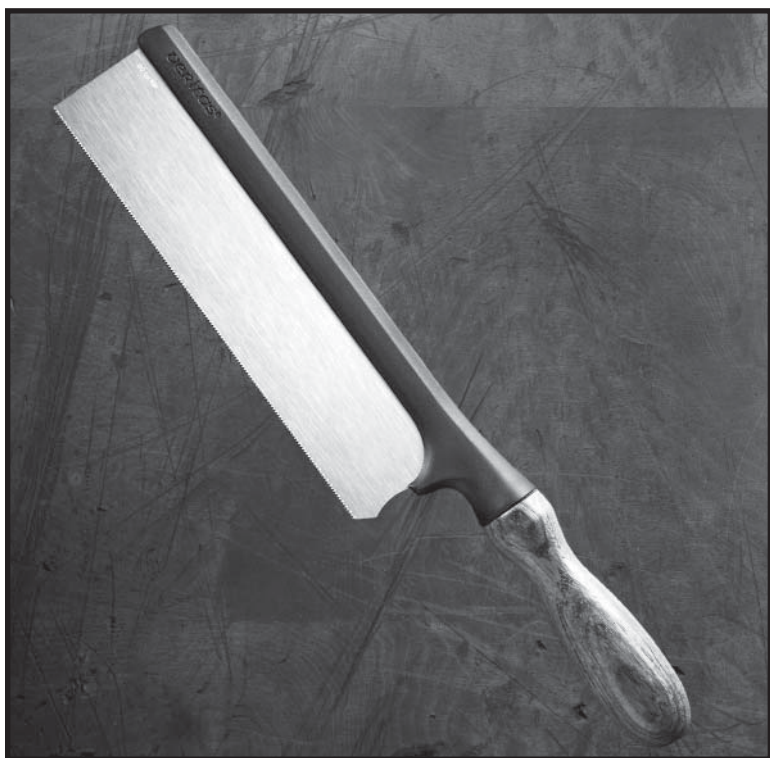


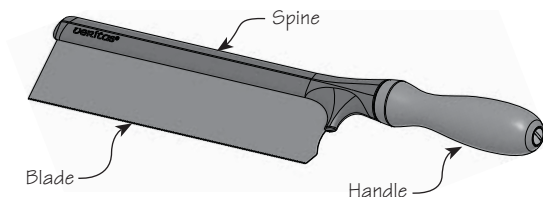
*veritas*®  
**Gent's Saw**



**05T10.01**  
**05T10.05**

The Veritas® saws combine the best characteristics of the classic gent's saw with those of state-of-the-art materials and construction methods. The tooth pattern on the thin high-carbon steel blade provides a good balance between cutting action and surface finish. The stainless-steel/glass/polymer composite spine provides strength and rigidity.

The fine tooth pattern on each saw (20 tpi rip and 22 tpi crosscut) is intended for use on material 1/2" or thinner. The blades are only 0.015" thick, with minimal tooth set for fast, low-effort cutting.



**Figure 1: Veritas Gent's Saw.**

## Sawtooth Geometry

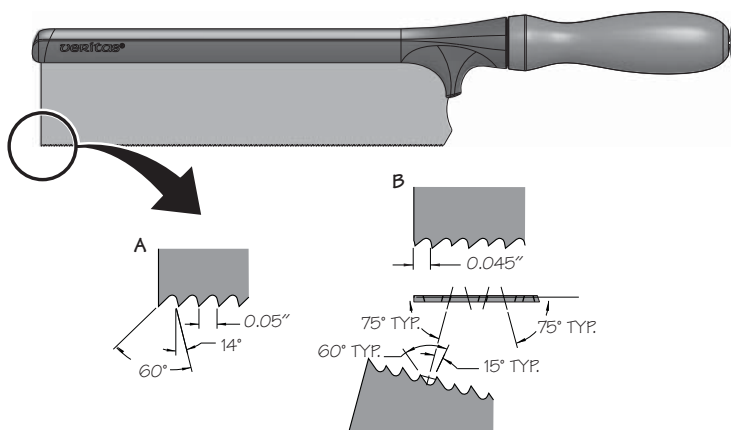
The teeth on the rip gent's saw are filed at 20 teeth per inch, with a 14° rake using the typical 60° included angle. Set is 0.003" on each side.

