

## Setting The Grinding Fixture

When all chasers of the set have been moved ahead and locked on their blocks for grinding, put the chaser and block into the proper size adapter, which has been clamped by the screw in the center slot of the Chaser Grinding Fixture.

All adapters are designed to hold a chaser at a twelve degree angle for grinding the chip clearance angle.

Correct setting of the chaser for grinding the hook angle is obtained by turning the grinding fixture head to the desired angle reading on degree scale of fixture head bracket and tightening clamp screw.

The face angle setting is made by turning the fixture on its base and tightening base lock screw. To grind the correct face angle of 1 degree 30' on the Chaser and Block assembly. If the hook angle is increased by 5 degrees the base reading should be advanced by 1 degree.

