

GLENDO CORPORATION

Accu-Finish[®]

For the Advanced Machinist

SHARPEN • MAKE • MODIFY SPECIAL TOOLS

from Carbide, Ceramic, Cermets,
HSS & even some PCD/CBN
in Your Shop



NEW

Workspace Utility Shelf

HANDY FOR
Mills • Lathes • CNC

PAGE 18 - 19

NEW Versatile Accu-Finish SERIES ONE

- Reversible Spindle
 - Larger Table
 - MORE FIXTURES
- PAGE 8 - 9

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CATALOG

8

...ways Accu-Finish helps Top Machinists do the Impossible

1. Tool Making

Now you can make special tools like a toolroom expert and create the exact tools you want when you need them. Why limit yourself to standard tools when they don't fit your application, delivery schedule or budget? Get Accu-Finish.

2. Sharper Cutting Edges

Accu-Finish gives a sharper, finer cutting edge than other grinding methods. This lets your tools perform tasks that were impossible until now. Ultra-fine boring, plastics machining, micro-finishing, working with difficult and "gummy" workpieces are just some examples of the advanced machining you can do with Accu-Finished cutting edges.

3. Stronger Cutting Edges

Accu-Finish sharpeners do not heat the surface of tools thanks to their unique, low speed diamond sharpening process. As a result, there is no loss of temper or strength so tool life and performance are maximized. This technology works so well that resharpened tools often exceed the performance of new ones.

4. Improve Surface Finishes

Accu-Finish lets you mirror-finish tools in seconds. This means a better surface finish on your workpiece, lower cutting forces and reduced built-up edge on tools. Simple, fast geometry changes like adding a wiper edge to your tools can significantly improve workpiece finish as well.

2-STEP APPROACH TO

Grind-R-Table

fits your grinder



Turn your bench grinder into an accurate, effective way to rough shape and sharpen tools with BG Diamond Wheels and Grind-R-Table add-on tool guide systems.

BG Diamond Wheel

expands the capabilities of your grinder

5. Eliminate Chatter

Chatter is often caused by tool geometry or finish. In just 30 seconds you can optimize the geometry and finish of turning tools, boring tools and more. Now, instead of chatter controlling the machining operation, you're in control of chatter!

6. Accurate Geometry

Now you can quickly set compound angles for the precise tool geometry you want using Accu-Finish. The built-in scales are so accurate and easy-to-read that your tools can routinely pass an optical comparator inspection the first time.

7. Saves Money

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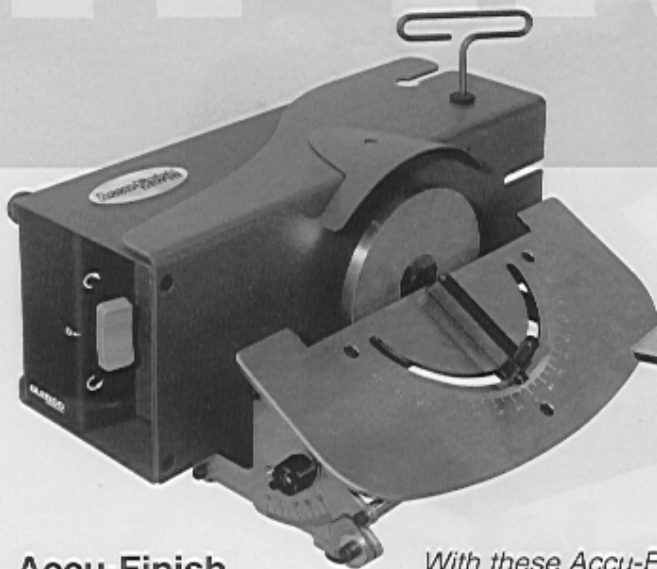
Imagine what double or triple tool life means in dollars to your shop. Consider how closer tolerances and improved part finishes can add to your productivity. And, think about making special tools in-house that allow you to do those impossible jobs without wasting your time. Accu-Finish saves you money so many ways. *Get one NOW!*

8. More Tool Materials

Because Accu-Finish can sharpen almost any tool material on the same wheel including carbides, ceramics, cermets, high-speed steels, even some PCD & CBN tools, you are free to use the best tool material for the job. No other sharpening system gives you this wide range of grinding capability.

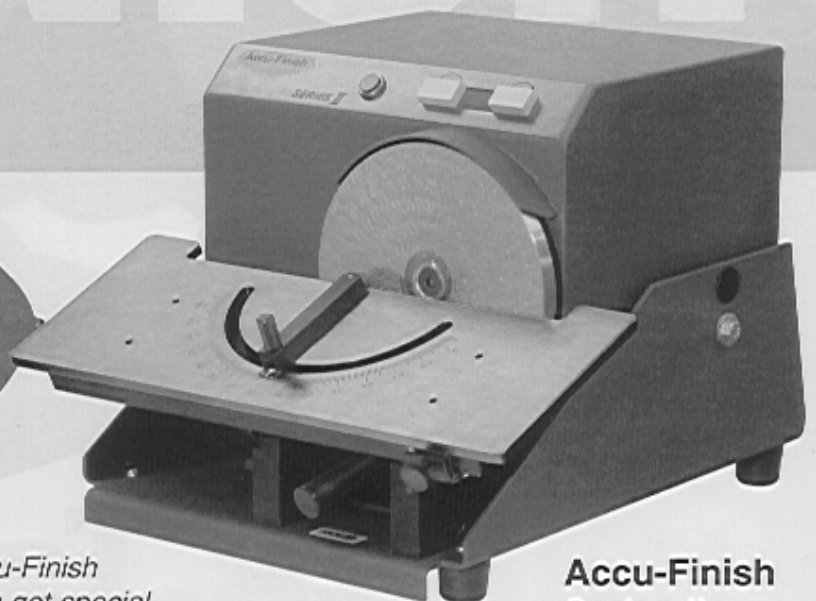
Accu-Finish®

Sharpening / Tool Making / Modification



**Accu-Finish
SERIES ONE**

With these Accu-Finish sharpeners you get special tool finishing capability unmatched by other grinders.



**Accu-Finish
Series II**

ROUGH

Use your bench grinder to rough shape OR remove tool edge damage. Grinders equipped with BG Diamond Wheels and Grind-R-Tables give the most accurate "rough" possible. For some, this step is sufficient for what they produce.



Grind-R-Table is easily removed!

Get the MOST out of YOUR Bench Grinder.

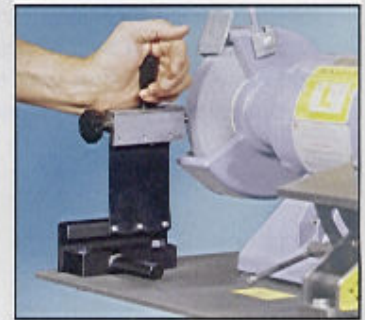
Turn your bench grinder into a safer and more accurate tool sharpener. The Grind-R-Table is a heavy-duty, solid steel constructed, add-on calibrated "TOOL REST" that fits most 6", 7" and 8" bench grinders. Now anyone can set compound tool angles on lathe tools, boring tools, threading tools and dozens more. You will grind tools that machine to closer tolerances and produce finer parts... order a Grind-R-Table NOW.

The combination of an Accu-Finish Grind-R-Table and BG Diamond wheels will make your grinder safer and more accurate.

We can supply a complete set-up OR you can add to your existing grinder.



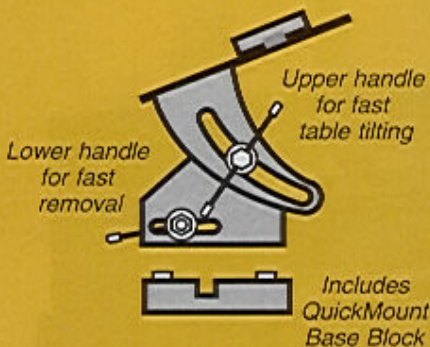
Compound angles are easy to set with the tilt table top and the sliding "T" protractor.



