



# Standard Tilt Table

## BEVEL GRINDING

### Assembly AND How-TO USE

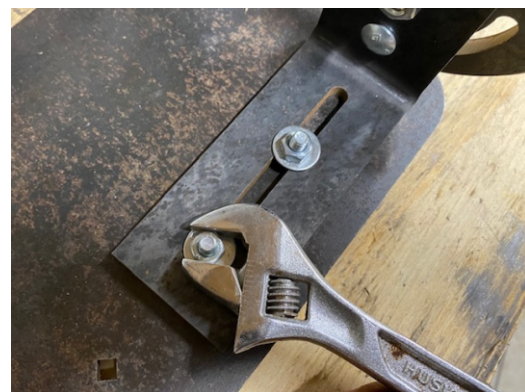
The Standard Tilt Table comes with everything you need. Table, Angle iron, Pivot arm and all hardware. Please note Tooling Arm is sold separately.



Step 1 Grind belt relief on back side of belt as shown. This can be done with an angle grinder or 2x72 belt grinder. Leave 1/16 to 1/8 thickness at the edge.



Step 2 Angle iron gets secured with two carriage bolts, washers and nuts. Pivot arm is secured with a 3/8 bolt, lock washer and nut. Locking handle screws into remaining carriage bolt.

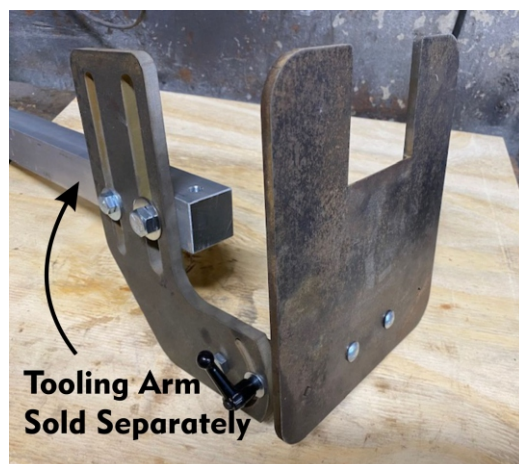


Do not over tighten the 3/8 nut. You want to be able to adjust the angle of the table with a little resistance from the lock washer compression. When lock handle is tightened table should be rigid.



Finished assembly is ready to mount into second tooling arm slot of 2x72 belt grinder. Please watch our how-to video which shows how to position, square and start grinding beautiful bevels.

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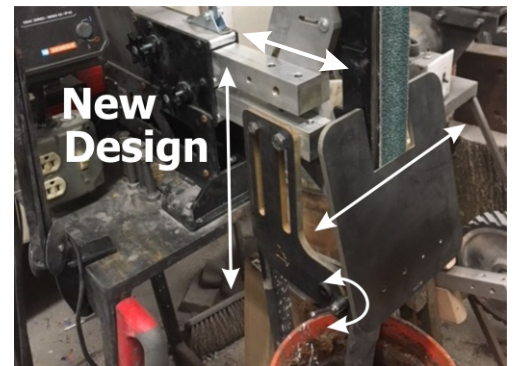
# Easy Tilt Table



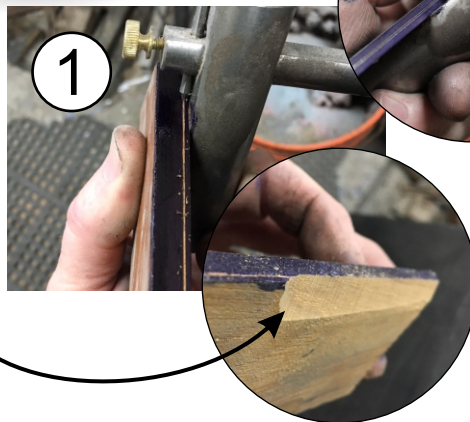
## Bevel Grinding

The Tilt Table mounts to a standard 1 1/2 inch tooling arm. It was designed for OBM grinders but is adaptable to fit a wide range of different manufacturers 2x72 belt grinders. Use adjustments to center table cut out on platen and square table to platen.

Center Line Scribe used to mark parallel Railroad Track lines on blades edge.



One trick of the trade when setting up the Tilt Table is to scribe a center line on a scrap of wood. Then test grind a bevel into the wood to see if the bevel is wide enough for the blade.



Corse grit belt.



2

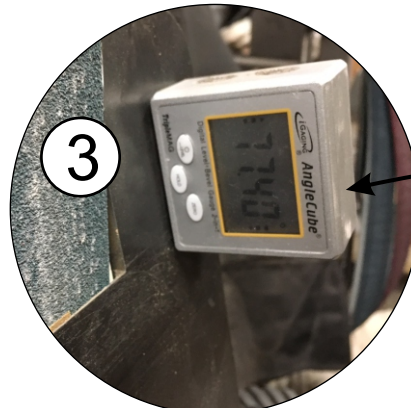
Hold the blade flat against the Tilt Table and then slowly bring it up and into contact with the grinders belt. The blade can then be moved horizontally. Its important to keep a little pressure against the blade to hold it flat against the table during all grinding. Use a corse grit belt to remove the bulk of the material. Then change to a finer grit to finish the bevel.

Fine grit finishing belt.



Keep a close eye on the scribed center lines. A consistent grind along these lines will result in a bevel that will follow the profile of the blade.

3



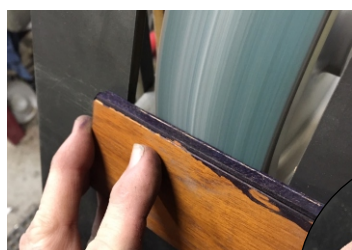
A digital angle meter can be used to reset the Tilt Table to desired angle for post heat treating bevel polishing.



# Large Wheel Tilt Table Hollow Grinds



Adjustments on the Tilt Table allow it to be positioned for hollow grinding on a large contact wheel.



We recommend beveling a scrap piece of wood to confirm bevel width is set accurately.



1

Start by holding the blade flat against the table and then bring it up into contact with the belt.



2

Maintain pressure to keep the blade flat while pulling it horizontally across the belt. As with flat bevels, it's very important to accurately grind evenly up to the scribed lines.



3

A finer grit belt can be used to polish the bevels.

