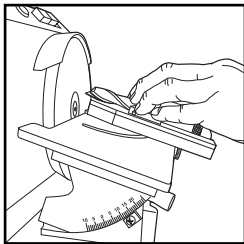
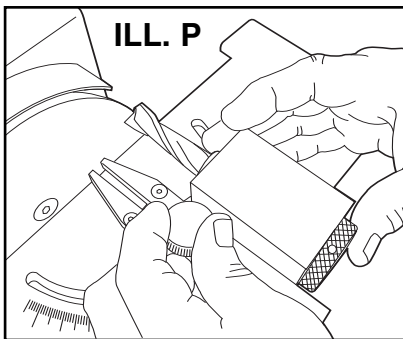


## USING THE TOOL STOP GUIDE

Remove the Protractor Guide from Accu-Finish table and attach the Tool Stop Guide (ILL. M). Look through opening in the tool stop and align centering mark with  $0^\circ$  (ILL. N). **NOTE:** To add "RAKE" or "RECESS" to the tool's cutting tip, adjust desired degree to the right of  $0^\circ$  (ILL. O).



Set desired face angle on the table's side protractor. Place Collet Block against right side of tool stop. Holding it tight against the tool stop, move table until the center of tool aligns with edge of the diamond wheel (ILL. P).

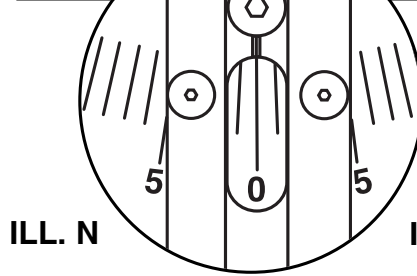
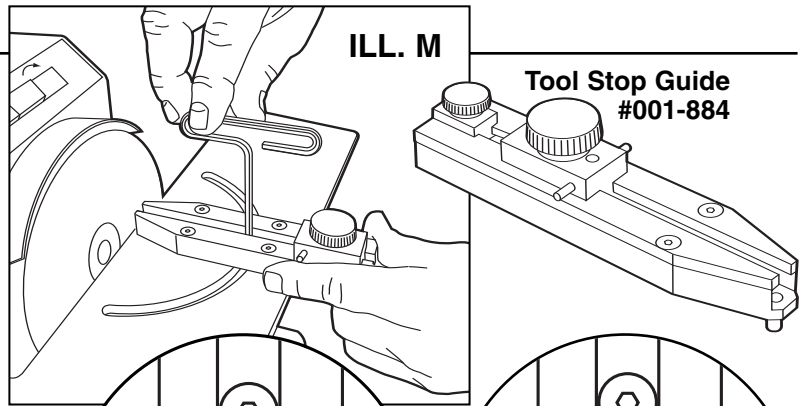


Double check that block is flat against tool stop and the "Stop Pin" is ahead of the block. Center tool with diamond wheel edge and LOCK table in position.

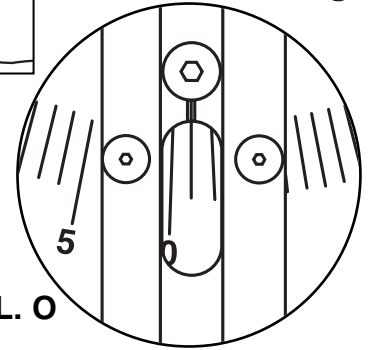
**NOTE:** When sharpening fluted tools, especially with a recess, we recommend using a  $30^\circ$  Reverse Angle Diamond Wheel for best results.

Push collet block forward until tool tip is against diamond wheel (1). Holding it there, move the Pin Stop against collet block (2) and tighten knob. Press smaller Stop (3) against Pin Stop and tighten knob. Loosen the larger Pin Stop knob and position a shim between the two stops (4). The shim should be the desired thickness of material you want to remove from tool's cutting edge. **NOTE:** *.003" is about the thickness of a piece of typing paper.*

Some choose to use only steps 1 & 2. Using off-hand placement of the Pin Stop for amount of tool tip removal. But, by using a measured amount shim, you will get longer tool life.



ILL. N



ILL. O

$30^\circ$  REVERSE ANGLE WHEEL

CENTER LINE

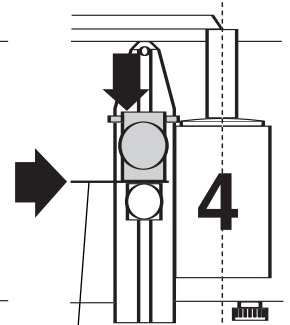
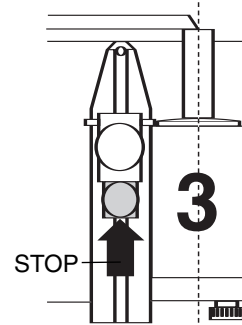
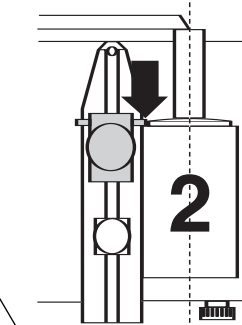
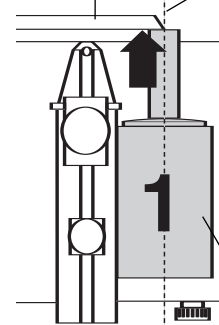
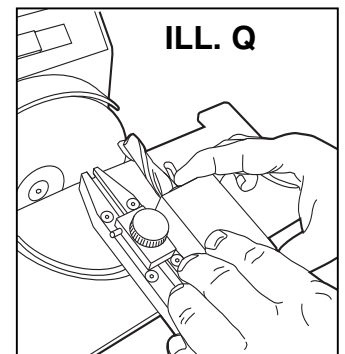


TABLE LOCK KNOB

STOP

SHIM

Holding the collet block against the tool stop guide, gently feed it into the wheel until the STOP PIN stops it. (ILL. Q). **CAUTION: DO NOT FORCE TOOL INTO WHEEL - DAMAGE WILL OCCUR.** Rotate collet block and sharpen each flute the same way.