QuickMount Wheel Dresser

Lets you dress green wheels - flat and true. Attaches to the QuickMount base and is safer to use and more accurate than hand-held dressers. Includes a 1/4 carat mounted diamond with a micro-screw adjustment for precise dressing.

See page 17 for lamp kit



Grind-R-Table

CALIBRATED SHARPENING TOOL REST

Grind-R-Table

- 001-696 **Grind-R-Table**
Table, Protractor "T" Slide and Base Block
- 001-754 **Special Package**
Two 001-696 Grind-R-Tables and
a 001-698 Base Plate
- 001-703 **Twin-Table Package**
001-704 Baldor 7" grinder, two 001-696
Grind-R-Tables, two 001-724 QuickMount
Bases, 001-697 predrilled mounting plate.
- 001-724 **Extra QuickMount Base Block**
- 001-697 **Pre-drilled Mounting Base Plate**
- 001-756 **QuickMount Lamp Kit (115 V)**
- 001-704 **Baldor 7" Grinder**
- 001-722 **QuickMount Wheel Dresser**
- 001-436 **1/4 carat diamond replacement**
for the QM Wheel Dresser

Sharpen **Carbide** on **YOUR** Bench Grinder with...

BG Diamond Wheels

Accu-Finish® BG diamond wheels are designed for the bench grinder you already own. All you need is this wheel to put you in full control of carbide tools. BG diamond wheels are affordable, long lasting and they stay flat without grooving or needing dressing. Our wheels grind cooler than other wheels, and handle carbides, ceramics, and cermets. Plus, they are not ruined if you accidentally grind steel like other diamond wheels.

BG wheels are 6" O.D. x 1" wide for use up to 3600 RPM.

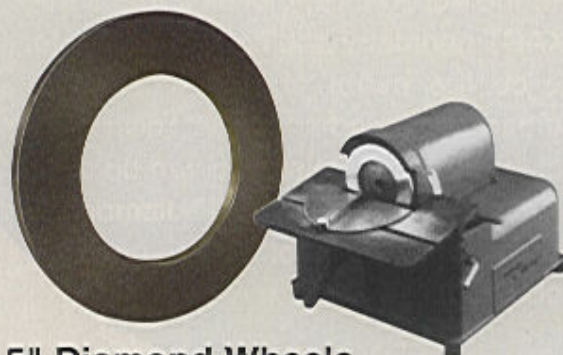
Specify:
1/2", 5/8", 3/4"
or 16 & 20mm
arbor size
when ordering.

*Money-back
guarantee.*

Wheels that stay true!



- 001-328 60 Grit "Rough"
- 001-329 80 Grit "Coarse"
- 001-330 100 Grit "Med. Rough"
- 001-331 180 Grit "Medium"
- 001-332 220 Grit "Med. Fine"
- 001-333 360 Grit "Fine"
- 001-372 600 Grit "Extra Fine"
- 001-635 Pkg. "A" (60 & 220)
- 001-636 Pkg. "B" (100 & 360)



5" Diamond Wheels for Magnetic-Mount Oscillating Grinders

These diamond wheels fit the original Leonard Grind-R-Lap, and most similar low speed machines including Cold Grind, K-K Calamar, Enco, Victory, SPI, etc. Now, make your oscillating grinder sharpen faster and finer with advanced Accu-Finish Wheels! Wheels are 5" O.D. X 3" I.D. made on precision solid steel core.

- 001-680 260 Grit "Course"
- 001-682 600 Grit "Medium-Fine"
- 001-683 1200 Grit "Fine"
- 001-755 Pkg. "L" (260 & 600)



T-6 Wheels for Double-End Tool Grinder

Wheels are 6" O.D. X 1" wide diamond surface. Fits standard 3.250" bolt circle with 1.25" pilot hole. Solid steel core.

- 001-679 60 Grit
- 001-841 80 Grit
- 001-666 100 Grit
- 001-667 180 Grit
- 001-668 220 Grit
- 001-669 360 Grit
- 001-670 Pkg. "C" (100 & 360)

FINISH

Use the Accu-Finish machine to put the EXACT geometry and finish required for the job. If a "mirror" finish is required on the part, you need a "mirror" finish on the tool... with Accu-Finish you can do it in seconds. The "NO HEAT" diamond wheels will extend tool life and grind tools to "BETTER" than new.

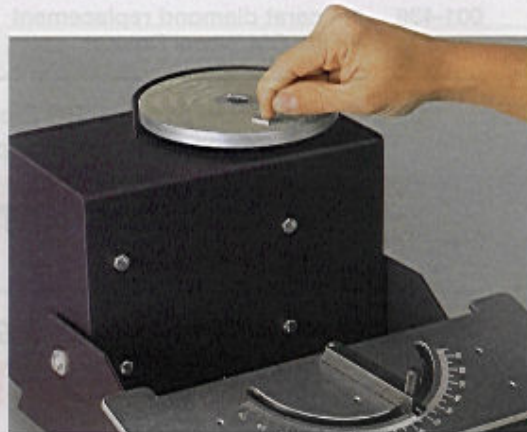


Accu-Finish will pivot up to a horizontal position, WITHOUT disturbing the table set-up, for fast and easy wheel changes.

Accu-Finish[®] SERIES II

With the Accu-Finish Series II you can sharpen carbide, ceramics, cermets, HSS and many PCD/CBN tools to a high-performance cutting edge. No special training is required...the technology is built into the Accu-Finish[®] machine and its wheels. This system is so effective that resharpened tools outperform new ones.

For a remarkably low cost you get longer tool life, "mirror" finishes and precise tool geometry every time.



Lapping

Renew carbide inserts and other tools by hand-lapping on the low-speed diamond wheel... *it's that safe!*

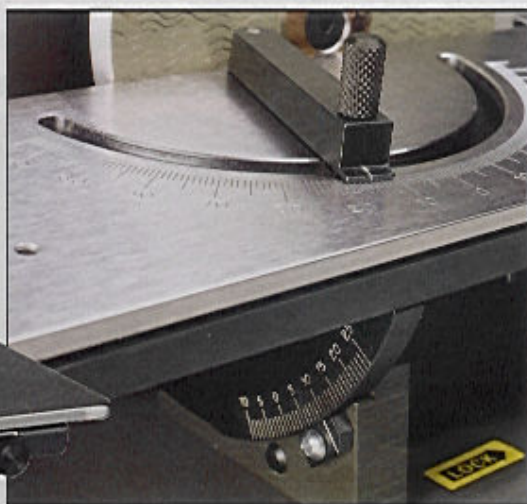
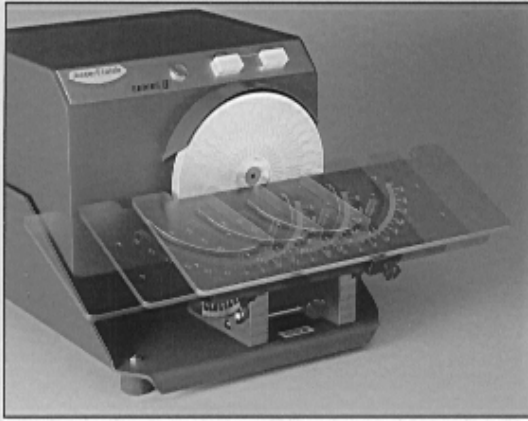
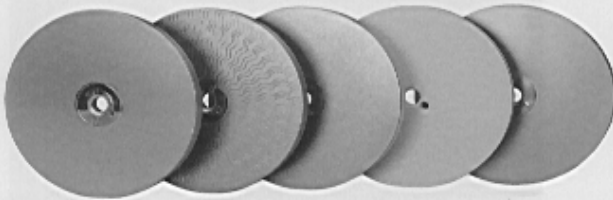


Table elevation and protractor scale allow for highly accurate compound angle settings. You can even change angles while the machine is running.



