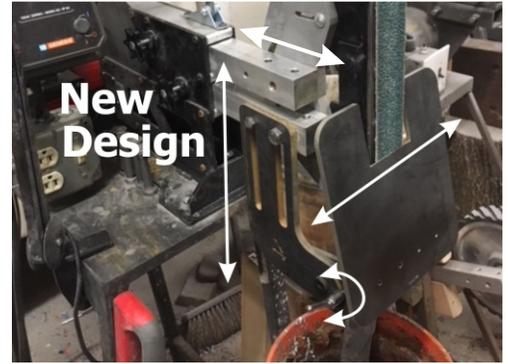


Easy Tilt Table Bevel Grinding

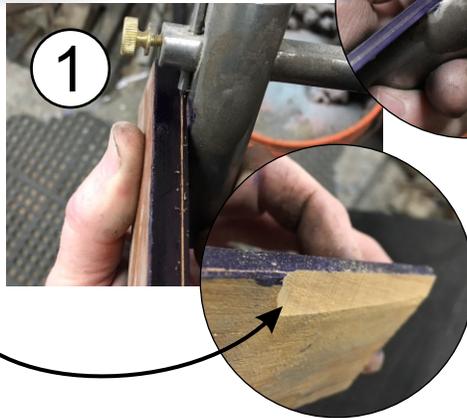
The Tilt Table mounts to a standard 1 1/2 inch tooling arm. It was designed for OBM grinders but is adaptable to fit a wide range of different manufacturers 2x72 belt grinders. Use adjustments to center table cut out on platen and square table to platen.



Center Line Scribe used to mark parallel Railroad Track lines on blades edge.



One trick of the trade when setting up the Tilt Table is to scribe a center line on a scrap of wood. Then test grind a bevel into the wood to see if the bevel is wide enough for the blade.



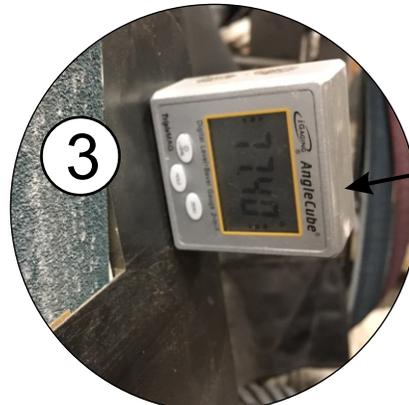
Coarse grit belt.



2 Hold the blade flat against the Tilt Table and then slowly bring it up and into contact with the grinders belt. The blade can then be moved horizontally. Its important to keep a little pressure against the blade to hold it flat against the table during all grinding. Use a coarse grit belt to remove the bulk of the material. Then change to a finer grit to finish the bevel.

Keep a close eye on the scribed center lines. A consistent grind along these lines will result in a bevel that will follow the profile of the blade.

Fine grit finishing belt.



3 A digital angle meter can be used to reset the Tilt Table to desired angle for post heat treating bevel polishing.

Large Wheel Tilt Table Hollow Grinds



Adjustments on the Tilt Table allow it to be positioned for hollow grinding on a large contact wheel.



We recommend beveling a scrap piece of wood to confirm bevel width is set accurately.

1

Start by holding the blade flat against the table and then bring it up into contact with the belt.



2



Maintain pressure to keep the blade flat while pulling it horizontally across the belt. As with flat bevels, it's very important to accurately grind evenly up to the scribed lines.

3



A finer grit belt can be used to polish the bevels.

