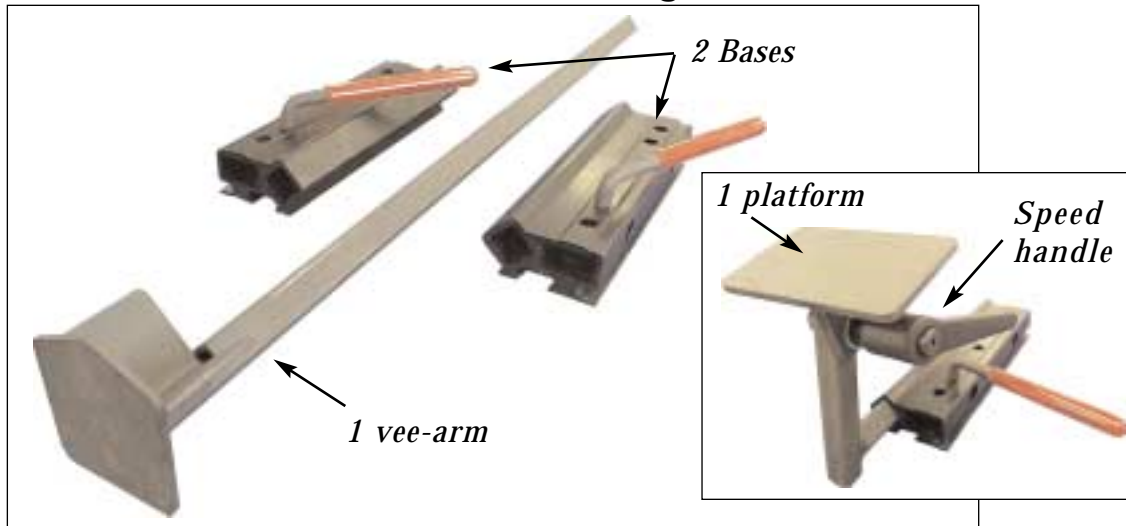


WOLVERINE GRINDING JIG INSTRUCTIONS

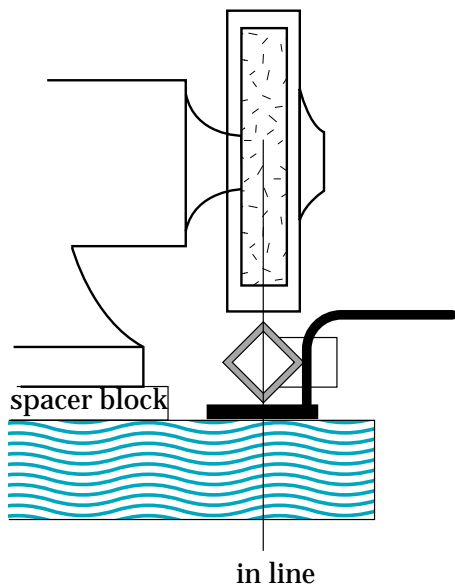
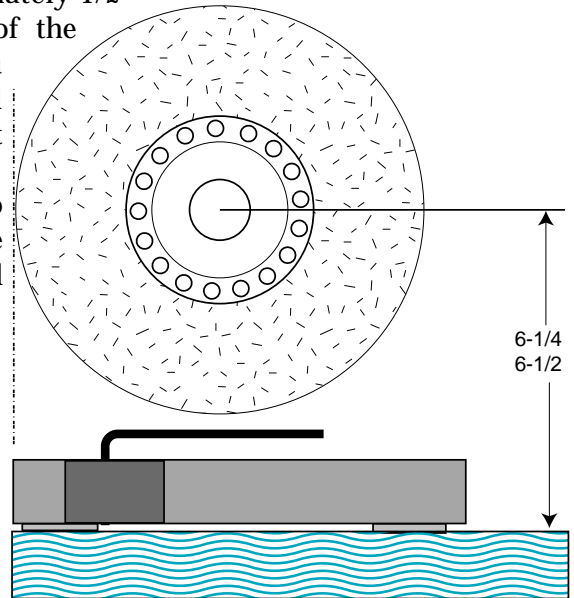
Contents of Package



Setting Up - Mounting the Bases

For your new *ONEWAY* Wolverine Grinding Jig to work best, your grinder and your grinding jig should both be mounted on a board or a bench so that they cannot move in relation to each other. The base should be mounted directly centered under your grinding wheel. Slide the vee-arm into the base to ensure that the centre of the pocket lines up with the centre of your wheel.