The calibrated table glides parallel to the sharpening wheel. This allows you to securely hold the tool against the protractor and slide the table back and forth, limiting the amount of tool material removed.

The table can be locked in position if desired.



Large 6" diamond wheels change in seconds. Different grits for different finishes. Choose from several Accu-finish diamond wheels to fit your shop's applications.

See page 10

001-610 Accu-Finish Series II machine
(less wheel) Includes machine, wheel wetting agent, spray bottle, wheel cleaning stick and instructions.
Approx. Wt. 55 lbs.

001-612 Standard Package
Includes 001-610 machine, 001-234 (360 grit) wheel, 001-235 (600 grit) wheel, 001-671 ceramic lap, 002-754 diamond spray, 001-756 lamp kit, 001-580 insert holder and 001-694 wheel rack.
Approx. Wt 60 lbs.

001-831 Total Package
Includes 001-610 machine, 001-234 (360 grit) wheel, 001-235 (600 grit) wheel, 001-671 ceramic lap, 002-754 diamond spray, 001-580 & 001-581 insert holders, 001-756 lamp kit and 001-823 Accu-Finish cabinet.
Approx. Wt. 135 lbs.

001-896 A-F Microscope Package
SEE PAGE 17 FOR MICROSCOPE DETAILS
Includes 001-610 machine, 001-234 (360 grit) wheel, 001-235 (600) grit wheel, 001-236 (1200 grit) wheel, 001-580 & 001-581 insert holder, 001-823 Accu-Finish Cabinet and 003-600 microscope kit.
Approx. Wt. 135 lbs.

Call for quote for 230 or 100 Volt.

SPECIFICATIONS:

- Motor:** Continuous duty, thermally protected, UL recognized, reversible. Available in 115V 60Hz, 220/240V 50Hz and 100V 50/60Hz.
- Spindle Drive:** Belt reduction (dual belts), 300 RPM
- Wheels:** 6" diameter with 1/2" arbor hole. Diamond wheels available in several grits and styles, plus Ceramic lap.
- Table:** Precision machined solid stainless steel table. Built-in protractor with removable tool guide. Table supported by four sealed ball bearings on precision ways. Can be locked in any position or traversed across wheel during sharpening.
- Size:** 18" wide X 11" high X 17" deep (without lamp and cabinet). AF machine shipping weight approx. 60 lbs.



Focal length (working distance) is 9.3" from microscope bottom to your work using 0.3 objective lens. Other lenses available to change magnification and focal length. You can zoom in for detailed work or zoom out to see large areas.

You can use this Microscope System with or without machine cabinet. Microscope swings away when desired.

Accu-Finish was designed to be simple and efficient to use. Tools can be sharpened and put back into service before other grinders are even set up.

SEE PAGES 16 & 17 FOR THE CABINET AND ACCESSORIES

Simple, Compact, Economical

Put a high-performance cutting edge on carbide, ceramics, cermets, HSS, and many PCD/CBN tools. No special training is required... the technology is built into the Accu-Finish® SERIES ONE and its wheels. This machine is so effective that resharpened tools outperform new ones.

Choose the tool geometry you want and use Accu-Finish to make special tools with just a 30-second setup time.

For a remarkably low cost you get longer tool life, better finishes and precise tool geometry every time.

The SERIES ONE was designed compact for portability and a lower cost, with all the capabilities to give you the sharpest edge possible.



Compact size lets you carry the SERIES ONE wherever it's needed.

Accu-Finish Sharpens:

- Carbide
- Ceramics
- Cermets
- High Speed Steel and many PCD/CBN

**To Order Call:
1-800-835-3519**



Set the table angle -OR- relief angle desired with the protractor on the side. The protractor on the table is used to set the cutting edge angle. Moving the table back and forth while grinding, will give the smoothest cutting edge.

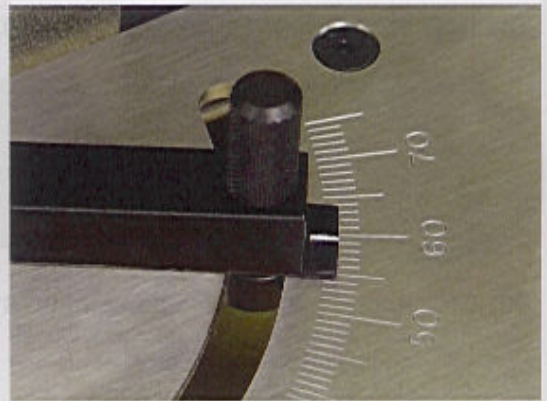


Table Angle Protractor

Accu-Finish® SERIES ONE



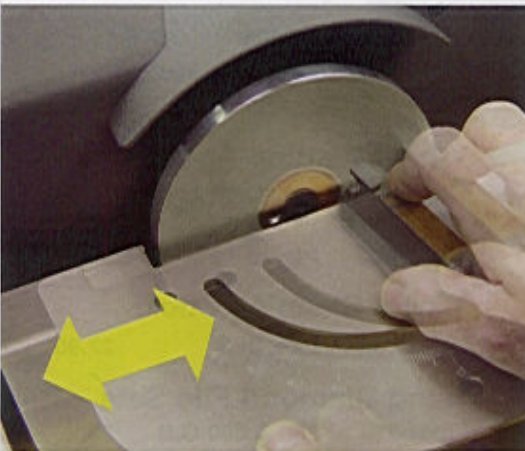
**Enjoy these NEW
SERIES ONE Features:**

- Reversible Spindle
- Larger Wheel Selection
- Fixtures to sharpen...Gun Drills, End Mills, Reamers, Cut-Off Inserts, and MORE

With Accu-Finish SERIES ONE you can sharpen tools like a toolroom expert!



Built-in protractor and table angle insures accurate tool angles.



The stainless steel table glides parallel to wheel giving the smoothest possible finish and prevents wheel wear.



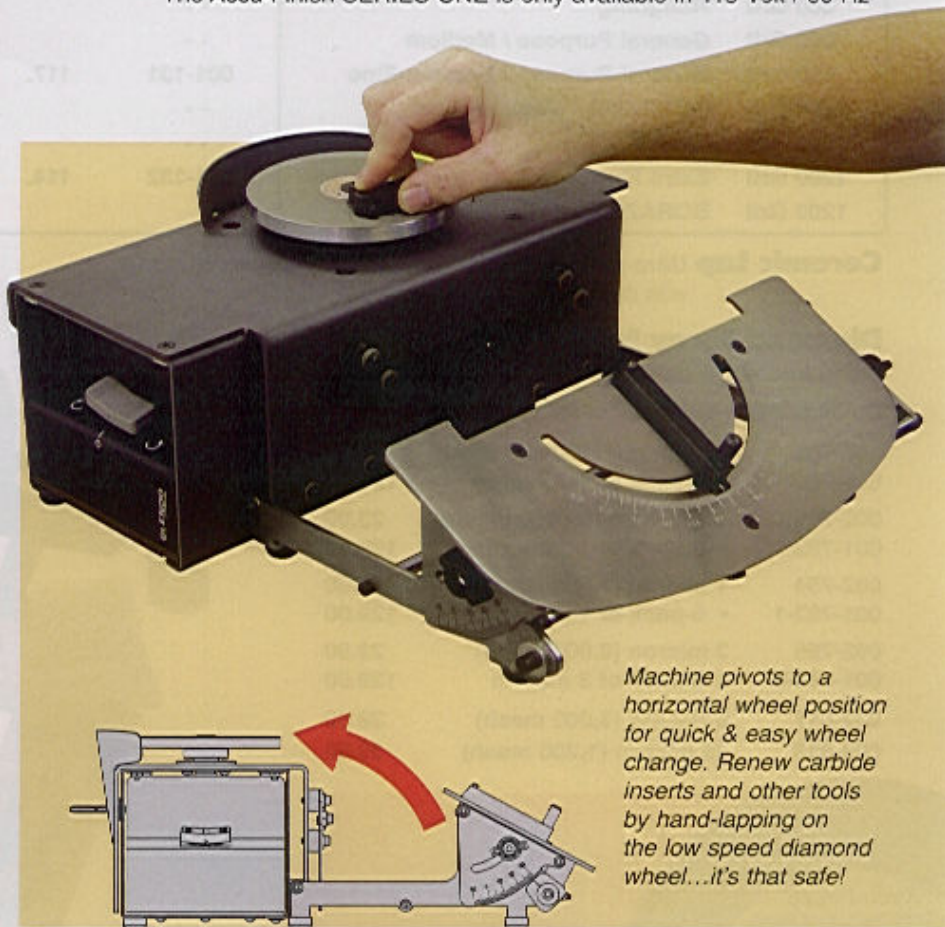
Economical 5" diamond wheels change in seconds. The SERIES ONE will also handle 6" diamond wheels. Choose from several Accu-finish diamond wheels to fit your shop's applications. See page 10

