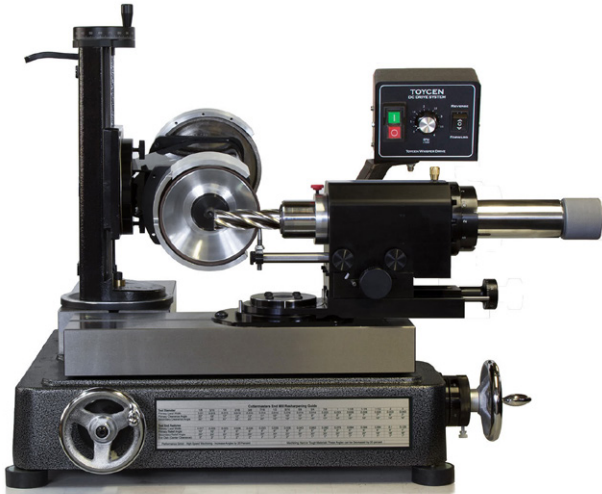


CUTTERMASTER Professional CM-01P

Technical Bulletin

December 14, 2017



Potential Movement During Radius Grinding

During radius grinding testing, in some instances, we've noticed that when the MK2 Radius Spindle is swung out at right angles to the x axis, there may be a lift experienced at the tool. This is caused by a tipping of the pivot plate which causes the wheel to take a bite out of the end of the tool.

What Causes the Movement?

The movement, which we measured to be around 0.0015", could be caused by the top of the way not being flat or by the bottom of the pivot plate having some roundness.

How To Address This Issue

We have addressed this issue by adding a pocket to the middle area under the pivot plate (see attached drawing). If you find this is happening please report it to us and we will provide you with a new base plate.

Alternatively, a quick fix is to place a .002" shim under the pivot plate (Figure 1), at the outside edge to the x axis table. Both fixes removed the potential for this small rocking movement.

[Watch a Video](#)

[Watch a video that shows how we checked for this movement and how we fixed it using a shim.](#)
[Click here, or find it at this url https://youtu.be/0zYzlaCvnV8](https://youtu.be/0zYzlaCvnV8)

Call Us

If you have any questions on this or any other tool grinding matter please give us a call.

