

SAFETY FIRST



Disconnect power source when making adjustments to machine or tool



Always wear proper ear protection when working with power tools or machinery.



Use caution when handling sharp objects (saw blades, router bits, drill bits and so on). Use protective gloves whenever possible.

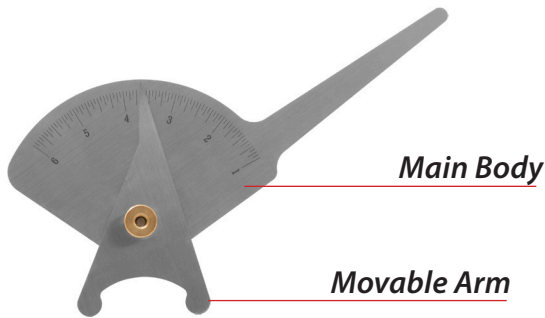


Always wear proper eye protection when working with power tools or machinery.



Always wear proper respiratory protection when working near airborne dust particles.

Please read and fully understand any and all safety materials that came with your power tools or machinery before operation. Always follow all safety guidelines set in place by the power tool or machine manufacturer.



Variable #2

Leg position. The trick is to remember which position does which grind and use the proper position. On a one-way Wolverine I will refer to the leg position as 2nd notch down from the top, or 5th notch down from the top.

SHARPENING GAUGE:

There are basically two parts to the Turning Tool Sharpening Gauge. First is the **MAIN BODY** which has a pivot leg and the linear scale. The second part is a **MOVABLE ARM** and uses two durable contact points which are designed to be placed against the grinding wheel (while it is stopped. Never while it is turning.)

GRINDING VARIABLES:

There can be three variables when grinding spindle gouges or bowl gouges. The secret to effortless repeatable sharpening is to eliminate as many of these variables as possible.

Variable #1

Tool projection. For most of us, a 2" tool projection beyond the tool holder is the perfect distance. The solution to eliminating this variable is to use a gauge block to assure the projection is 2" each time.



Variable #3

Position of the pocket arm. That is the device that positions the bottom of the gouge holding accessory. The one-way Corporation refers to theirs as a VariGrind jig and that may be the one most folks are familiar with. The most common way to set this distance is to place the gouge into the tool holding device and adjust the position of the pocket until the nose of the lathe tool seats perfectly against the grinding wheel. This method over time proves to be hit or miss at best. A little error each time will soon result in a grind which may be unusable. Different people have designed setting devices and various gauge blocks to assure that this angle always works regardless of the changing diameter of most abrasive grinding wheels. Some work better than others.

DISCOVER THE "MAGIC NUMBER"

First, set your sharpening jig the way you normally would placing the bevel of the gouge on the wheel until it seats perfectly and lock the pocket in position. Then simply place the pivot leg of the universal setting jig into the pocket arm. Then loosen the tightening knob holding the movable arm and place the two contact points against the grinding wheel. Tighten the movable arm. Then read the number on the linear scale and record it. You have now discovered the magic number for this gouge.



The key to remembering which settings to use on what tool is to write it down. I prefer to write the numbers directly onto the tool handle.



In my case I use a simple sharpie. I stick with the standard 2 inch projection so I do not have to write that down. The universal setting gauge uses an easy to read numbered linear scale. Set the leg of the universal setting jig into the pocket, place the movable arm against the grinding wheel so that it makes simultaneous contact with the top and bottom contact points and lock the arm in place. A quick look at the linear scale will indicate a number. Record that number (I like to write mine on the handle) someplace safe. The second component would be the leg position. I simply add number after a comma to this formula like this: 4.8,2.

TURNING TOOL SHARPENING GAUGE



Wouldn't it be wonderful if you could pick up any HSS lathe gouge you own and reproduce that grind exactly every time? Now you can and it is easy with the Turning Tool Sharpening Gauge. The Turning Tool Sharpening Gauge allows you to record the exact setting of your turning tool grind and reset your sharpening jig as needed. Simply sharpen your turning tool to the desired setting and once you're finished, set the gauge on to your gauge, lock in place and record the setting.