

How has been milling cutter ground know? Almost erraa



How can ability grind good milling cutter?

Before grinding a knife, need undertakes checking to emerywheel, if discover emery wheel is jumpy, columnar, irregular, round horn crosses the face to wait for a circumstance greatly, undertake nap with respect to need. Can amend with emerywheel commonly implement (diamond nap implement, age a napimplement etc) undertake nap to the columnar face of emerywheel, yi Ke uses the hardness that wear bead to undertake naprelative to larger useless old emery wheel. If plane of emerywheel side is already rough whole, can change emery wheelpiece.

Establish blade of milling cutter end panel to grind a technology:

1, the technology that troubles end panel of Ping Lixi knife.

Without giving thought to of how many blade establish millingcutter, want above all edge end panel perpendicular grind at axessmooth, this is to make sure edge apogee can lie the key ofsame plane. Photograph of corrective edge end panel is likelower part law to the verticality of milling cutter axes.

? range estimation. But have the aid of one flat, transfer to alower level of day of edge of Jiang Lixi knife is on flat, thebanking angle that observes the left and right sides is spent. Rotate milling cutter next 180 ° observe its control banking angleto spend again. If be in, the banking angle that observes with onone direction two differs, need to repair grind, till the bankingangle that till be the same as one direction on two times, observesis identical. Rotate milling cutter again later 90 ° , repeat aboveact.

? uses square corrective. 90 ° square is used on one flat corrective, put milling cutter and square the observation after making the same score whether there is space between milling cutter and squareor clearance is even, judge the verticality that gives milling cutter according to clearance next, undertake repairing grinding to milling cutter.

