



Grinding procedures for Gang Slitter Knives

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

1. If necessary use a hone to knock down any pick-up, high spots or buildup off knives. If excessive use of a belt sander can be used with great care to clean up the OD.
2. If visual analysis indicates cracks may be present conduct a dye penetrate test of the surface.
3. If used input knife into a computer tracking system to monitor knife vendor, hardness, regrind frequency, stock removal and reorder point notification.
4. When grinding the OD it is important to grind on arbors with 0.001" maximum interference to ID of the parts to be ground. This will reduce the run-out which directly affects slit edge quality. We recommend grinding approximately 0.020" off the OD, enough to insure the "fatigued" surface has been eliminated. In some cases greater stock will need to be ground off the surface.
 - 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.
5. All edges are hand-honed removing all burrs.
6. We inspect the knives and record information for historical reference.
7. Oil is applied to insure "rust" free parts.