

JOINTING STONE SHAPING INSTRUCTIONS

Note: Grinding accuracy is critical in determining proper jointing stone selection.

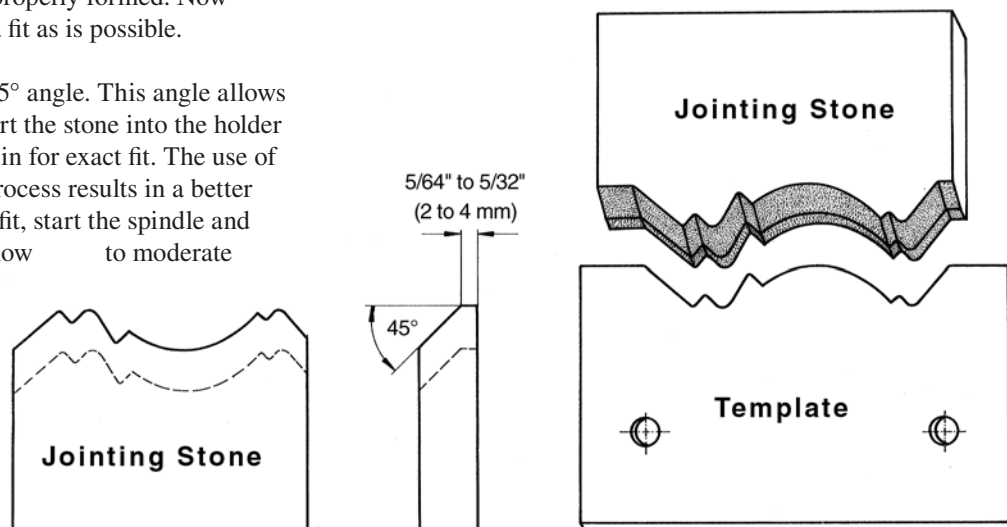
First, layout the stone using the pattern knife to be jointed. It is most important to maintain as accurate a mirror image fit as possible to the profile being jointed, as the jointing stone will in effect re-profile the knife if not properly formed. Now pre-shape the stone to as accurate a fit as is possible.

Taper the stone on both sides at a 45° angle. This angle allows faster chipping-in of the stone. Insert the stone into the holder on the machine, and chip the stone in for exact fit. The use of only one knife in the chipping-in process results in a better fit. After the stone is chipped-in to fit, start the spindle and bring the stone into the knife at a slow to moderate speed. One technique is to bring the stone in and out in 1 second intervals, making minor adjustments at each interval.

Another technique is to bring the stone in and hold it in

slight contact with the knives. Depth control adjustments are made while contact is being made. This technique is tricky as extended time of contact can cause the stone to glaze.

Jointing Carbide Instructions on Page 106.



JOINTER STONES RECOMMENDATION CHARTS

Hard Jointing Stones

Materials Being Jointed at 3,600 rpm	Type of Joint		Abrasive Materials		Grit
	Planing	Profiling	Silicon Carbide	Aluminum Oxide	
HSS	X		X	X	80-220
HSS		X	X		220-400
Carbide Tipped	X		X		220-400
Carbide Tipped		X	X		220-400
Carbide Sandwich	X		X		220-400
Carbide Sandwich		X	X	X	220-400

Soft Jointing Stones

Materials Being Jointed at 6,000 rpm	Type of Joint		Abrasive Materials		Grit
	Planing	Profiling	Silicon Carbide	Aluminum Oxide	
HSS	X		X	X	280-600
HSS		X	X		500-600
Carbide Tipped	X		X		220-400
Carbide Tipped		X	X		150-220
Carbide Sandwich	X		X		220-400
Carbide Sandwich		X	X	X	150-600