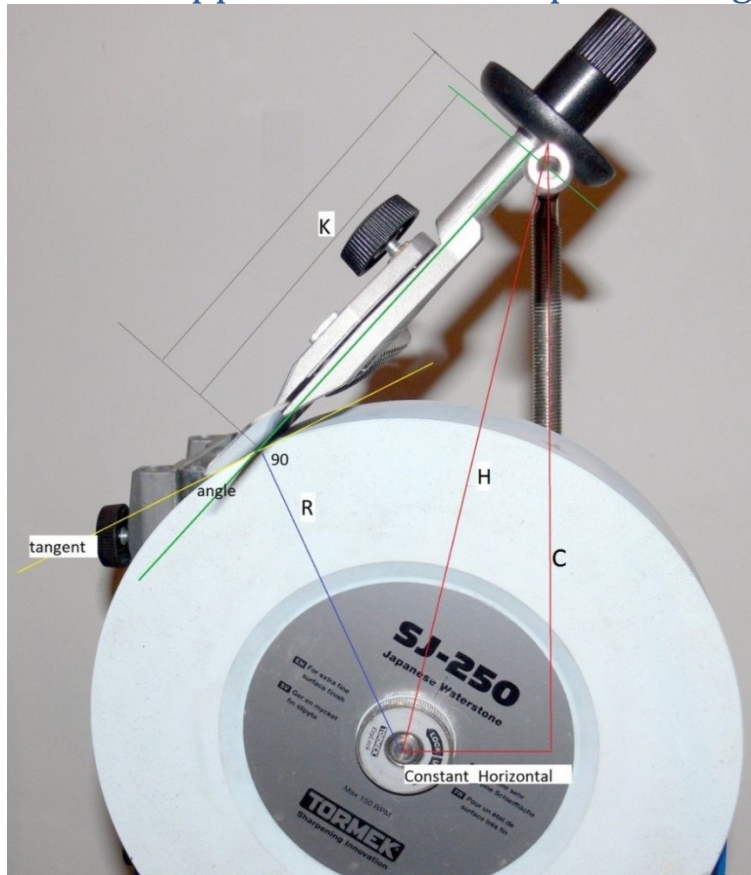


Computer Software
 Scientific approach for an exceptional edge



We use computer software to set a desired grinding angle. This software comes especially handy when you use several progressively finer grinding wheels of different diameter, and as you change to the next wheel you have to adjust height of the Support to maintain the same grinding angle. Time-wise it is quicker than any other method.

Jig-Support-Wheel relations are shown on the sketch. The Support height for a given grinding angle can be calculated by Pithagorean theorem; the right-angled triangle used in the calculations is shown in red on the sketch.

Hypotenuse is calculated by the formula:

$$H^2 = K^2 + R^2 - (2 \times K \times R \times \text{Cos}(90 + \text{Grinding_Angle}))$$

and the other triangle side (Constant_Horizontal) is a distance from the Support centerline to the shaft centerline.

Support height from its base (i.e. the housing top) to the top of the support bar, for a given grinding angle = calculated value for the vertical **catetus C minus** distance from the shaft centerline to the Support base (Constant_Vertical).

You can obtain Windows applet in the Sharpening Shop on our website. iPhone and iPad applets, as well as the MacBook applet can be bought from the App Store. Android phone & tablet applets can be bought from the Google Play. Search for **Angle Setter for Jet JSSG10**

This software sets angle grinding into the wheel, against wheel rotation, as shown on the following picture



Applet Installation

Extract (unzip) the download.

WINDOWS 7-10+ This applet runs on Windows 7, Windows 8, Windows 10 and future Windows OS. Run by clicking the **Jet_Angle_Setter** and click Install when prompted. This installs and runs the applet, and the application can be uninstalled via Add/Remove Programs.

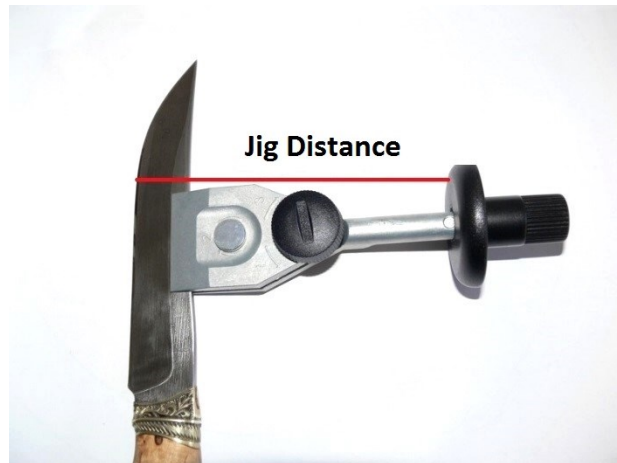
How to use the applet

A screenshot of a software window titled "Grinding Angle Setter for Jet J55G-10". The window has a standard Windows-style title bar with minimize, maximize, and close buttons. The main content area is titled "About" and contains the following fields and controls:

- Enter the grinding wheel diameter in mm:
- Enter distance between the knife jig adjustable stop and the knife edge in mm:
- Enter the target grinding angle:
- (For double-bevel blades, the grinding angle is half of the included edge angle)
- Support bar height in mm:
- (Vertical distance from the top of the bar to the housing.)
- A "Calculate" button is located to the left of the support bar height field.

You have to take two measurements in mm – you will need them for applet input:

1. Wheel diameter, which is 250 mm in a new grinding wheel.
2. Having mounted the knife in the knife jig, measure the distance between the knife jig adjustable stop (the black plastic part) and the knife edge in mm, shown in the following photo.



Run the application, enter the wheel diameter, jig distance and the target grinding angle in degrees per side, and press the Calculate button.

For your target grinding angle, the applet will give you the Support bar height as a vertical distance from the top of the bar to the housing.

The Support bar height is set with the help of a caliper depth probe.



When we sharpen a batch of knives at the same angle, and keep the distance between the jig adjustable stop and the knife edge constant as we clamp new knives, we have to recalculate the Support height for a given grinding wheel only after truing that wheel. If for whatever reason we change the clamping distance, or have to sharpen at a different angle, we recalculate the Support height.

We've been using the applet for setting a grinding angle for years, verifying the edge angle with a CATRA laser protractor in the end of grinding for QA, and this software has never failed.