

2 x 72 Belt Grinder (Linature) Video

2 x 72 belts

(VSM Ceramic belts made in Germany) inexpensive but good
TruGrit has, \$5 - \$7 ea
<https://trugrit.com/>

Start with

Ceramic 36 grit for fast removal (or 24 grit if you want to be really aggressive)
piece will tend to stay cooler

60 grit ceramic - initial shaping
piece will warm

100 grit ceramic
piece will get hot

Finishing

3M Trizact
Will need belt cleaner
a bit pricy, but last a long time
from TruGrit, about \$10 each

120 grit

220 grit

Polishing

Scotchbrite
But alternative brand (Red Label)
Also good for mill scale
Amazon - Red Label Abrasives 2 X 72 Inch Non Woven Surface Conditioning Sanding Belts for Knife Makers and Metal Fabricators - Coarse, Medium, and Fine Grits - 3 Pack Assortment. Set of three about \$50 from Amazon
There is also an Extra Fine version

Norton Norax belts
pricy but good
Have to search to find but Texas Knifemaker's Supply regularly carries <https://www.texasknife.com>
Come in up to at least 3000 grit, about \$12 per belt.

600 grit

1200 grit

Good for putting edge on a knife

I have belts up to 2000 grit. After that, for polishing steel (or aluminum), I use 3M Trizact disks in 35, 10, and 5 micron grits in a random orbital sander and final polish with 3M Fine Machine Polishing Compound on a buffing wheel. Gives a mirror finish. (But, as I've been told many times, avoid a 'mirror' finish - it shows every flaw. (but done right it's exquisite))

With coarser grits, the heat tends to leave the piece with the ground off pieces (chips and sparks). Higher grits tend to leave the heat in the piece. So, for the same grinding speed and pressure, something being ground with a 24 grit belt will not get as hot as something being ground with a 220 grit belt. This becomes especially true at grits above about 600.

Sources

Tru-Grit	https://trugrit.com/
Texas Knifemakers Supply	https://www.texasknife.com
Amazon	www.amazon.com
Jantz	https://knifemaking.com/
Pops Knife Supply	https://popsknife.supplies/
Alpha Knife Supply	https://www.alphaknifesupply.com/shop/

Maverick Abrasives <https://www.maverickabrasives.com/>

Combat Abrasives <https://www.comatabrasives.com/>

(Both of the above appear to be the same place doing business under 2 different names.

Combat site is easier to navigate. I've had recent reports that their belts are poor quality.)