

## **Grinding and honing the mitring blades**

The grinding and honing of the mitring blades is very important and it must normally be undertaken by a professional saw or tool grinder.

It is possible to 'flat' or 'hollow' grind the blades but 'hollow' grinding produces the best finish but only the angled surface of the blade must be ground, not the front or back or ends.

Always have your blades ground in pairs even though only one maybe damaged.

Because accidents can happen at any time, it is normal practise to have a spare pair of blades always ready for immediate replacement.

The cutting angle of the blade is 30 degrees

It is essential that after grinding, the blades are honed to remove any sharp edges and this includes honing the actual cutting edge of the blade.

Honing not only removes any burrs but also produces a very even cutting edge which produces the finest finish when mitring

**Always take care when handling mitring blades due to their extreme sharpness and weight**

## **Changing the mitring blades**

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It is essential that the mitring blades are kept in good condition. As soon as the finish of the mitring deteriorates or any damage is caused to the blades they must be taken off and re ground.

### **Removing the Blades**

**Care must be taken due to the sharpness of the blades**

Undo the 3 screws 020, in each blade, a spanner is provided.

Remove the top and bottom screw and then press the blade against the Mitring Head whilst removing the third screw.

Remove the blades carefully and put them in a safe place.

### **Before fitting the new or reground blades**

Clean the surfaces of the Mitring Head and the blades so as to ensure that no dirt is trapped between the blades and the Mitring Head when the new or reground blades are fitted

### **Fitting the new blades**

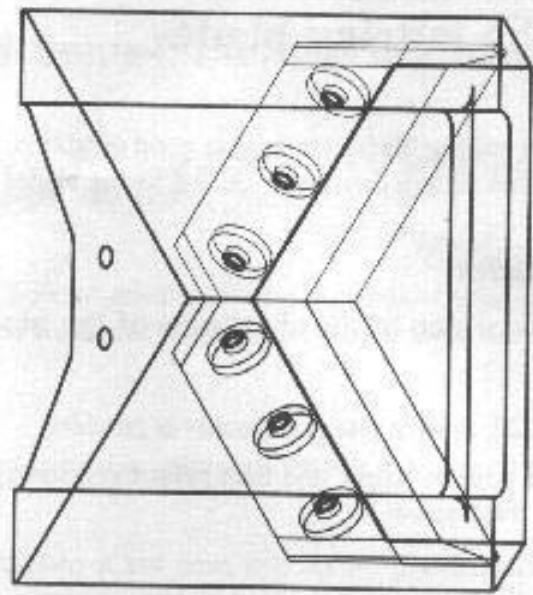
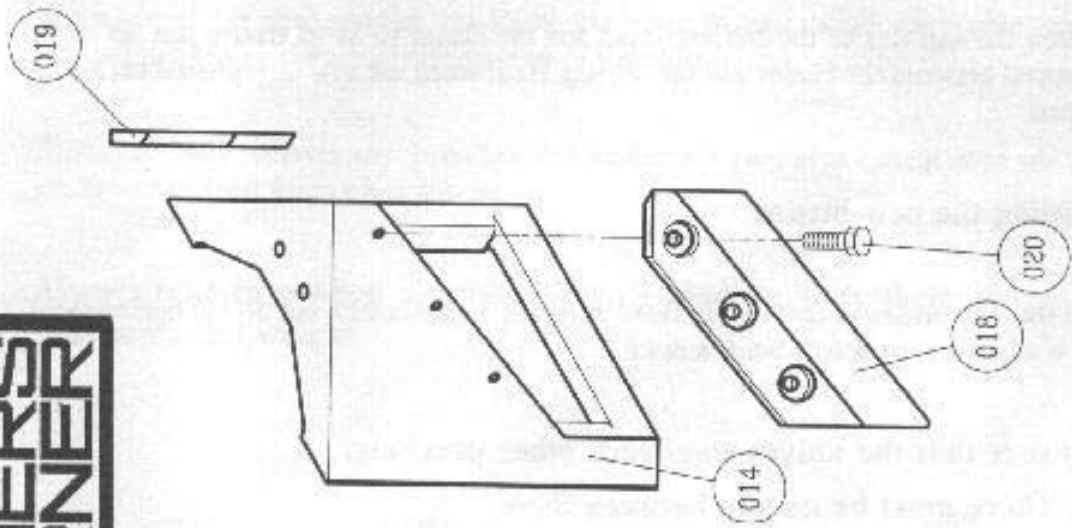
Fit the new blades to the Mitring Head using the 3 screws 020 but do not tighten them. It is advisable to replace worn screws.

**Ensure that the knives meet each other precisely.**

- 1. There must be no gap between them,**
- 2. Neither blade must protrude ahead of the other one**
- 3. The cutting edges must come together exactly**

Tighten the holding screws starting with the top screw in each blade, then the middle screw and then the lower screw .

Make a trial mitre and check.



**Figure 7**  
**Changing the Mitering Blades**