001-599B Accu-Finish SERIES ONE
(less wheel) Includes machine, wheel wetting agent, spray bottle, wheel cleaning stick and instructions.

001-600 Starter Package
Includes 001-599B machine and 001-131 (600 grit) wheel.

001-605 Value Package
Includes 001-599B machine, 001-130 (260 grit) wheel, 001-131 (600 grit) wheel, 001-132 (1200 grit) wheel and 001-580 insert holder.

The Accu-Finish SERIES ONE is only available in 115 Volt / 60 Hz



Machine pivots to a horizontal wheel position for quick & easy wheel change. Renew carbide inserts and other tools by hand-lapping on the low speed diamond wheel...it's that safe!

SPECIFICATIONS:

Motor: Continuous duty, thermally protected, UL recognized, reversible. (115V 60Hz)

Spindle Drive: Belt reduction (dual belts), 240 RPM

Wheels: 5" or 6" diameter with 1/2" arbor hole. Diamond wheels available in several grits and styles, plus 6" Ceramic lap.

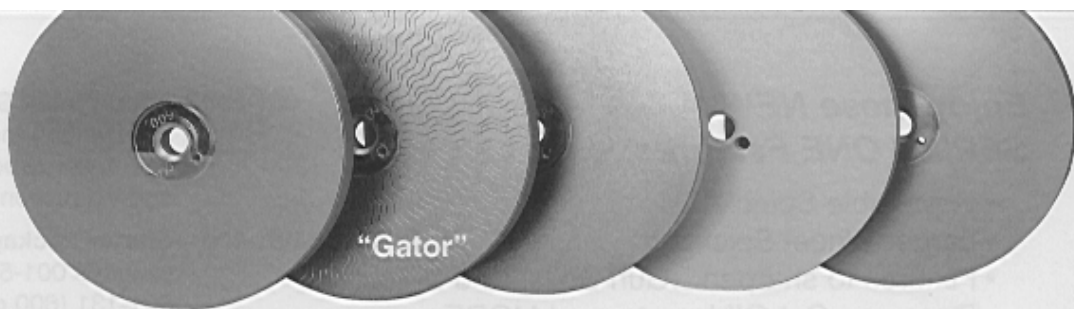
Table: Precision machined solid stainless steel table. Built-in protractor with removable tool guide. Table supported by slide blocks on precision ground rods. Can be locked in any position or traversed across wheel during sharpening.

Size: 18" wide X 11" high X 17" deep (without lamp).
Shipping weight approximately 20 lbs.

Insulated lamp shade stays cool. Rated 40 W. See page 17



Accu-Finish® Diamond Wheels



Description & Application		5" Dia. (125mm)	6" Dia. (150mm)
100 Grit	Fast Roughing	--	011-198
180 Grit	"Gator" Fast Roughing	011-194	
260 Grit	Roughing and Shaping	001-130	001-233
360 Grit	"Gator" Roughing	--	001-234
360 Grit	Roughing	--	001-661
500 Grit	General Purpose / Medium	--	011-080
600 Grit	General Purpose / Medium-Fine	001-131	001-235
600 Grit	BORAZON - Medium-Fine	--	001-809
800 Grit	Fine	--	011-212
1200 Grit	Extra Fine	001-132	001-236
1200 Grit	BORAZON - Extra Fine	--	011-254

8" Dia. Diamond Wheel for Series II
Wheel guard must be removed.
600 Grit General Purpose
001-807

Ceramic Lap Ultra-polishing - "mirror" finish. Requires charging with diamond spray.

001-671

Diamond Spray for Ceramic Lap

Used to charge ceramic lap. Each spray bottle contains one full carat of diamond.

- 002-752 1/4 micron (100,000 mesh)
- 001-782-1/4 • 6-pack of 1/4 micron
- 002-753 1/2 micron (50,000 mesh)
- 001-782-1/2 • 6-pack of 1/2 micron
- 002-754 1 micron (14,000 mesh)
- 001-782-1 • 6-pack of 1 micron
- 002-755 3 micron (8,000 mesh)
- 001-782-3 • 6-pack of 3 micron
- 002-817 6 micron (3,000 mesh)
- 002-818 15 micron (1,200 mesh)



Wheel Rack

Organizes and protects your diamond wheels.

001-694

Wheels not included.

Wheel Wetting Agent

Concentrate - makes 1 gallon per pkg.

- 001-659 Pkg of 3
- 001-660 Pkg of 12

Wheel Cleaning Sticks

- 001-783 Pkg. of 3

Hand Diamond File Sets

- 001-714 360 & 600 Grit
- 001-779 2 ea 600 Grit

Automotive and Special Tool Wheels



■ DIAMOND SURFACE



FACE / EDGE Diamond Wheels

Especially designed for sharpening valve seat cutter bits.

- 360 Face/Edge (roughing) 001-920
- 600 Face/Edge (general) 001-921
- 1200 Face/Edge (extra-fine) 001-922

30° REVERSE ANGLE Diamond Wheels

Designed for ID grooving and threading tools.

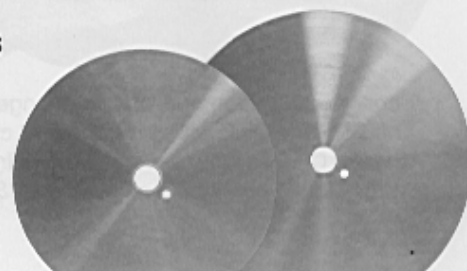
- 320 Grit Rev. Angle 011-113
- 600 Grit Rev. Angle 011-087
- 1200 Grit Rev. Angle 011-088

Aluminum Wheel Blank

Make your own...
Strop -OR- Abrasive Wheel

Simply adhere leather to make a strop or desired grit sandpaper to fit your needs.

- 002-129 5" Blank Wheel
- 002-537 6" Blank Wheel



FIXTURES

Accu-Finish® SERIES ONE & SERIES II

Collet Blocks

Collet blocks use any 5C collet (not included) to hold tools precisely centered in the square or hex block. The square block lets you sharpen 2 or 4 flute tools, the hex fits 2, 3, or 6 flute tools. These blocks are precision ground from hardened steel. Each block includes a lock nut and wrench.

