

2010

Metric Conversions

MM x 0.03937 = Inches
 Inches x 25.4 = MM
 Grams x 0.03527 = Ounces
 Ounces x 28.349527 = Grams

EAGLE ROCK[®]
 TECHNOLOGIES

Wettstein Tool[™]

Grinding Accessories

No. A1-205

Endmill and Shellmill Grinding Fixture

The original WETTSTEIN TOOL grinding fixture for regrinding Endmill and Shellmill faces on your surface grinder. Uses standard 5C Collets. The 5C spindle indexes to accurately position the cutting edge to be ground. All angles are built into the base. Available with 15° or 36° indexing.

Tooler's Classics[™]



6

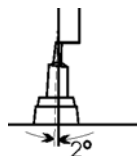
Primary End Relief

To grind primary end relief and center relief, place end mill in fixture and grind one flute. Then index to grind opposite flute. This will give a 5° primary end relief angle.



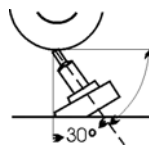
Center Relief Angle

This view illustrates position of wheel at start of grinding position and center relief angle 2°.

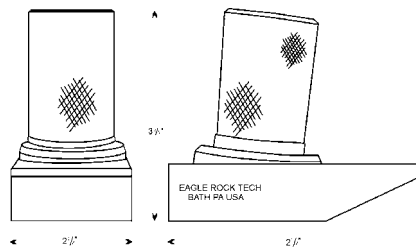


Secondary End Clearance

To grind secondary end clearance, tip fixture [as shown] using same wheel position as illustrated at left. This gives a secondary end clearance of 30°. The tool will index to allow grinding opposite tip.



Shellmill arbors on page 5-6 are required for grinding Shellmills.



	Flutes	Index	Cat. No
Endmill Grinding Fixture	2-3-4-6-8-12	15°	A1-205-00
Endmill Grinding Fixture	5-10	36°	A1-205-10