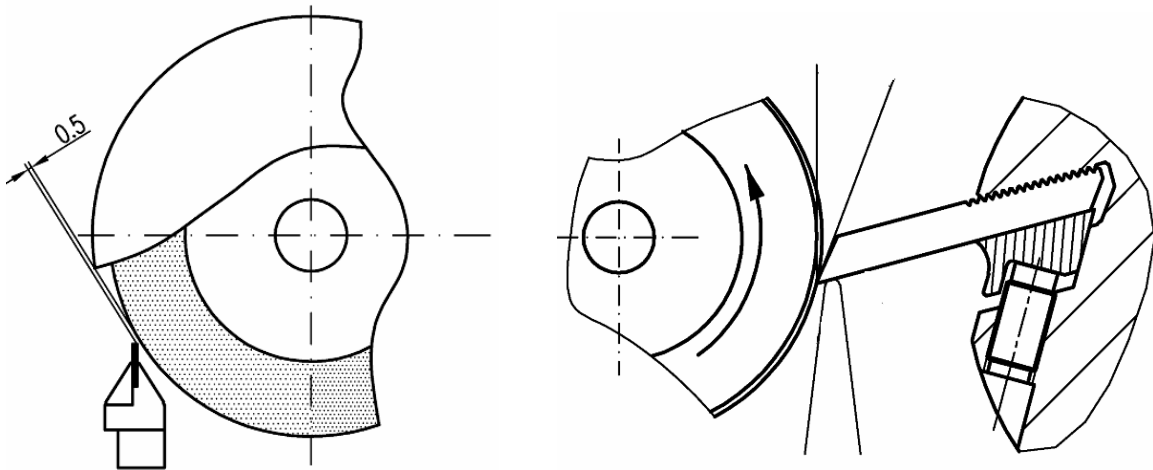




## DLC COATED HYVAL KNIFE STEEL SPECIFIC GRINDING INSTRUCTIONS

- 1) Make sure your knife rest does not have any sharp edges or burrs.
- 2) There needs to be a gap of approximately 0.5mm (0.020") between the grinding wheel and knife rest.
- 3) A 2mm CBN (Cubic Boron Nitride) grinding wheel should be used for the final finish grind. This wheel should be 240-320 grit, and should be run at 2500RPM. However, good results have also been seen when using a 100 grit aluminum oxide wheel.
- 4) If your grinder has a carbide package that allows reverse wheel rotation, the finish grind should be done with the rotation of the grinding wheel towards the cutting edge.
- 5) Remove burrs with a piece of hardwood or plastic after finish grinding. Use of an abrasive stone will remove the DLC coating.
- 6) Standard grinding procedures and angles are to be used for all other operations.



tooling@weinigusa.com  
800/343-4644