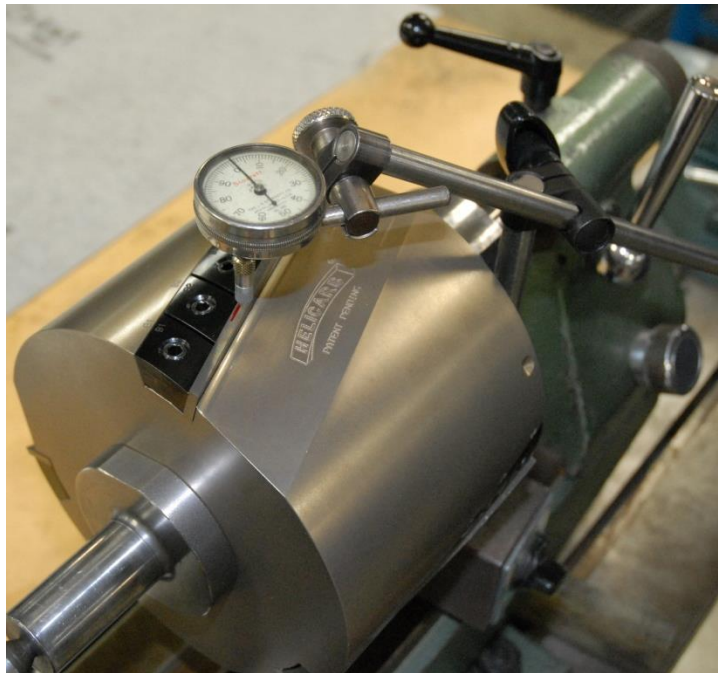


## Checking O.D. Clearance Angle after sharpening a Helicarb® Cutter

The Helicarb® cutters O.D. clearance angle should be at **approximately 11°**. This can be checked with the blade in the cutter head by using a dial indicator. Follow the instructions below:



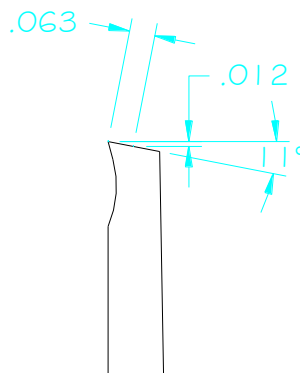
1. Mark a line on the top of the blade 1/16" (0.063) from the cutting edge.



2. With the cutter mounted in a checking fixture, place a dial indicator at the cutting edge and set the indicator to zero.



3. Rotate the cutter until the dial indicator touches the line that was marked on the top of the blade 1/16" from the cutting edge.
4. The dial indicator should read .012". If it reads .012", then the O.D. clearance is at the recommended 11°. See diagram below.



## BLADE CROSS SECTION