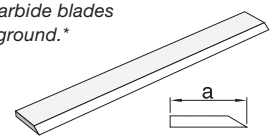
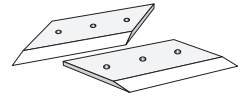
Planer Blade Attachment SVH-320

HSS PLANER BLADES

Copes with any length.
Min width (a) 13 mm (½").
*Tungsten carbide blades cannot be ground.**

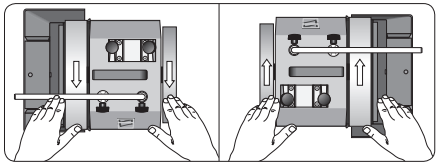


MITRE GUILLOTINE BLADES

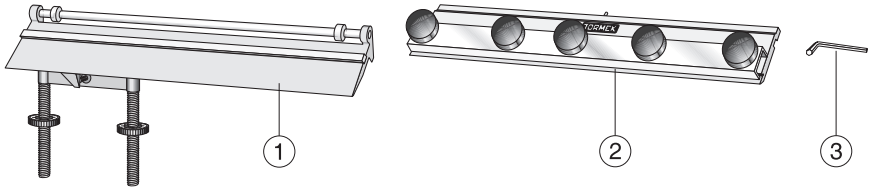


** The Tormek Blackstone Silicon SB-250 can touch up carbide.*

Positioning of Machine



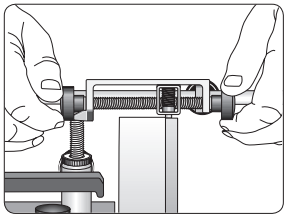
Grinding direction: towards the edge.



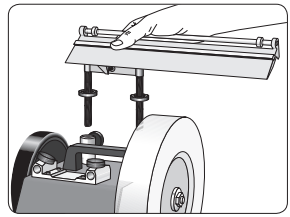
Design

The grinding jig comprises *support* (1), *blade holder* (2) and *Allen key* (3). In this jig the tool is guided precisely and ground flat along its whole length to a pre-set fixed depth. This is not the case with the other Tormek jigs, where your hand decides where the grinding occurs and the depth of grinding. It is important that the grinding angle is set with great accuracy. If you follow the detailed step by step instructions carefully, you will be satisfied with the results.

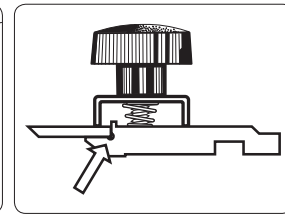
Preparations



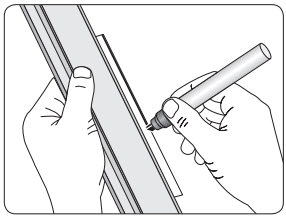
Check that the grinding wheel is exactly round and that the grinding surface is even. Adjust if necessary with the Tormek Truing Tool TT-50.



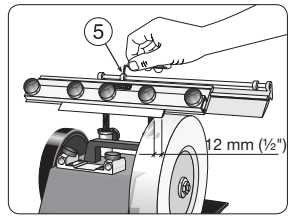
Remove the Universal Support and place the support in the sleeves of the machine. If required, remove the honing wheel.

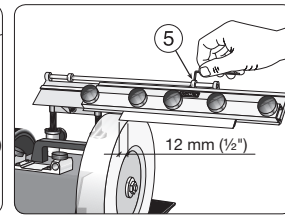


Clamp the blade in the holder. Make sure that it rests on the stop along the entire length. Always commence with any damaged blade in the set.



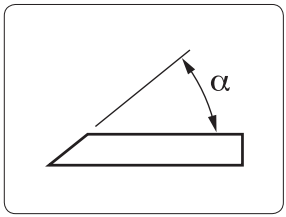
Colour the grinding bevel with a marker pen so that you can see where the grinding occurs when setting the edge angle.



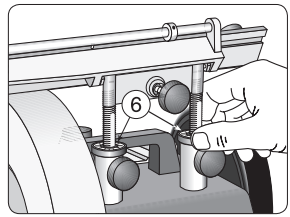


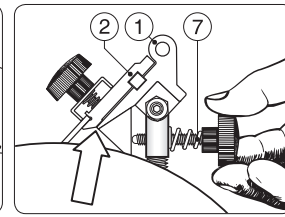
Place the blade holder on the support. Set the grinding length to the length of the blade to ensure that the blade does not run off the edge of the stone during grinding. This is done by adjusting and locking both stops (5). Blades longer than approx 270 mm (10½"), you move in the holder and grind in two steps.

Setting the edge angle and aligning the jig

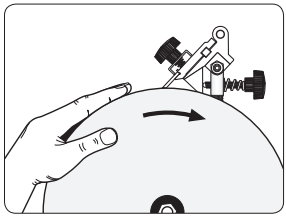


Grind the blade at exactly the original edge angle (α).

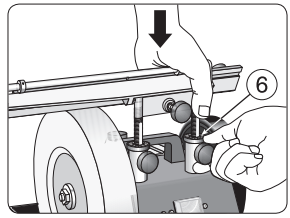




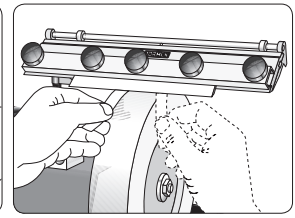
Make an initial height setting with the wheels (6). Set the edge angle with the adjusting screw (7). Make fine adjustments to the height with the wheels (6). The bevel should now lie flat on the stone and the holder (2) should touch the support (1).



Check the angle setting by turning the wheel by hand. The stone should make marks on the whole bevel, from the tip to the heel.