The front of the base should be flush to the front of the grinding wheel. The base must be approximately 1/2" (or less) from the front of the mounting board. Once you have the base positioned use four screws to anchor it in place. Two bases are provided to allow easy, interchangeable grinding between left and right wheels.



Notes

1. Rubber feet underneath the grinder should be removed and be reinstalled underneath the mounting board if required.
2. With some grinders (particularly 6 inch grinders) it may be necessary to mount your grinder on a spacer approximately one inch thick to achieve the 6-1/4 minimum dimension. This will be necessary if any part of the base interferes with the wheel guards and when using the *ONEWAY* dressing jig.

Instructions For Grinding

You now have two ways of supporting your tools for grinding:

1. the vee-arm and
2. the platform.

1. Using The Vee-Arm

The vee-arm can be used to grind bowl-gouges, roughing gouges, and skewes.

All **Gouges** are ground with basically the same technique. Slide the vee-arm into the base. With the grinder turned off, rest the handle of your tool in the vee-arm pocket. Slide the vee-arm in or out of the base until the bevel of your gouge lays flat on your wheel and then clamp the vee-arm in place with the locking lever.

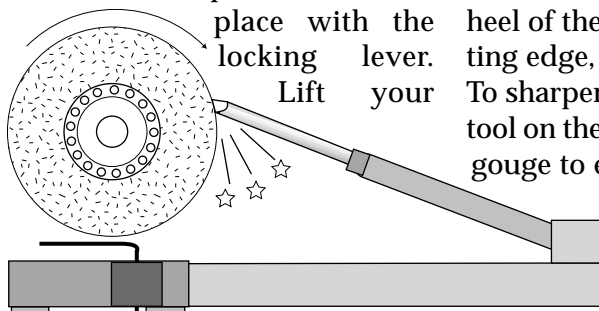
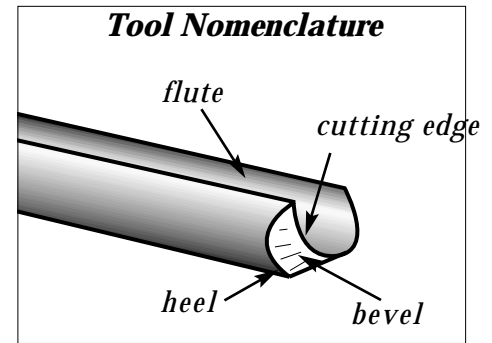


Figure 2

Lift your gouge off the wheel and turn the grinder on. Gently touch your gouge to the wheel. Check the position of the vee-arm by lifting the tool off the wheel and looking at the grind marks on the bevel. If the grind marks are even on the whole bevel, then the vee arm is adjusted properly. If the grind marks are just on the cutting edge you will have to adjust the vee-arm in. If the grind marks are on the heel of the tool, away from the cutting edge, move the vee-arm out. To sharpen a bowl gouge touch the tool on the wheel (fig 2) and roll the gouge to each corner of the gouge.

The further you roll the tool, the further back



the ears will be ground. How far back you grind the corners is a matter of personal preference but most turners will grind them back about 10 to 20 degrees. A good general purpose bevel angle is 45 degrees (figure 3).

Sharpening Chisels

Standard wood chisels are easily ground using the base and vee-arm.

Adjust the arm to set the bevel and grind the chisel with small sideways motions and light cutting pressure.

Cool often as most chisels are carbon steel which softens when turned blue with heat. Three or four strokes on a strop will generate a razor sharp edge on this tool.

