

SAFETY MAINTENANCE

KNIFE GRINDING

The time between knife grinding will vary with the type of wood and operating conditions. Sharp knives are very essential to good chip quality and nothing is gained by running the chipper with dull knives. Indications of dull knives are poor chips, excessive oversize, fines and poor feed characteristics of chipper. A few more hours chipping may sometimes be gained by hand honing the knives while still in the disc.

The chipper knife is factory ground to a 31° bevel. There are exceptional conditions where the angle may vary from 29° to 31° to improve performance.

IMPORTANT - Angle should never exceed 31°.

The most suitable angle for any particular condition can only be determined by the trial and error method right on the job.

To achieve longer knife life, follow these steps.

1. Grind the knives at 31 degrees.
2. Cut the very tip of the knife off by using a 10 inch single cut bastard mill file.
3. File the tip down to the width of a ball point pen line thickness (approx. .008) . This can be done with a couple of passes of the file.
4. Using a file, sharpen the backside of the flat side of the knife to a 45 degree angle off the front edge.

