Diamond Truing Tool, ADV-50D

Trues the grinding surface exactly round and flat.

Positioning of the machine

Grinding direction: towards the tool.

Design

The cutting tip (1) consists of diamond grains embedded in a copper cylinder. The grains are positioned like “raisins in a cake”. During use, the soft copper will be worn and the diamond grains will stick out as peaks on the surface. Worn grains will after a period of time be replaced by new ones. This design gives a long life to the tip.

The tip (1) is mounted in a handle (2) with a screw (3). The cutting depth is controlled with the stop (4), which is locked with two knobs (5) onto the Universal Support.

The grindstone is trued exactly round because it is cut in its working position on the shaft. The cutting of the stone is guided by the Universal Support, which also guides the jigs. This ensures that the surface of the stone is parallel to the tool fitted in the jig.
**Truing**

Let the stone run until it has become fully saturated then stop the grindstone.

Set and lock the Universal Support approx. 10 mm (3/8") from the stone surface.

Mount the stop (4) and the handle (2) on the Universal Support as illustrated.

Set the cutting depth (t) while the stop rests upon the truing tool’s handle.

**Important!**
Max cutting depth (t) is approx. 0,6 mm (0,024"). Tighten the two locking screws securely.

Start the grindstone. Let the handle touch the stop with light pressure, and feed slowly sideways by pressing the thumb.

Start the turning from both sides of the stone to eliminate the risk of cracks on the edge of the stone.

The diamond grains in operation can occasionally be on one side (a) of the tip surface. Then loosen the mounting screw (3) and turn the tip 90° (b).

The remaining grooves are removed using the coarse side of the Stone Grader SP-650.

**Note:**
- **True the grindstone immediately if you notice any lack of trueness.** This will increase the life of your grindstone. Even a slight out of true will automatically be increased if you continue grinding.
- **Feed slowly across the stone for finest grooves.** Use 1,5 to 2 minutes for moving across the stone. A slow feeding movement is also easier to control.
- **The handle should not be pressed too hard upwards against the stop,** to ensure that the stop is not moved from the pre-set position.