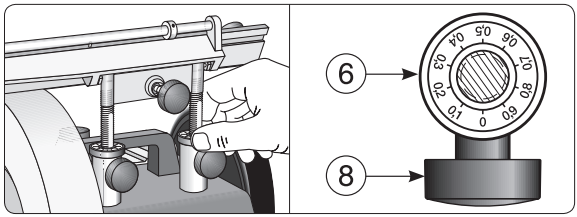
Press down the grinding jig while locking with the locking screws so that the two wheels (6) rest on the base without any gap.



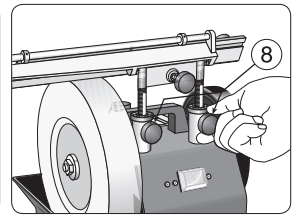
Make sure that the blade makes contact along the whole width of the wheel – a thin piece of paper simplifies this check. Adjust if necessary with the wheels (6).

Important *Do the angle setting with care to get exactly the same edge angle as the existing one. If you set the jig to grind the heel of the bevel, the operation will take unnecessarily long time.*

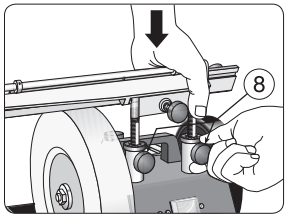
Setting the grinding depth



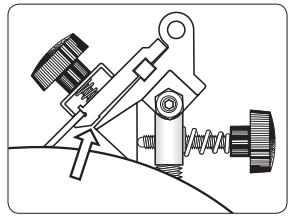
Set the grinding depth by raising the wheels (6). Turn the wheels equally in order to retain the parallel setting. The grinding depth is shown on the two wheels (6) which are graduated for each 0.1 mm (0.004"). The numbers on the wheels (6) do not need to be synchronised.



Unlock the two locking screws (8) and allow the support plate to lower by the amount you have raised the wheels (6).

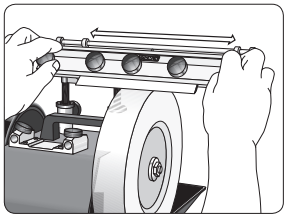


Lock the support plate – while it is pressed down – with the two locking screws (8).

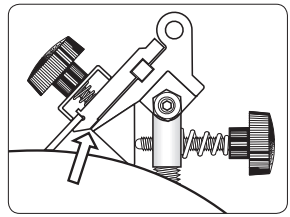


There is now a gap between the blade holder and the support.

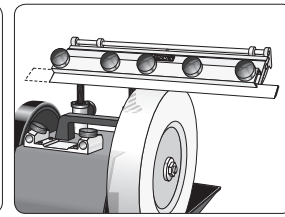
Grinding



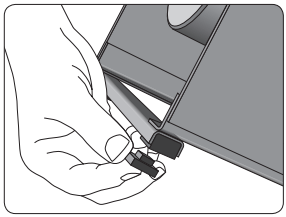
Grind by moving the holder with even pressure from side to side between the side stops.

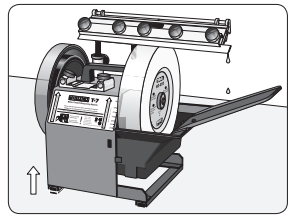


You must grind until the blade holder rests against the support along the whole length. Grind the other blade with the same setting.



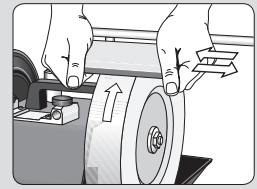
For longer blades more than 270 mm (10½"): Move the blade in the holder and grind in two steps. Make sure that the back of the blade rests on the stop.



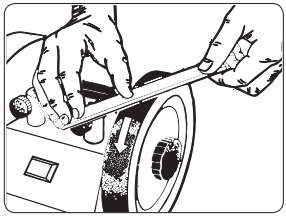


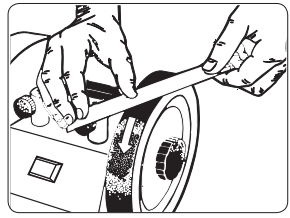
The water tends to track to the ends of the blade. Mount the water chute onto the trough and raise the honing wheel side of the machine by using the two Tilt Shoes. The water will now follow the blade and drip onto the chute.

Important *If the grinding effect of the stone decreases during the operation, reactivate the stone with the Tormek Stone Grader SP-650.*
New grinding grains are then brought into operation.
Use the corners of the grader for best effect.



Honing

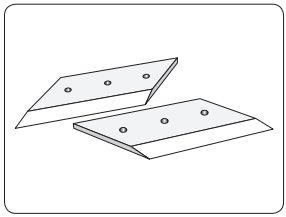




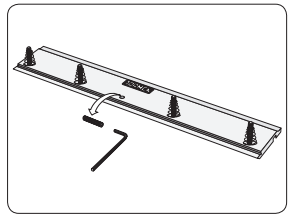
Hone away the burr gently on the leather honing wheel. Start with the reverse side and then the bevel and repeat this a couple of times. Important: Always hone away from the edge!

Mitre Guillotine Blades

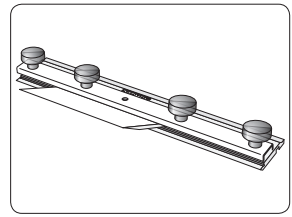
To mount these wider blades you need to remove one (or two) of the screws in the blade holder. Use a 3 mm Allen key. The sharpening instructions are the same as for planer/jointer blades. Re-mount the screws when grinding planer/jointer blades.



A set of mitre guillotine blades.



Use a 3 mm Allen key to remove one of the screws.



Mount the blade so the edge is parallel to the blade holder.