

# VERMEC SHEAR SCRAPER SHARPENING INSTRUCTION SHEET



Pic 1-Grinding Mandrel

## Step 1

Hold grinding mandrel (Pic 1) in left hand with reduced diameter end facing up.

## Step 2

Place cutter on grinding mandrel (Pic 2) with cutting face pointing downwards



Pic 2-Grinding Mandrel and Cutter

## Step 3

Place retaining bush over reduced end of grinding mandrel to hold cutter (Pic 3). This retaining bush is used to apply pressure to the cutter so it is free to rotate whilst cutter is being ground. Apply just enough pressure so that when the cutter is in contact with the grinding wheel it is just free to rotate. Using the bush as a brake, ensure cutter does not spin too fast or stop rotating.



Pic 3-Grinding Mandrel, Cutter and Retaining Bush

## Step 4

While holding the cutting mandrel at  $45^{\circ}$  to the spindle of the grinding machine bring the cutter to touch the grinding wheel. While maintaining  $45^{\circ}$  bring bottom hand out until the whole face of the cutter is in contact with the grind stone. (Pic 4 and Pic 5)



Pic 4

## Step 5

Using the retaining bush, adjust pressure on cutter until it rotates freely whilst grinding. When there is too much pressure applied the cutter will stop spinning and form a flat spot. When there is not enough pressure the cutter spins too fast to be sharpened effectively. With practice you will become familiar with optimum pressure required.



Pic 5

## Step 6

After a few seconds you can remove the assembly from the grinding wheel and inspect cutter. If necessary repeat the procedure.

## Warning:

**Care must be taken. Always wear eye protection. Keep fingers away from spinning wheels. The grinding activity generates significant heat so caution is required.**