Cuttermasters
(800) 417-2171

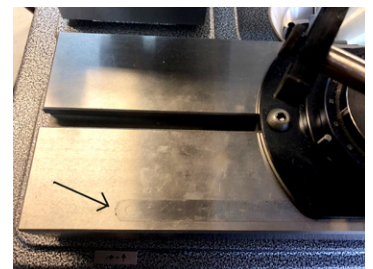
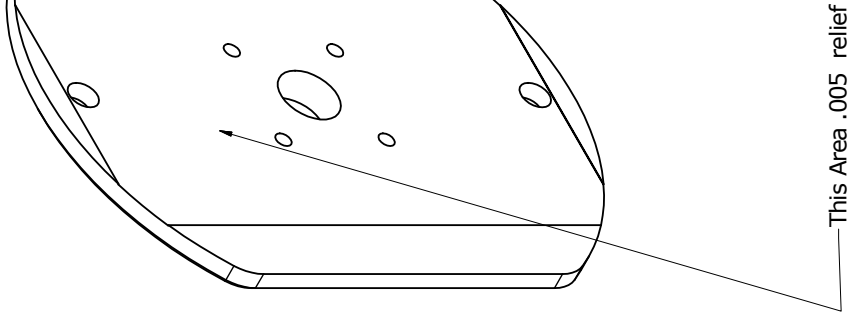
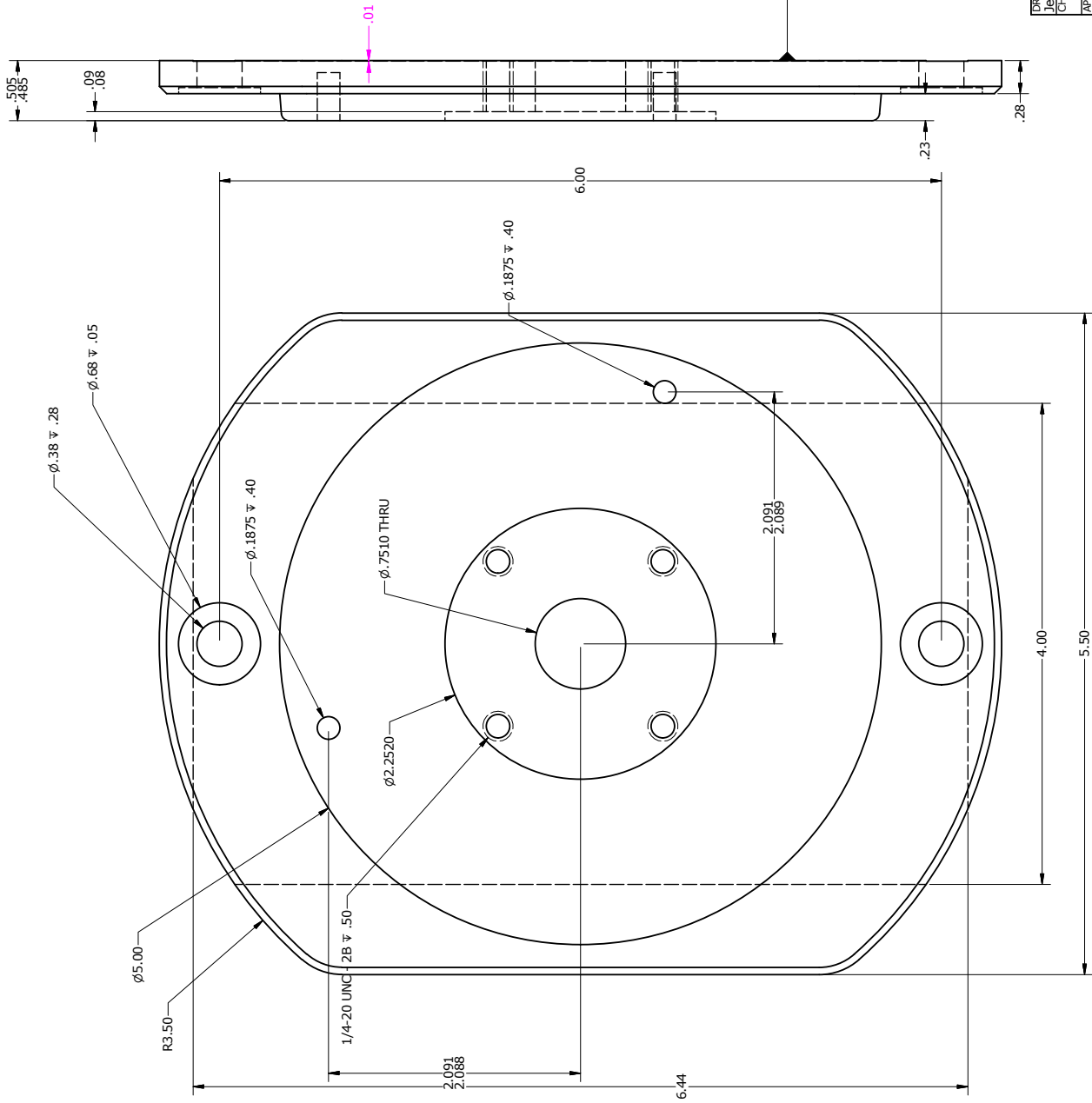


Figure 1

Alum T6 Black Anodized



DRAWN	DATE	<p>This drawing is the property of Toycoen Tool Grinding Systems, Inc. and is not to be used in part or committed to third parties without specific written permission from Toycoen.</p> <p>Toycoen</p>
CHECKED	TITLE	
APPROVED		
<p>UNLESS OTHERWISE SPECIFIED: DRAWINGS ARE IN INCHES (mm). LINEAR TOLERANCES ARE: .X = ± 0.5° .XX = ± 0.1° .XXX = ± .005</p>		<p>THIRD ANGLE</p>
<p>SURFACE FINISH: $\sqrt{25}$</p>		<p>SCALE: 1 OF 1</p>
<p>DO NOT SCALE DRAWING</p>		<p>REV 2</p>
<p>SIZE DWG NAME</p>		<p>C 070-0476-1002 -BASE- PIVOT</p>