- 001-881 Square 5C collet block
- 001-885 Hex 5C collet block

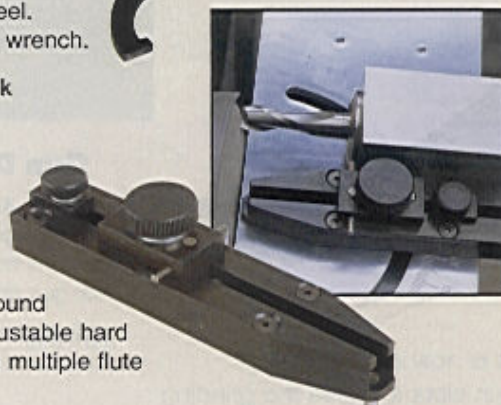


Tool Stop Guide

Used with Collet Blocks and Counter Bore Fixture

Controls the amount of material ground from each cutting edge with an adjustable hard stop. This insures that all edges on multiple flute cutters are equal.

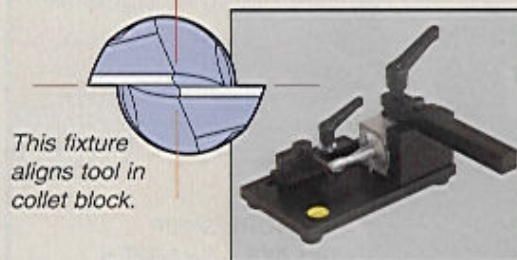
- 001-884 Tool Stop Guide



Alignment Fixture for Collet Blocks

To insure the best tool geometry, the tool must be accurately aligned in the collet block before sharpening. This collet block alignment fixture will locate any 2, 3, 4 or 6 flute tool in the proper position for sharpening.

- 001-927 Alignment Fixture



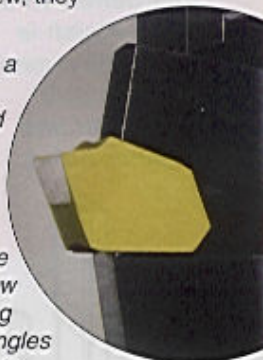
This fixture aligns tool in collet block.



SAVE MONEY Tool Resharpener & Recycling

Inserted cut-off and grooving tools are relatively expensive because there are only one or two useable edges per insert. Using this unique new fixture, Accu-Finish can resharpen a variety of wedge type cut-off/grooving inserts in about a minute. Shops using this Accu-Finish system report that these resharpened tools not only compare favorably with new, they can outlast them.

In a minute, the end of a used cut-off or grooving insert can be resharpened to cut like new. Because the top is untouched, the chipbreaker and coating remain. During resharpening, tools can be modified to outperform new ones...for example, adding special right or left lead angles to the front of cut-off inserts.



Jaw opening and grip angle is fully adjustable. Works on most tapered wedge type inserts and many clamp type inserts.

Cut-Off / Grooving Insert Sharpening Fixture

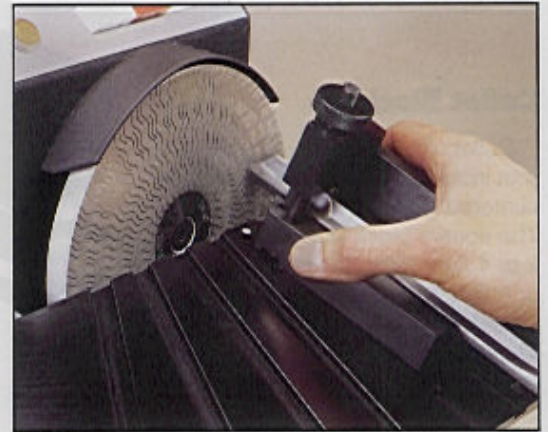
- 011-378



Gun Drill Sharpening Fixture



Duplicate the same drill point time after time on gun drills from 0.1" to 1.0" dia.



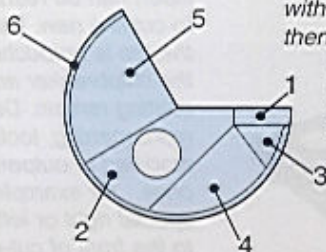
SAVE \$'s & Drill Better!

Double the life of your gun drills with this simple sharpening process. PLUS, a gun drill sharpened on an Accu-Finish is better than new and will drill straighter and cleaner holes.



Sharpening gun drills is now an "easy-step" sequence using built-in slots to guide the grinding of each facet. There is only one angle to set, the clearance angle, which you adjust in seconds based on the drill manufacturer's specifications or your own experience.

Sharpen facets (1) through (5) with the gun drill in the holder then chamfer the edge (6) with the Accu-Finish in lapping position or with a diamond file.



3 Easy Steps:

1. Clamp your gun drill in the holder by turning the knob. Holds standard faceted gun drills and half-round deep hole drills.
2. Set the clearance angle you want and place the drill holder in the beginning guide slot.
3. Sharpen each drill facet using the built-in series of guide slots to maintain the correct geometry.

You get the Accu-Finish "NO-HEAT" benefits that produce sharper and stronger cutting edges that will out perform and last longer than brand new gun drills. The drills cutting surface can be mirror finished in seconds on the Accu-Finish.

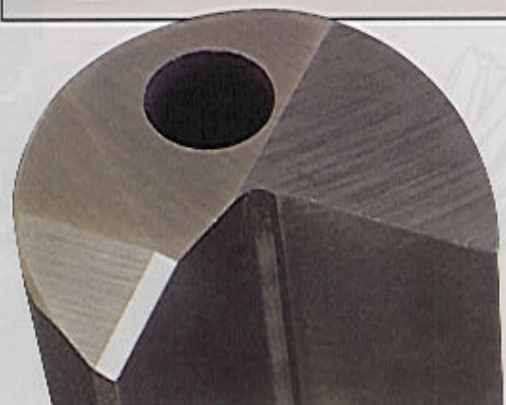
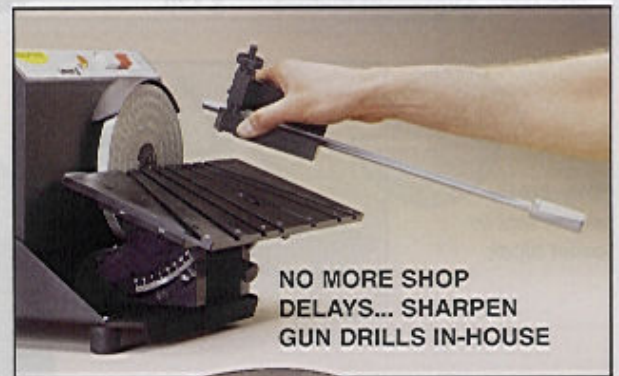
Gun Drill Sharpening System

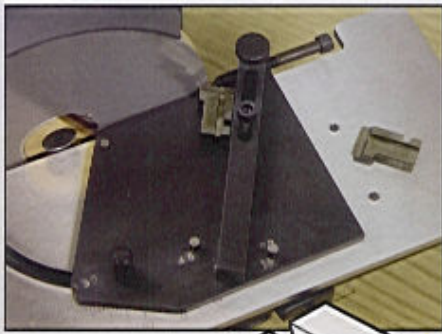
Includes Accu-Finish Series II machine, 360 and 600 grit diamond wheels, guide table, gun drill holder, instructions and accessories. For gun drills up to 1.0" (25mm) diameter.

001-965 Gun Drill Attachment
Includes everything but the Accu-Finish machine. Fits Series ONE or Series II. Approx. Wt. 6.5 lbs.

001-970 Gun Drill Sharpening System
115 V, 60 Hz. Approx. Wt. 61 lbs.

001-971 Gun Drill Sharpening System
220/240 V, 50 HZ. Approx. Wt. 61 lbs.





