template.
- Redress wheel again, make one more kiss pass across the knife.
- Tilt for side clearance angles, grind both sides, (be sure not to cross over bottom dead center). Stop side travel when you here no contact with wheel and knife.
- Redress wheel leave it @ zero & reference the knife.
- Keep wheel to the “zero” position (straight up and down).
- Drop your back clearance angle to your finish angle, re-reference the wheel with the coolant off, to set the desired width of finish grind line, and then make a light pass across entire profile in both directions.

If the profile was opened up in the areas where side clearance was applied OR, if these same areas show a thinner width of finish grind line than you are seeing in the minimum tool radius (lowest point of knife) areas. Then the tool rest is, TO HIGH.

If you are seeing the opposite effect then the tool rest is, TO LOW.

If there needs to be an adjustment, remove the grinding wheel, remove the nut from the bottom of the tool rest support arm and remove the entire (black) tool rest assembly as in the photo. DO NOT remove the allen bolt! Remove or add shims according to the evidence from your initial grind.

Re-install the tool rest assembly but, do not tighten the mounting nut yet.

Use the existing tool body or mount in another one and move it towards the tool rest. Gently hold the tool body against the tool rest and this will help

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you insure the tool rest gets locked down in the correct position. Now, tighten the locking nut under the tool rest support arm.

Repeat the above steps until the tool rest is giving you a perfectly equal line width all the way across the entire profile. **ONLY**, through this procedure, will the tool rest be at the correct height.

There is no way to simply measure something, make an adjustment and achieve the same level of perfection as the above processes will achieve.

TIP

Maintaining the grinding wheel shape is crucial to calibration so, it is good to redress the wheel between each step of this process. If the wheel is not the correct shape it can and will give false readings.

You will be grateful in the end that you took a little time to do this right the first time.

Also, this **MUST** be part of your annual maintenance (if not more often) along with axial calibration of the grinder.

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