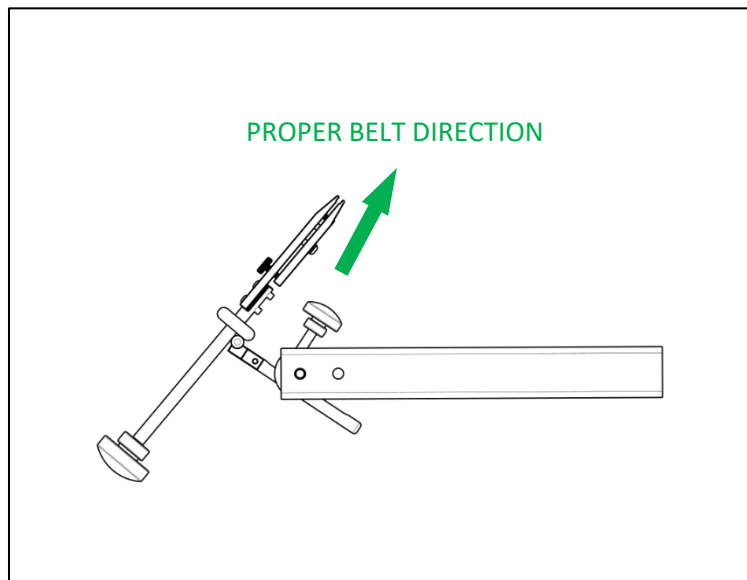


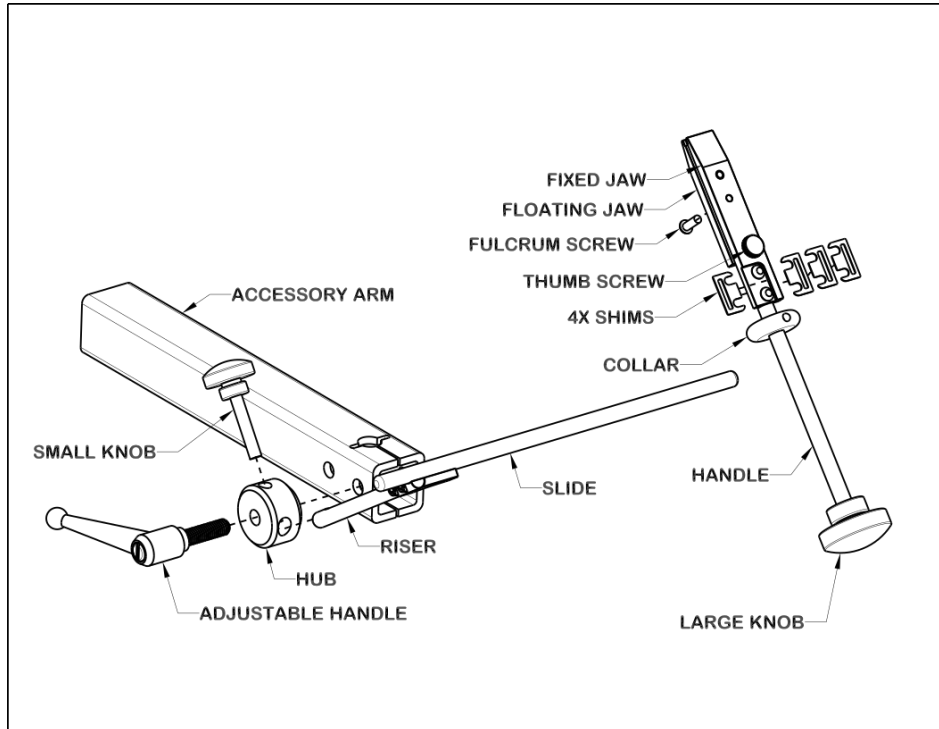
# SHARPENING ATTACHMENT



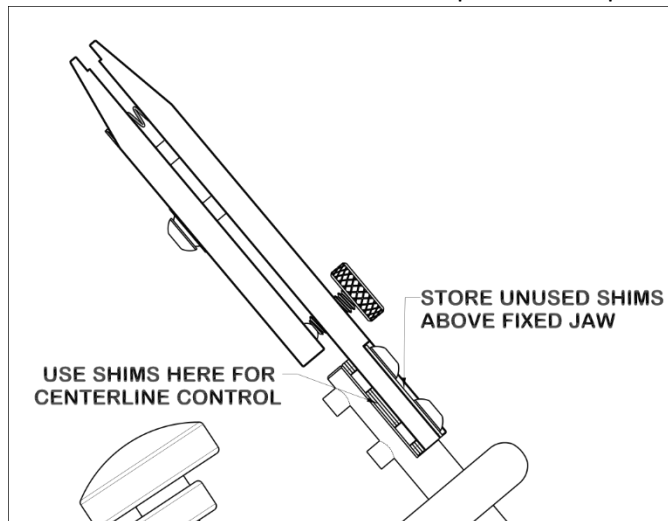
- **CRITICALLY IMPORTANT: BELT GRINDER MUST BE RUN IN REVERSE (BELT RETREATING FROM CUTTING EDGE) IN ORDER TO PREVENT SERIOUS INJURY TO THE OPERATOR OR DAMAGE TO THE EQUIPMENT.**