The crosscut gent's saw has 22 tpi, filed with a 15° rake and a 60° included angle. Set is the same (0.003" per side). The teeth on this saw are not filed directly across the blade (90°), but at an alternating 75° angle to the blade, which creates a 15° bevel on each tooth. Unlike rip teeth that are a series of little chisels, crosscut teeth are a series of little knives. A double-extra-slim file will be necessary for sharpening these teeth.

As supplied, these saws will have residual sharpening burrs on the teeth. While the burrs will disappear as the saw is "broken in", a light stoning before initial use will improve starting cuts. Place the blade on a flat surface, letting the spine overhang the edge. Lightly run a stone (no coarser than 1200x) over each side of the blade, taking no more than one stroke per side.

**⚠ Caution:** *Stoning will reduce the set in the teeth. Since there is very little set in the teeth, you want to be sure not to remove too much of it.*

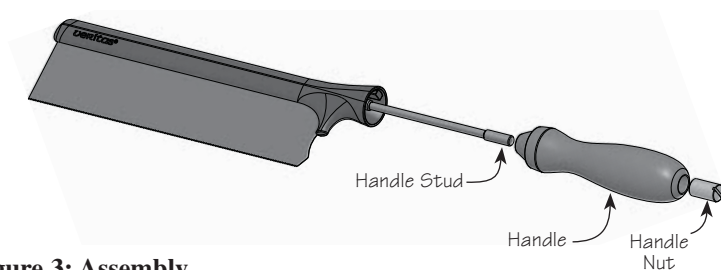
Since the blade is high-carbon steel, the teeth can be resharpened when necessary. Please refer to references, such as *The Complete Guide to Sharpening* by Leonard Lee (Taunton Press), for detailed directions on sharpening a saw blade.



**Figure 2: Sawtooth geometry for rip (A) and crosscut (B) gent's saws.**

## Replacing the Handle

The joint between handle and spine is such that sawing loads are not transferred through saw bolts. Since it is attached to the spine using a single threaded stud, the handle can be quickly replaced if necessary.

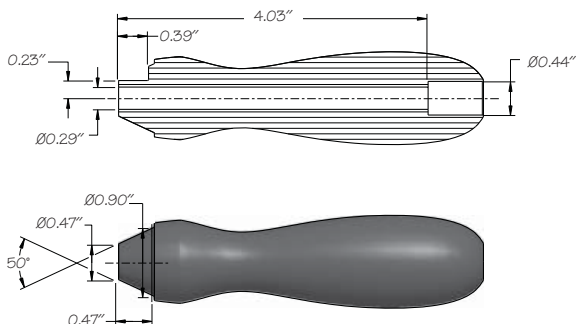


**Figure 3: Assembly.**

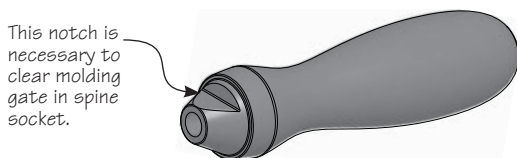
While the handle shape has been carefully developed to offer the best comfort level, we recognize that every woodworker has a preferred handle type. You may want to modify the existing handle, or make your own from scratch. You can make your handle any size or shape that fits your hand; however, keep in mind the dimensions for the tapered tenon, the depth of the counterbore for the handle nut and the notch in the tapered tenon (see **Figure 4**) to ensure your handle will fit properly into the spine socket.

1. The taper angle on the tenon is sized to fit into the spine, so it needs to be accurately created; however, the tenon itself can be a little larger in diameter than the dimensions shown in **Figure 4**.

2. The hole diameter for the handle nut needs to be as shown in **Figure 4**, while the depth of the hole for the handle stud can be slightly deeper than the 4.03" shown (such that the counterbore for the handle nut is slightly shallow to start with).
3. The 0.39" notch in the tapered tenon is necessary to clear the molding gate in the spine socket.



**Figure 4: Handle template.**



**Figure 5: Notch detail.**

## Care and Maintenance

- To ensure many years of service and to prevent damaging the fine teeth, always store the saw with the blade protector in place.
- A light coating of wax will prevent the blade from rusting.
- Rubbing paraffin wax on the side of the blade just before use will also allow the saw to run more smoothly through the cut.
- Do not use beeswax candles; beeswax will gum everything up.

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