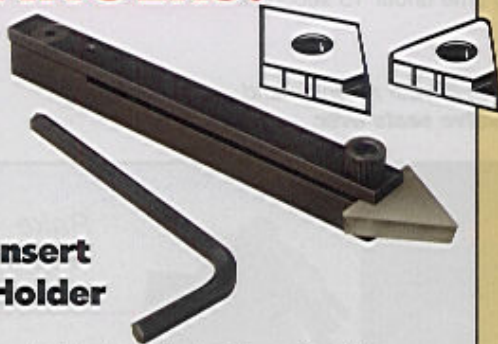
Die Chaser Fixture

With this fixture you can resharpen the leading edge of geometric and similar die chasers on the Accu-Finish Series II. Generates a matched set of chasers for correct threading performance. Lead-in angle adjusts to 15°, 22.5°, 30°, 37.5°, 45° and 52.5°. Relief or clearance angle is automatically controlled by table elevation. Sharpens high-speed steel and carbide chasers without heat for a stronger and longer tool life.

Die Chaser Fixture

001-736

SAVE YOUR FINGERS!



Insert Holder

An ideal way to hold inserts while sharpening the sides, nose and edges. Holds all shapes of inserts. Saves your fingers and lets you do a better job. Use these holders with any Accu-Finish machine, bench grinder or double-end tool grinder.

001-580 Insert Holder
for 1/8" to 3/16" thick

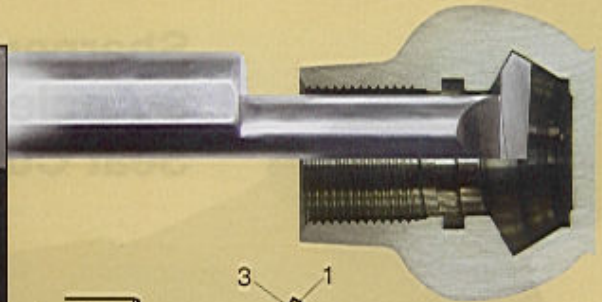
001-581 Insert Holder
for 3/16" to 1/4" thick

Make Special Tools Fast & Easy

with Accu-Finish®



There is a full diamond surface on the front AND angled back side of this special wheel... a big advantage for making special tools.



Special tools can be difficult and time consuming to make... NOT with Accu-Finish.

Example

Here's HOW this special inside profiling tool was made:

1. Outside tool nose edge (1) is sharpened to the desired relief and cutting angle using the compound table built into Accu-Finish. The tool is held in the square collet block which provides an accurate reference for the entire sharpening sequence.
2. The front end (2) is sharpened to the desired relief and clearance angle.
3. The inside tool nose edge (3) is sharpened on the back side of the unique Accu-Finish Reverse Angle Wheel. This type of sharpening is difficult or impossible with other grinders but is remarkably simple with Accu-Finish.
4. The top tool surface (4) is sharpened by turning the collet block on its side and using the Accu-Finish Protractor Extension to maintain the desired geometry.



Sharpening 3-Angle Valve Seat Cutters...

In-the-Cutter-Body with Rake Angle Control

With Accu-Finish, you can sharpen 3-angle valve seat cutters WITHOUT removing the cutter bit from the cutter body. Dedicated Accu-Finish fixtures are available for Sunnen (VSC or SGM), Serdi and most ball drivers that use Serdi-style bits. Imagine the time savings and improved accuracy of sharpening your seat cutters in the cutter body.

These fixtures will also let you determine and grind the best cutter rake angle. Changes in rake can dramatically improve valve seat finish and eliminate chatter. With this system you can accurately set cutter rake angle anywhere from -10 to +10 degrees.



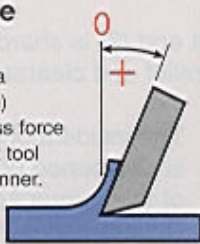
Cutter Bit stays in the cutter body.

What's RAKE ANGLE?

Why is it IMPORTANT?

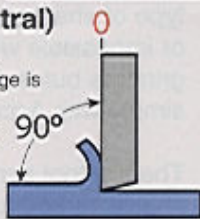
Positive Rake

Cuts with a (chisel-like) action. Less force on tool but tool edge is thinner.



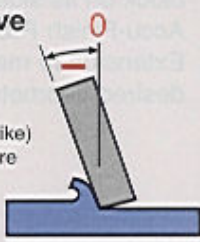
0 (Neutral) Rake

Cutting edge is square to workpiece



Negative Rake

Cuts with a blunt (scraping-like) action. More force on tool but tool edge is stronger.



Rake is an angle the tool edge makes to the workpiece. 0 (neutral) rake means the tool edge is square to the workpiece. Positive rake tilts the tool edge to a sharper angle; negative rake tilts it to a blunter angle.

The best rake angle gives longer tool life, better valve seat finish and eliminates chatter. Finding the best rake depends on seat hardness, rigidity of the engine head, mechanical condition of your head machine and tool quality. Once the best rake angle is found, it's critical that you grind it the same every time.

Step 1

Remove the valve seat cutter body from your machine and mount it in the Accu-Finish fixture (no wrench required). *The cutter bit stays in the cutter body!*

Step 2

Set the desired RAKE ANGLE and SHARPEN. Total sharpening time under 15 seconds.

Step 3

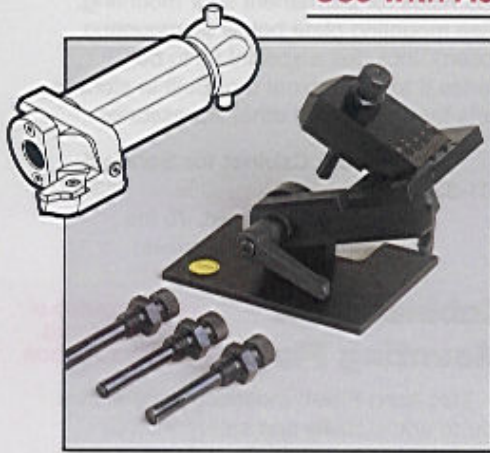
Put the cutter back in your machine and make the best valve seats ever.



Serdi valve seat cutter with Accu-Finish in-the-cutter-body sharpening and adjustable rake angle. Other fixtures are available for Sunnen VSC/SGM and most popular ball driver seat cutters.

All Model 901, 930 and 940 fixtures give you In-the-Cutter-Body sharpening with -10 to +10 degree Rake Angle control.

Use with Accu-Finish Series II Sharpener.



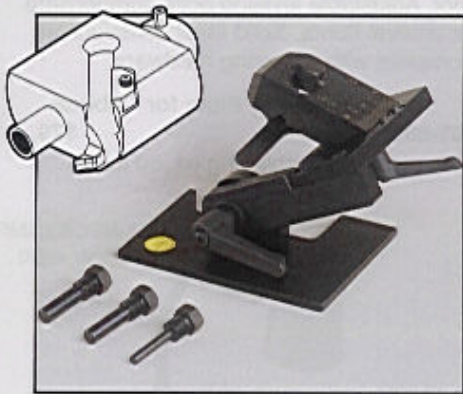
Model 940 Sharpening Fixture

Fits most ball drivers using Serdi-style cutter bits.

001-940 Model 940 Sharpening Fixture

Requires appropriate guide post.

001-943 .375"
001-944 .385"
001-945 .389"
001-947 .437"



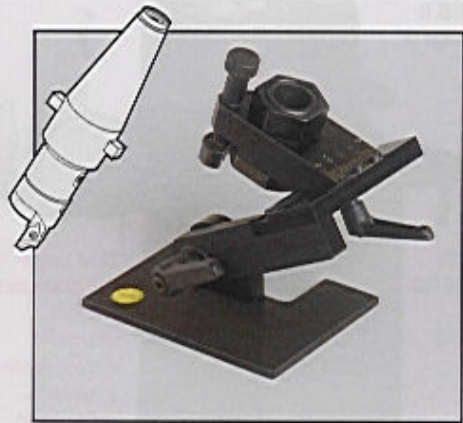
Model 901 Sharpening Fixture

Fits Sunnen VSC or SGM holders.