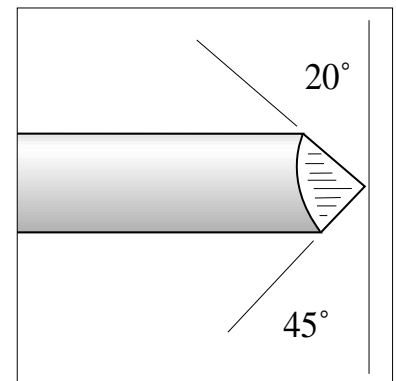


Figure 3: Bowl gouge side view

The Roughing Gouge

The **roughing gouge** is ground much the same way as a bowl-gouge but should have a different geometry when you are finished grinding. Instead of grinding the ears back 20 degrees, the end of the tool should

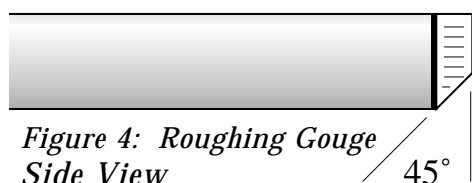


Figure 4: Roughing Gouge Side View

remain square (figure 4). When you are grinding these two tools you will find

that different areas of the tool will grind away at different speeds. It is important to watch the shape of the tool as you are sharpening and to spend more time grinding some areas of the tool and less time grinding others. Also please note that bevel angles are starting values only. Modify them to meet your own turning style.

Skews

Skews are ground much the same as bowl or spindle gouges. Start by locating the bevel. After this step, a simple small sideways sliding motion will quickly regenerate a sharp tool. Use light cutting pressure, turn over frequently for even sharpening and keep the tool cool

by dipping in water. After grinding, a few strokes on a strop will remove the small burrs present at the cutting edge. The skew and scraper are the only turning tools requiring stropping or honing of the cutting edge after grinding. To sharpen the rounded skew or

Richard Raffan shape, first establish your radius by grinding on the platform. Then grind in the vee-arm by rocking/rolling the tool exactly as when sharpening a gouge. A radius fixture is not needed to obtain this grind (figure 6).

End view of cutting edge of radius skew
Arrow shows motion skew must make on grinding wheel to grind this profile.



Radius Skew Top View

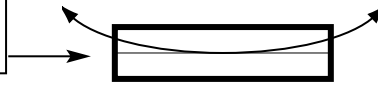
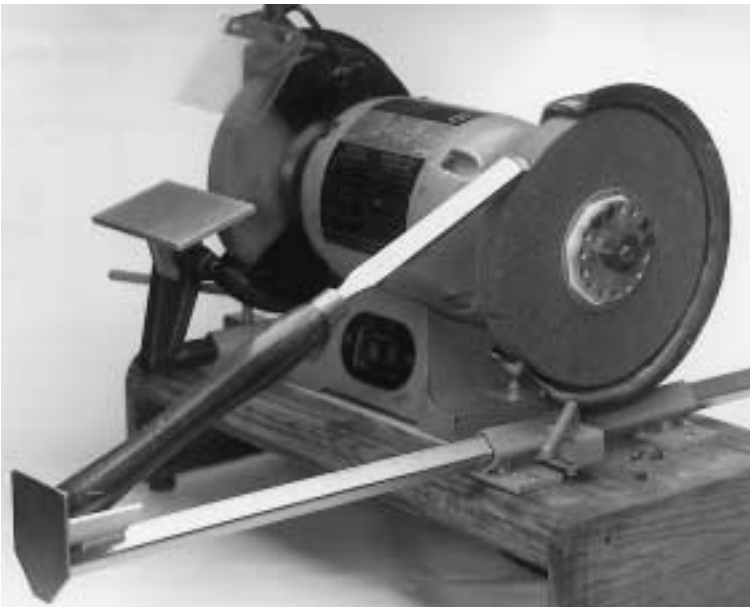
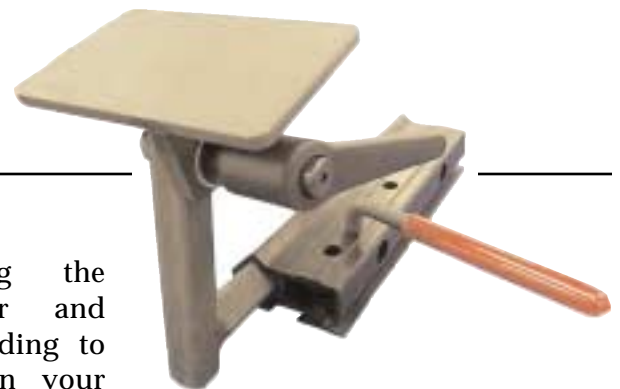


Figure 6.



