

# SLUGGER® CUTTERS RESHARPENING

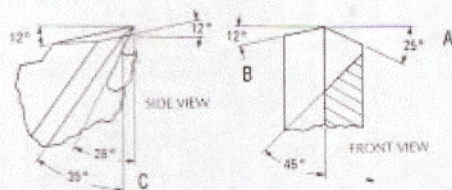
By Jancy

## RESHARPENING CUTTERS $9/16"$ — $13/16"$

Jancy SLUGGER® Cutters may be refaced to maintain sharpness and cutting ability. Complete resharpening to restore or maintain the rake angles should be done by a qualified professional in accordance with the shown diagram.

### Resharpen Instructions

- (1) Sharpen inside angle (A) removing only enough stock to resurface cutter's edge.
- (2) Sharpen outside angle (B) removing enough stock to return outside angle to 50% of total wall thickness.
- (3) Reform gullet area (C) only when base of gullet radius is no longer apparent. Gullet direction and depth are critical.

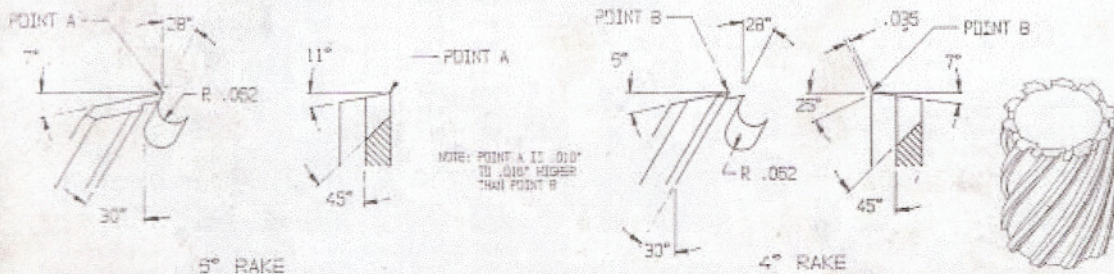


6 TOOTH CUTTER SHOWN



## RESHARPENING CUTTERS $1\frac{1}{4}"$ (31 mm)— $3"$

Jancy SLUGGER® Cutters may be refaced to maintain sharpness and cutting ability. Complete resharpening to restore or maintain the rake angles should be done by a qualified professional in accordance with the shown diagram.



### Resharpen Instructions

Sharpen teeth alternately, every other cutting edge, using diagram A; sharpen opposite cutting edge using diagram B. Note: Highest point on Grind A should be .010" above highest point on Grind B.

### Tips When Sharpening

- (1) Separate cutters in groups with like diameters and number of teeth.
- (2) Remove only small amounts of material - never removing more than .005 per pass. Excessive stock removal will anneal the cutter.
- (3) Do not try to sharpen out large chips in teeth. Do this over several sharpenings.

### Jancy Factory Resharpening

Jancy Engineering offers a factory quality remanufacturing of SLUGGER® cutting tools. Returning the cutting edges to the original geometry. Resharpen orders of 6 or more cutters qualify for paid 2nd Day UPS freight both to and from the factory, with a reliable return ship date available upon request. Consult your distributor for further details concerning factory sharpening.

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