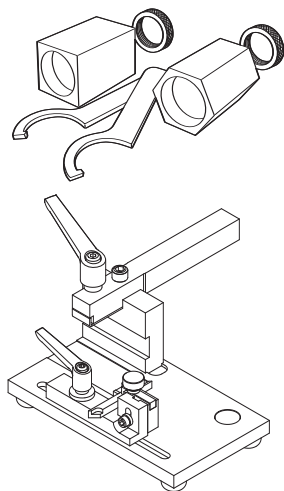
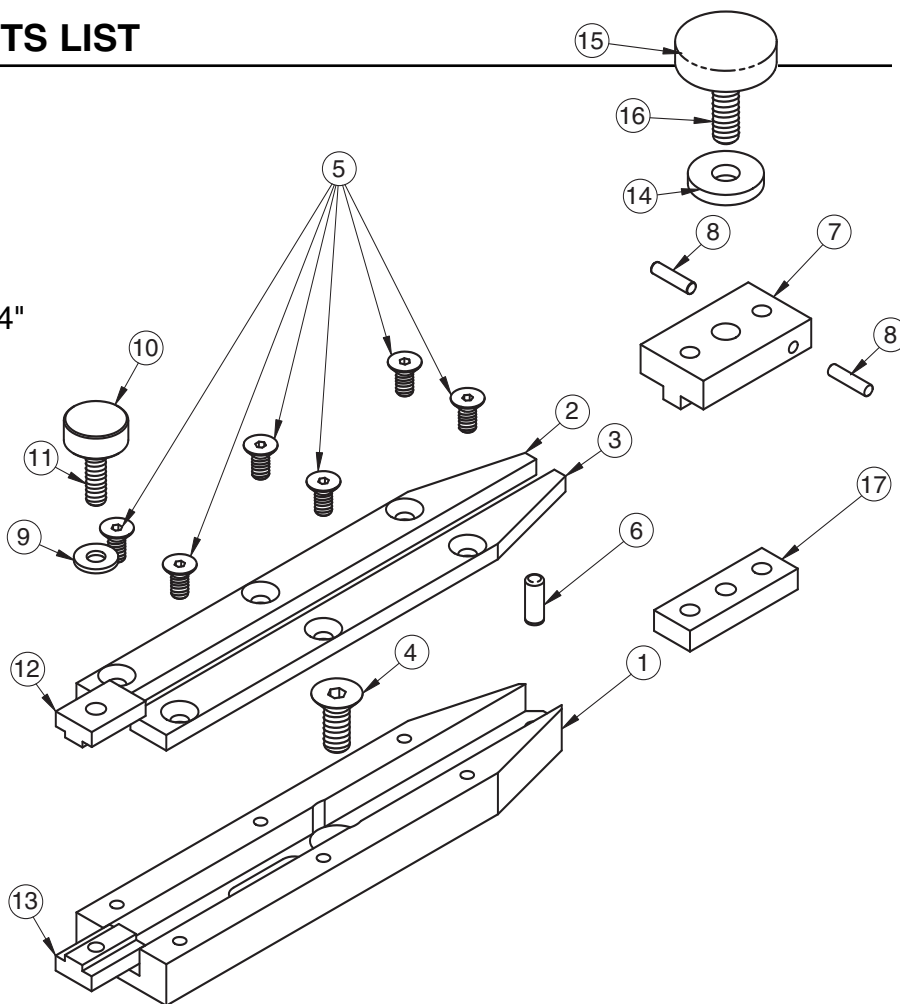


To grind the secondary relief and clearance angles, adjust the desired angle on the table's side protractor and set the stop pin forward a small amount and grind one flute. Check frequently to see how much material is being removed. If not enough and you are against the stop pin, move the pin inward. If you have removed enough and you are not against the pin, hold the tool against "stopped" wheel and reset pin stop. After establishing pin placement, do the other flutes.

# Accu-Finish<sup>®</sup>

## Tool Stop Guide #001-884 PARTS LIST

- 1 011-186 Base
- 2 011-184 Left Top Plate
- 3 011-185 Right Top Plate
- 4 002-173 1/4-20 X 1/2" FHSCS
- 5 002-175 #8-32 X 3/8" FHSCS
- 6 002-508 Dowel Pin - 3/16" X 3/4"
- 7 011-183 Large Tee Block
- 8 002-988 Round-End Pin
- 9 002-110 Washer
- 10 002-172 Knob
- 11 002-288 #10-32 X 5/8" SHCS
- 12 011-181 Small Tee Block
- 13 011-180 Small Tee Nut
- 14 002-307 Washer
- 15 002-136 Knob
- 16 002-490 1/4-20 X 7/8" SHCS
- 17 011-182 Bar Nut



### OTHER ACCU-FINISH PRODUCTS AVAILABLE

#### Collet Block

- #001-881 Square 5C Collet Block
- #001-885 Hex 5C Collet Block

#### Alignment Fixture for Collet Blocks

- #001-927 Alignment Fixture

#### 300 Reverse Angle Diamond Wheel

- #011-113 320 Grit Rev. Angle
- #011-087 600 Grit Rev. Angle
- #011-088 1200 Grit Rev. Angle

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