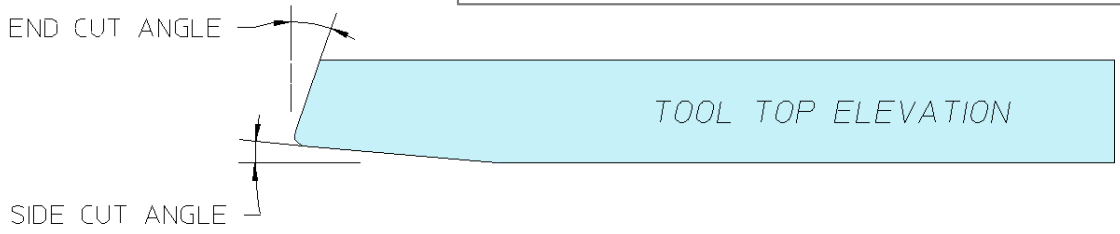
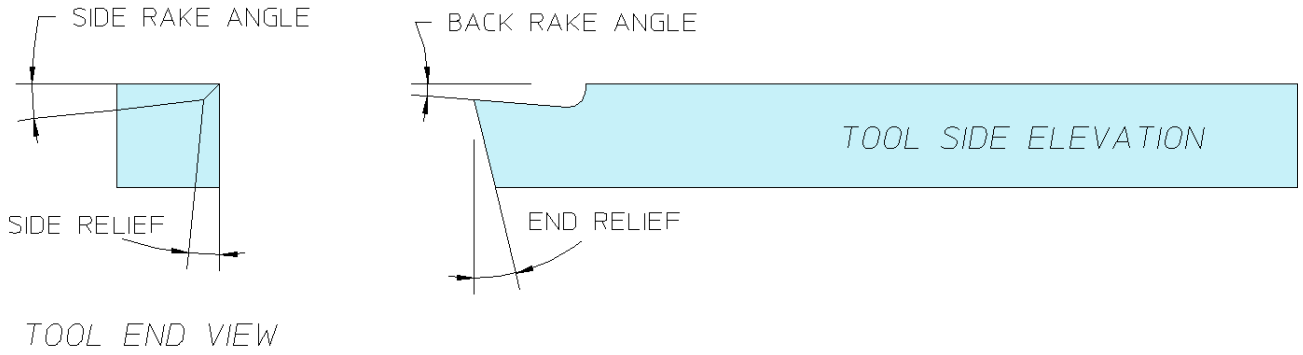


TOOL GRINDING DATA



Lathe Tool Notation

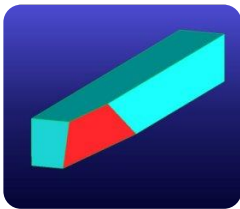
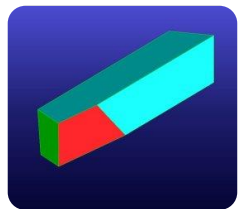

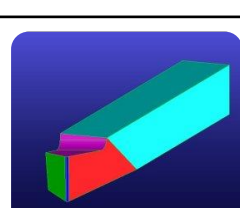


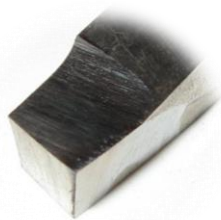
Visit www.steves-workshop.co.uk/tips/toolgrinding/toolgrinding.htm for descriptive text

Suggested Tool Angles

Material	Side Relief	End Relief	Side Rake	Back Rake
Aluminium	12°	8°	16°	35°
Brass	10°	8°	5° → -4°	0°
Bronze	10°	8°	5° → -4°	0°
Cast Iron	10°	8°	12°	5°
Copper	12°	10°	20°	16°
Steel	12°	8°	12° → 18°	8° → 15°
Tool Steel	10°	8°	12°	8°
Stainless Steel	10°	8°	15° → 20°	8°

Tool Grinding Sequence

Side Relief and Cut Angle	
End Relief and Cut Angle	
Radius Tip	
Side and Back Rake Angles	



Finished Tool

