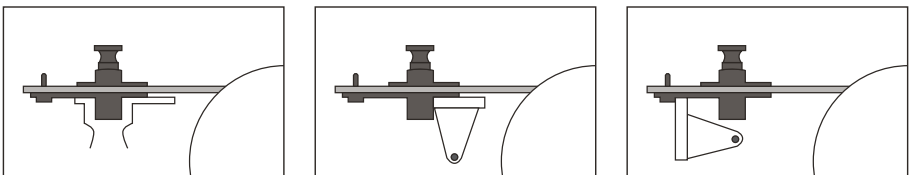


1. For 90° square grinding, place the alignment pin behind a clamping screw. For 30° skew grinding, place the clamping screws in the front inside screw positions and the alignment pin in the far right position.
2. Clamp the chisel or plane blade loosely in the jig, butting the tool against the alignment pin and the appropriate clamping screw.
3. Place the jig on the tool rest and adjust the projection of the tool so that it rests on the grinding wheel at the desired bevel angle.
4. Turn the left screw until it is snug on the tool, then tighten the right clamping screw. Make sure the tool and clamping bar are level when tight. This lever action of the clamping bar allows you to rigidly clamp your tools with normal hand pressure.
5. Tilt the jig up, turn on the grinder and lower the tool tip to contact the grinding wheel.
6. Using light pressure, slide the tool back and forth across the wheel face until it is fully ground.
7. Remove and strop or hone as desired.

For power grinding of carbon steel tools, it is important not to overheat the tool, as this will soften the tool edge. Use light pressure and check for heat build-up. If you do a great deal of grinding, it is worthwhile to invest in a proper wheel with an open structure and a soft bond. A good choice is a white aluminum oxide wheel (coded A80-H8) with a vitrified bond.

*The Veritas® Grinding Jig works with any power grinder that has a tool rest with one edge parallel to the wheel face.*



*Can be used on a tool rest from 3 different positions.*