EXPLODED VIEW:

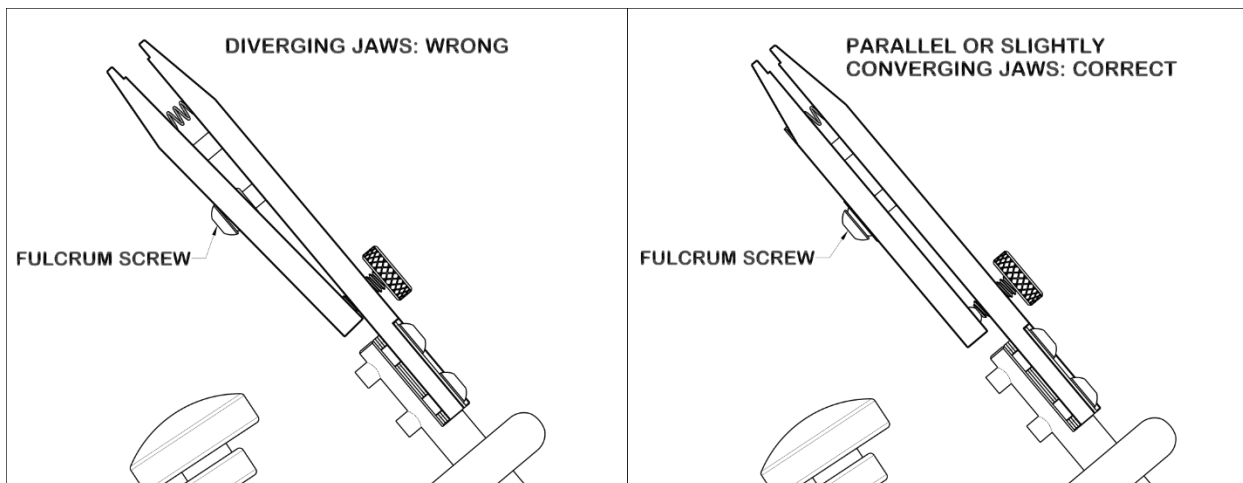


- If the blade to be sharpened needs a symmetrical edge ground on both sides of its centerline, place the proper number of shims between the handle and the fixed jaw based on the thickness of the blade. See Chart Below. Store unused shims in the pocket on top of the fixed jaw.