Tip

If you are working on something that will require the tool to be resharpened a number of times, leave the vee-arm clamped in place. This will allow you to quickly and easily reproduce the bevel angle and to remove minimal material from your tools. If a tool is dull when you are finished with it resharpen it before you put it away. That way all your tools are sharp all the time.

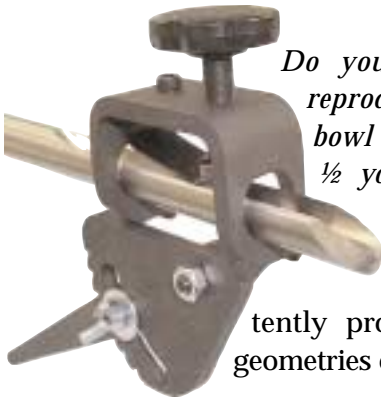


2. Using the Platform

With the grinder turned off, slide the assembled platform into the base. Please note that the platform can be used on the left or right side of the grinder. Clamp the platform arm in place with the locking lever so that the platform is held securely. Adjust the platform so that the tool meets the wheel at the desired angle. Reset to the minimum distance from the wheel before

starting the grinder and proceeding to sharpen your tool.

Vari-Grind Attachment



Do you find it impossible to reproduce the grind on your bowl gouge without grinding 1/2 your tool away?

The Vari-Grind Attachment will consistently produce sharp, repeatable geometries on turning tools.

The Vari-Grind Attachment will easily and consistently perform the following:

- ✓ fingernail grind
- ✓ bowl gouge grind
- ✓ side or Irish grind

Side Grind (Irish Grind)

While attending many wood shows and symposiums, designers at *ONEWAY* recognized that the side (or long grind) on deep fluted bowl gouges has become very popular. This shape is superb for rapid hollowing, and is useful on the outside of bowls. Once you learn how to use it, it will be one of your favorite grinds.



Three tools that are very popular and useful are the classic fingernail shape, the traditional bowl gouge and the new side grind configurations. These shapes however are difficult both to grind and to maintain.

Vari-Grind Part No. 2480

Skew Jig

Save TIME and MONEY with Oneway's Skew Grind, every time you use it!

Our Skew Jig (specifically designed to work with our Wolverine Grinding Jig) will perform the following:

- ✓ increased safety
- ✓ flat bevel
- ✓ bevel and cutting edge parallel
- ✓ same bevel every time
- ✓ minimal material waste

One reason that the skew leaves such an incredible finish on work pieces is due to its very thin edge which leaves naturally cleaner cuts. This creates a problem

with sharpening the skew as this thin edge will easily fold over during grinding. *ONEWAY's* Skew Grinding Attachment minimizes this problem by allowing the

skew to be mechanically held. The unique offset handle position actually reduces the hollow grind generated and leaves a stronger more predictable tool.



The Skew Grinding Attachment produces a virtually flat bevel with greatly improved cutting characteristics.

This fixture is a highly recommended option with our Wolverine Grinding System.

Skew Grind Attachment Part No. 2690

WHEEL DRESSING - Wolverine Dressing Attachment

Grinding wheels must be dressed to keep them sharp and clean. Grinding wheels, like sandpaper, become dull with use; the grit breaks down and becomes dull. If grinding wheels are not sharp, they begin rubbing rather than cutting, which results in increased friction. Higher temperatures and burned tools are the result. Wheels must also be kept free from metal particles that build up during sharpening. Like sandpaper that gets clogged with sawdust during sanding, grinding

wheels become clogged with metal particles during grinding.

For optimum result when grinding tools, we suggest you obtain our Wolverine Dressing Attachment. It is the only dresser available for low cost bench grinders allowing controlled removal of the 0.001" to 0.002" per pass required. We guarantee a round, clean, sharp wheel when using this dresser on balanced wheels.

Wolverine Dressing Attachment Part No. 2292