001-901 Model 901 Sharpening Fixture

Requires appropriate guide post.

001-910 .236" (6mm)
001-911 .375"
001-912 .385"
001-913 .389"



Model 930 Sharpening Fixture

Fits Serdi 5100 and similar cutter bodies.

001-930 Model 930 Sharpening Fixture



Sharpen Serdi-style bits on any Accu-Finish with this bit holder.

Economical way to sharpen Serdi-Style cutter bits

If you don't need in-the-cutter-body sharpening, here's a fast, simple and economical way to sharpen Serdi-style bits on any Accu-Finish Series ONE or Series II. Rake angle can be adjusted using the Accu-Finish tool guide.

001-925 Double-end Serdi-style bit holder

(includes 2 torx screws and wrench)



Secures the cutter bit with the same screw and wrench used in most cutter bodies/ball drivers.

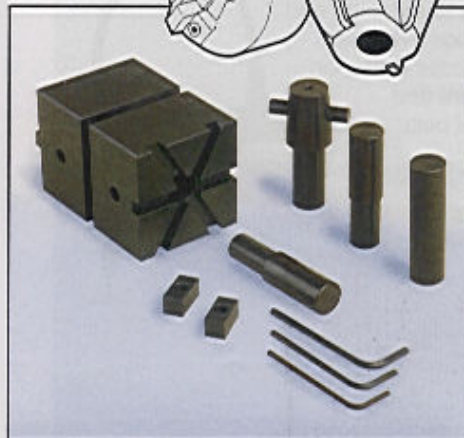
See Page 10 for

FACE/EDGE Diamond Wheels

Especially designed for sharpening valve seat cutter bits.



DIAMOND SURFACE



Counter Bore Fixture

Designed to sharpen the bottom cutting edges of most 2-flute valve seat counterbore cutters and 4-flute bowl hogs using the Accu-Finish Series II and Tool Stop Guide. Includes mandrels and drive keys to fit most popular styles.

Counter Bore Fixture

001-882

Use with #001-884 Tool Stop Guide (see Tool Stop Guide on page 11)

ACCESSORIES



Accu-Finish Protractor Extension Arm

Lets you set more tool angles.

The Accu-Finish table protractor goes to 75°. At times you need angles greater than these. This extension arm clamps onto the tool guide and gives you a 90° offset that lets you set all the angles. Machined from solid steel.



Protractor Extension Arm
001-822

Hand Diamond File Sets

Touch-up carbide, HHS and other tools right on the machine. Recommended for lightly honing lands on new or resharpended tools.



- 001-714 360 & 600 Grit
- 001-779 2 ea 600 Grit

Hand Protector

The wash-off hand protection.

Give your hands convenient protection from dirt and grime. Rub pr88 onto your hands before dirty jobs. After you're done, watch even the toughest dirt leave as you wash. Non-toxic product that is kind to your skin with no oily feel. Even works on printer's ink and automotive grease. About 600 hand treatments. 1 Liter (33.8 oz)



pr88 Hand Protector
002-983

Hand Loupe

Hand Loupe
Triplet 10X 18mm lens.
Chrome with leather case. A must for close inspection of tools and work.



011-380 Hand Loupe



Optivisor

Helps you see your work better. It features ground lenses and adjustable headband. Includes special kit for changing lens position.

- 002-710 #3 (1.75 power)
- 002-711 #5 (2.50 power)
- 002-712 #7 (2.75 power)

Optiloupe

This optiloupe kit adds an extra 2.5 power to your Optivisor. Swings away when desired.



022-119 Optiloupe Kit

Magnifier Lamp

Built-in lens magnifies your work. Flexible-neck adds light and vision where you need it. Improve the quality of your sharpening and reduce eye strain. Includes clamp-on mount and 40W bulb.



Magnifier Lamp
002-811

Accu-Finish Floor Cabinet

This heavy steel cabinet turns your Accu-Finish Series II into an organized sharpening center. Perfect working height. Has holes for permanent floor mounting. (See mounting plate below as mounting option). Includes a special kit to bolt Series II to the cabinet top. Built in storage slots for wheels and other accessories.

Heavy-Duty Cabinet for Series II 001-823

(approx. shipping wt. 75 lbs.,
shipped UPS in 2 boxes)

Cabinet Floor Mounting Plate

RECOMMENDED IF NOT MOUNTING CABINET TO FLOOR

This Accu-Finish mounting plate allows you to add stability and safety without permanently mounting the cabinet to the floor. Adjustable leveling bolts compensate for unlevel floors. Solid steel construction. Complete with mounting hardware.

Floor Mounting Plate for Cabinet 001-890

(approx. shipping wt. 30 lbs.)



FLEX-NECK LAMP
(See upper right)

ACCU-FINISH
SERIES II
See page 6

INSERT
HOLDERS
See
page 13

See page 10
for diamond
wheels,
diamond
spray, wetting
agents
and other
accessories.

FLOOR
MOUNTING
PLATE

Lamp Kit
for Accu-Finish
Series II machine
and other applications

Extra heavy-duty, UL listed lamp has 24" flexible neck that is sealed against oil and grit. So, this lamp stays where you put it. Quick-mount bracket for easy installation. Rated to a bright 100 watts to give plenty of work light. Insulated shade stays cool.

Heavy-Duty Lamp Kit
(115 Volt, 3-prong grounded plug)
001-756

Lamp Kit
for Accu-Finish
Series ONE machine and
other applications

Same heavy-duty construction as the lamp above, only smaller. UL listed lamp has 15" flexible neck that is sealed against oil and grit. Lamp stays where you put it. A hex ferrule with lock nut and washer for easy "panel" mounting. Insulated shade stays cool. Rated to 40 watts.

Compact Lamp Kit
(115 Volt, 3-prong grounded plug)
022-915

Power Foot Switch

Turn the machine on and off with both hands free. Especially useful for horizontal lapping. Comes prewired for standard 3-wire, 115 Volt grounded outlet. UL listed to 1/2 HP.

On/Off Foot Switch
002-205



Wheel Rack

Organizes and protects your diamond wheels. Stores 5 wheels, holds both 5" and 6".

Wheel Storage Rack
001-694

(Wheels not included)

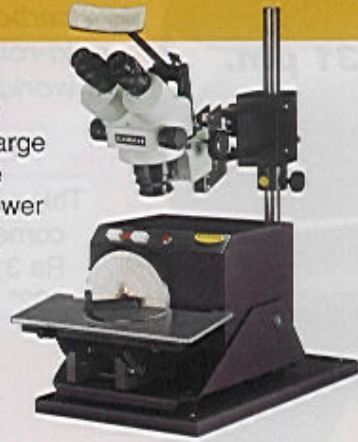


INSPECT
EVERYTHING
TO THE
LAST DETAIL

INSPECTION

The better you can see,
the better the results!

This microscope system is unique because you can both inspect and work under it. This difference is critical. The large focal length gives you plenty of distance under the microscope for hand tools, power tools, measuring and gauging tools, etc. Work is done with absolute clarity and precision without eye fatigue.



003-595 Twin Halogen Lamp Kit.
Fits either microscope stand.



Microscope INSPECTION System
003-600

Includes Meiji Microscope, Stand and Headrest. Steel construction for stable support. Height is easily adjusted from 2.5" (63.5mm) to 19.5" (495mm). Horizontal arms travel 11" (279mm) allowing exact positioning of the scope above the workpiece. (Does NOT include Twin Halogen Lamp Kit shown in photo)



Microscope "Flex Arm" INSPECTION System

003-681

The Flex-Arm stand offers the quickest inspection set-up for items that vary in size or shape.

