

General Grinding Steps for High Speed Steel (HSS)

ROUGH GRIND

1. Set back clearance grinding angle.
2. Set wheel RPM.
3. Set proper distance between the wheel and the tool rest. .020" 0.5mm
4. Make sure wheel width matches the tracing pin width (use a square tracing pin).
5. Rough grind the knife until the tracing pin contacts the template.
6. Index the wheel toward the tool rest proper distance. .020"
7. Regrind the knife.
8. Repeat steps 1 through 7 for all knives.
9. Make sure all knives are even.
10. Dress the wheel round. Be sure to then rotate the tracing pin to the round side.
11. Regrind all knives while maintaining the proper distance between the wheel and the tool rest. .020"
12. Set up for side clearance (on any angle over 60°) and grind in areas needed, still at the rough grind angle.
13. Redress wheel (round). At 0° side clearance, regrind all knives while maintaining the proper wheel/tool rest relationship. .020"

FINISH GRIND

1. Set proper back clearance grinding angle.
2. Set higher wheel RPM.
3. Set distance between wheel and tool rest. .020"
4. Make sure the wheel shape and width match tracing pin.
5. With coolant off, index wheel towards knife until minimal contact is made. Start coolant and proceed with grind (smaller grind is better).