



Grinding procedures for Side Trimmers

Regrinding these parts for maximum performance and minimal downtime, including setup, involves:

1. Use of a course honing stone to remove pickup, high spots or buildup from the side faces may be needed. If excessive use of a belt sander on the OD of the knives may be necessary to remove pick-up off the OD of knives. In some instances the OD may be able to be ground. This needs to be verified by our customer.
2. A visual analysis of the knife edge is suggested and if cracks are visible a Dye penetrate may be needed to check for damage.
3. If used one should input knife into a computer tracking system to monitor knife vendor, hardness, regrind frequency, stock removal and reorder point notification.
4. Face grind knives to remove nicks or cracks, care should be taken to get below “fatigue” layer. The coolant used for grinding is a water based mixture of various chemical to reduce heat which is detrimental to cutting edge, and does cause distortion and to prevent oxidation of knives.
5. Knives when ground are to be held parallel to within 0.0005”. This is important for quality of cut and integrity of cutting edge. Parallelism directly affects the knife clearances and needs to be maintained.
 - Selection of grinding stones used has evolved into a science, we will utilize either vitrified bond or ceramic stones to reduce heat and improve finish.
6. All edges are hand-honed removing all burrs.
7. We inspect the knives and record information for historical reference.
8. Oil is applied to insure “rust” free parts.