Includes Meiji Microscope, Flex Arm "Acrobat" Stand, Headrest and Base. All steel construction. Arms can be locked ridged or left flexible.

Arm reach: 30" (762mm)
Height: 24.5" (622mm)

Twin Halogen Lamp Kit
(shown on Inspection Stand above)

Includes 2 halogen work lamps and mounting bracket for attachment to the microscope stand. Lamp locks in position or can move side-to-side with microscope.

003-595 120V / 60Hz
003-596 240V / 50Hz

Microscope Ring Light

Glare and shadow free, uniform illumination. Circular fluorescent bulb with 7000 hours of lamp life. Highly recommended for the "Flex Arm" stand.

120 V
022-268T

220/240 V, 50/60 Hz
022-268T-220

Replacement Ring Bulb
022-286



Tool Conditioning with Accu-Finish®



Identical
low carbon,
cold-rolled steel
workpieces

This new insert
corner turns
Ra 31 μ in. at
.002" per rev.

Accu-Finish®
conditioning makes
this corner turn an
amazing Ra 12 μ in.
at the same feed
rate and depth of cut.



A closer look

Accu-Finish gives an extremely sharp, fine edge that reduces cutting forces and works more efficiently. In under 30 seconds, the trailing end of this insert corner was modified to add a "wiper" effect that improves workpiece finish 2 to 3 times at the same feed rate. The coating remains fully intact on the top of the insert where it's most effective. This conditioning works well on new or used inserts.

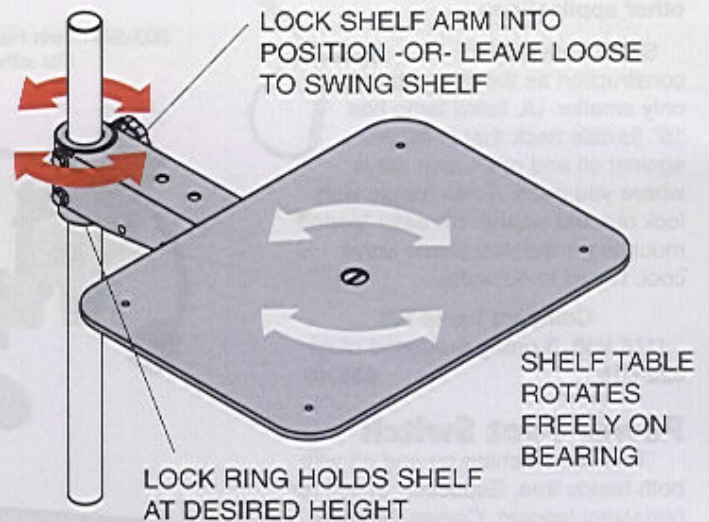
Other benefits

- Conditioned tool is less likely to chatter, a big advantage when boring.
- Required horsepower is reduced.
- Conditioned edge works throughout a wider range of surface speeds...great for slower spindles or small part diameters.
- If desired, the conditioned edge allows a much smaller depth of cut than standard tool edges.

Workspace NEW Utility Shelf

Here is a wonderful addition to any machining center or tool set-up area. Designed by a machinist who was tired of trying to find a place to lay tooling and measuring equipment in an area not covered in metal chips or debris, this innovative shelf has unlimited applications around your shop.

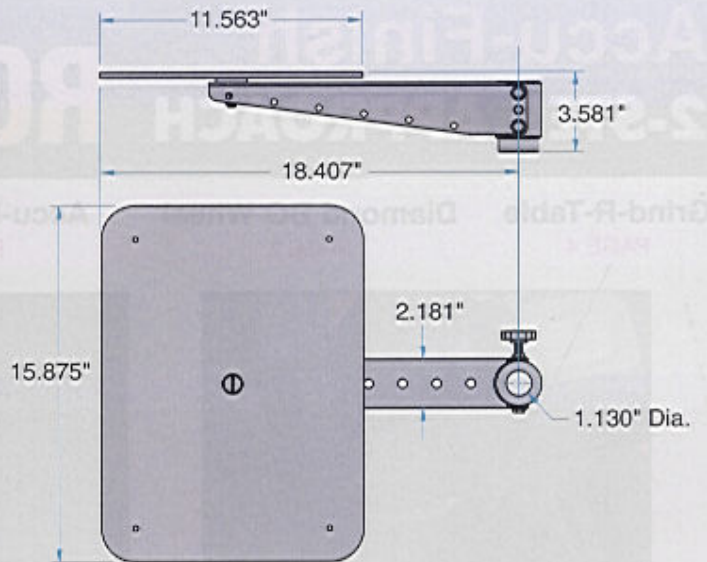
The post mounting on the Workspace Utility Shelf gives the user freedom to adapt any machine or area needing the flexibility of a modular shelf system. Works with any 1.125" OD post.



SHELF MOUNTS ON ANY 1.125" OD POST
(POST NOT INCLUDED)

DOUBLE YOUR
WORKSPACE
WITH TWO
SHELVES





Swing shelf in for easy access...

Built for everyday use and constructed with rugged materials, the table is .25" aircraft grade aluminum connected to an adjustable steel arm and a heavy alloy collar. The table pivot can be moved closer to the post or farther away as needed for clearance.



...swing out-of-the-way when needed.

003-680 Workspace Utility Shelf

Includes shelf, shelf bracket, post bracket, shelf bearing, post locking ring, bolts, hex wrench and instructions. Post not included. Shipped unassembled

003-642 24" Post Kit (not shown)

Includes 1.125" OD Stainless Steel Post (24") with mounting flange base.



Gain instant SPACE where you need it!

Accu-Finish[®] 2-STEP APPROACH

ROUGH...FINISH

Grind-R-Table
PAGE 4

Diamond BG Wheel
PAGE 5

Accu-Finish Machine
PAGES 6 to 9

Accu-Finish
Diamond Wheels
PAGE 10



1 ROUGH

Use your bench grinder to rough shape OR remove tool edge damage. Grinders equipped with BG Diamond Wheels and Grind-R-Tables give the most accurate "rough" possible. For some, this step is sufficient for what they produce.



2 FINISH

Use the Accu-Finish machine to put the EXACT geometry and finish required for the job. If a "mirror" finish is required on the part, you need a "mirror" finish on the tool... with Accu-Finish you can do it in seconds. The "NO HEAT" diamond wheels will extend tool life and grind tools to "BETTER" than new.

Accu-Finish Fixtures

- Counterbore Cutters
- Bowl Hogs
- End Mills
- Spot Facers
- Flat-Face Drills
- Multi-Flute tools
- Cut-Off / Grooving
- Gun Drill
- Inserts
- Die Chasers
- Automotive

PAGES 11 -15

Tool Making / Modification

Accu-Finish helps machinists make special tools like a toolroom expert. Almost any tool material can be used because Accu-Finish works on HSS, carbide, coated carbide, cermets and many types of ceramic and PCD/CBN using the same wheel. It's not only the most versatile and advanced sharpener, it's the safest, thanks to the unique low speed spindle technology that **grinds tools WITHOUT heat.**

*Whether you are a new
or experienced machinist...
a hobbyist or pro...*

Accu-Finish[®]

*will make you a
BETTER machinist.*

2 YEAR WARRANTY

Accu-Finish SERIES ONE and SERIES II are warranted for 2 full years against defects in material and workmanship. Any such defect will be repaired or replaced by sending it freight prepaid to Glendo in Emporia, Kansas. After servicing under this warranty, Glendo will pay normal surface freight back to the customer's location. Shipping damages, normal wear and tear, and abuse not covered.

GLENDO CORPORATION

BERTOLDI SRL

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