



SHARPENING INSTRUCTIONS

How To Correctly Sharpen **Black Magic**



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Black Magic™ Sharpening Instructions

The **Black Magic** fleshing disc is manufactured from the same high quality, 440 stainless steel found in most modern knife blades. The disc is first machined tooled from a stainless steel blank and then subjected to a two step heat treatment process to produce a blade with good edge retention.

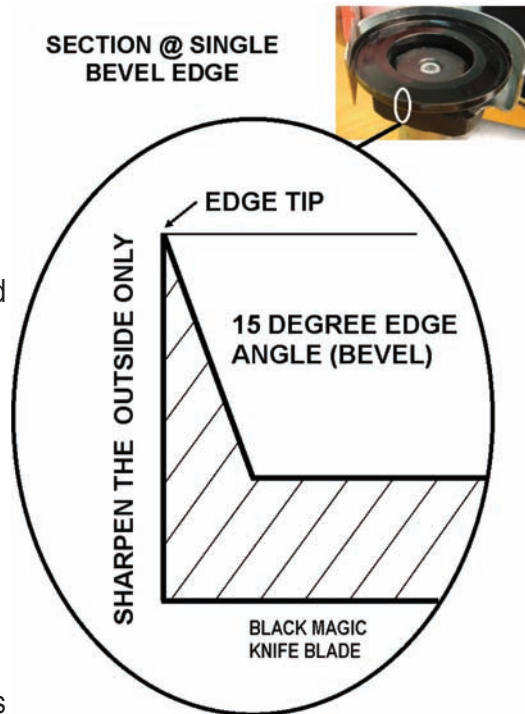
Most people are familiar with knives that are produced with the more familiar double bevel edge, but the **Black Magic** blade utilizes a single bevel edge. Utilizing the single bevel edge allows the blade to be re-sharpened without the operator having to worry about maintaining the correct edge angle (bevel).

The edge angle (or bevel) is set to 15 degrees, which is the ideal angle for a filet type knife blade. The width of the blade edge tip is approximately five thousandths (.005) of an inch or less.

When sharpening, the idea is to **remove material from the flat side** of the knife blade, exposing a new cutting edge.

We recommend that you use our **Diamond Grit File (Part # 11051)** when sharpening the **Black Magic**. Only use water as a lubricant and be sure to rinse and dry after each use. To clean the file, use an abrasive kitchen cleanser (non-petroleum based) and a scrub brush.

SECTION @ SINGLE BEVEL EDGE



HAND HELD SHARPENING

Secure the **Merlin Angle Grinder** in an upside down position, exposing the blade.

With the **Merlin** set on the slowest speed, rest the edge of the diamond file on the safety guard.

As you use the safety guard to steady your hand, gently press the file to the outside edge of the disc while holding the file parallel and level to the edge.

Apply mildly firm and consistent pressure. You need not exert extra pressure – let the diamond file work for you.

Turn the grinder off and check the sharpness.

Repeat as required to get the edge you want.



BENCH SHARPENING

Secure the flat, diamond tipped file to a flat surface.

With the **Merlin** set on the slowest speed, keep the outside edge of the disc level and parallel to the diamond file, then gently press the disc to the file. You need not exert extra pressure - mildly firm, level and consistent pressure lets the diamond file work for you.

Remember that you only need to remove a couple of thousandths of an inch of material from the flat side of the knife blade to expose a new cutting edge.

Sharpening is easy when you concentrate on keeping the outside edge of the disc **level** and **parallel** to the file.

