

## 1. CARBIDE TEETH

Sharpen teeth without removing them from the machine using a 4" disc grinder with a diamond sharpening wheel. Make certain tooth area is clean and free of debris prior to proceeding. Grind following the slant of the tooth. Process will take about an hour of time. Clean and grease on completion. Note: The diamond wheel is available as Cee-Jay Tool part # 99-S-10012.

Sharpen teeth after removing them from the machine using a disc grinder with a silicon carbide "green" wheel. Make certain tooth area is clean and free of debris prior to proceeding. Care should be taken to avoid damaging the shank of the tooth when stabilizing for grinding. Grind following the slant of the tooth. Inspect top & bottom grease seals for wear and /or damage. Replace if necessary prior to reinstalling teeth.

Note: These wheels are only available in larger sizes (10" or so) and while the actual sharpening is much faster, more time will be required to complete the process due to pulling and reinstalling the teeth.

## 2. TOOL STEEL TEETH

Sharpen teeth without removing them from the machine using a 4" disc grinder with a standard 80 grit wheel. Make certain tooth area is clean and free of debris prior to proceeding. Grind following the slant of the tooth. Process will take about an hour of time. Clean and grease on completion.

Rebuild teeth after removing them from the machine using a DUR600 hard face rod manufactured by UTP (Bohler Thyssen). Remove all foreign material from the welding area. Preheat tooth to 500 degrees F. Weld then allow the tooth to cool slowly in sand. Grind a new point following the original slant of the tooth using a disc grinder with standard 80 grit wheel. Care should be taken to avoid damaging the shank of the tooth when stabilizing for build up & grinding procedures. Inspect top & bottom grease seals for wear and /or damage. Replace if necessary prior to reinstalling teeth.

**NOTE:** This is a working process used by Cee-Jay Tool customers.