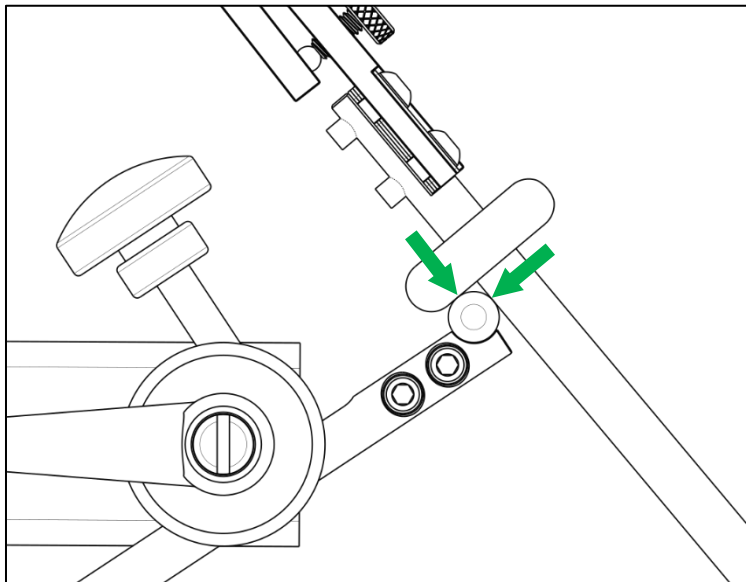
Blade Thickness	# of Shims
.000 in - .031 in	0
.032 in - .094 in	1
.095 in - .156 in	2
.157 in - .219 in	3
.220 in - .281 in	4

- Before clamping on the spine of the blade, take any necessary precautions to protect the finish of the blade such as tape, or the provided rubber strip. Take this thickness into account when choosing the proper number of shims in the previous step.
- Use the thumb screw to tighten the clamp on the spine of the blade
  - For best clamping results, make sure the jaws are parallel or slightly converging towards the clamping end. If the jaws are diverging towards the clamping end, correct the issue by loosening the fulcrum screw. If the jaws are converging at an excessive angle, tighten the fulcrum screw. See below



- Set the collar position along the length of the handle shaft for your situation. In general, the further away the collar is from the blade, the easier it will be to achieve a consistent result because the extended length makes the angles less sensitive to small movements. However, for blades with a lot of curvature, it is sometimes necessary to bring the collar up close to the clamp. Practice will make it clear what works best for your blade shapes. Typically, this setting is the least important.
- Set up a grinding accessory such as a hard flat platen, rotary platen, radius platen, slack attachment, contact wheel etc.
  - For platens, we recommend setting the angle leaned as far back as possible for the best comfort and visibility.
- Install the sharpening accessory arm in the remaining receiver slot of your belt grinder.
- Use the adjustable handle and small knob to roughly position the slide in a position that works for the accessory you have chosen.
- If you know what bevel angle you are trying to achieve, you can use a digital inclinometer to measure the angle between your grinding surface and the fixed jaw.

- If you are trying to match an unknown angle on a previously sharpened knife, we recommend marking the bevel with a sharpie and turning the belt by hand to interpret what adjustments need to be made based on where the sharpie has been removed and where it hasn't.
- Use the adjustable handle or the small knob to make any angle adjustments.
- With the grinder turned off, make a few practice passes across the belt to familiarize yourself with what the motion will feel like. Every knife requires a slightly different technique. Use one hand to control the handle of the knife and the other hand to guide the sharpening handle.
  - To achieve a consistent angle, you must keep the slide seated in the corner of the handle and the collar. Contact indicated by arrows in image below.



- Run the belt in reverse at a low speed and begin sharpening with whatever belts suit your chosen sharpening procedure. Flip the knife over frequently making passes on both sides to monitor symmetry.
- After an apex is reached and a burr is established, we highly recommend finishing and maintaining edges with a 2x72 leather strop. Polishing compound should be applied to the fuzzy side of the leather facing out.
- **CAUTION:** While making passes, do not run the tip of the knife all the way off the edge of the belt. Stop the motion of the pass and lift pressure off the belt when the tip reaches approximately the center of the belt. This is for a couple reasons.
  - 1) Running all the way off the belt-edge increases the likelihood of catching the belt-edge or the side of a wheel with the blade tip and throwing the blade.
  - 2) Running all the way off the belt edge makes it very likely you will over-grind your tip because of how little surface area is in contact with the belt at that point. The concentrated pressure on that small area will remove material very quickly.
- **BONUS TIP:** Be aware of your handle material. While focusing on sharpening, it is common to accidentally grind a notch in your handle if care is not taken.