

WKW

Grinding Carbide Inlayed Corrugated Knives

Grinding carbide inlayed corrugated knives will require a different grinding wheel if you are now grinding HSS or solid carbide Bak-Pak®. When grinding carbide inlayed knives the grinding wheel needs to cut through three materials, the first being a very soft grade of steel, the second a braze material, and the third being a hard carbide. A diamond wheel will work but will not perform real well. If a diamond wheel is being used, use a 150 grit wheel for best results.

A CDX grinding wheel works best with the grinder RPM set to its highest speed but not exceeding the maximum RPM recommended for the wheel. Using a 120-220 grit wheel works best with the finer grit size producing the finer cutting edge grind. A CDX wheel is a synthetic diamond wheel that uses a “block or blockier” diamond with a more open grain structure. When grinding any carbide keep in mind that it will take more time and the wheels will be more expensive. It is important to know that when grinding carbide inlayed knives, the wheel works best if it is not forced. Set up the knife grinding process by adhering to the old common phrase **“Let the wheel do the work”**. This will allow the wheel to perform at its best and last the longest. If the grinding wheel seems to cause burning and is not grinding properly, the wheel needs to be cleaned with a dressing stick. It would be a good idea to clean the wheel frequently with a dressing stick similar to the Norton 38A220-H8VBE or 38A150-I8VBE.