

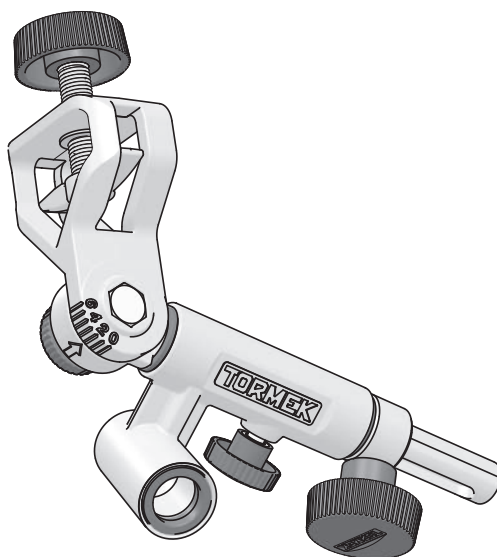
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# SVD-186 R Instruction



## **PATENT**

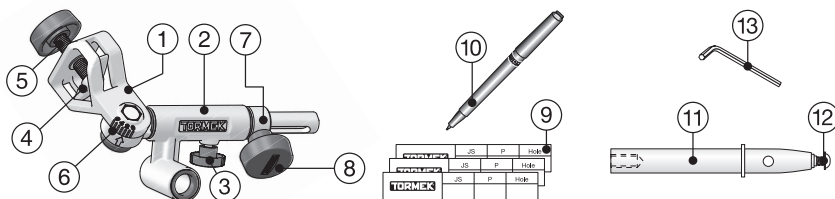
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# Gouge Jig SVD-186 R

*For detailed instructions, please see the Tormek Handbook HB-10!*

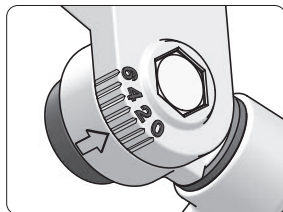
## Design

The jig comprises a *tool holder* (1) which runs in a *sleeve* (2). The *locking knob* (3) locks the rotary motion of the gouge jig. The tool is aligned with a *disc* (4) and tightened with a *screw* (5). Easy and precise *click setting* (6). The *stop ring* (7) can be set with the *screw* (8) in order to round off the heel of the grinding bevel. The setting can be noted on a special *recipe label* (9), which is attached to the ferrule. *PP-10 Profile Pen* (10), which works on the labels is included. For turning cutters there is a *shaft* (11) with a *mounting screw* (12) and a 2.5mm *allen key* (13).

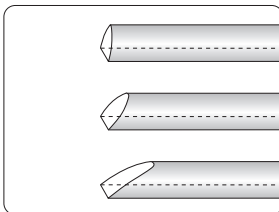


## Turning Gouges and Carving Tools

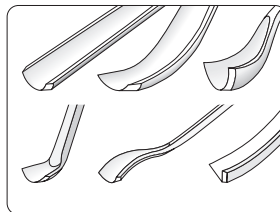
You can grind turning gouges with the so called fingernail shape as well as carving gouges with various shapes. You can also grind straight and curved V-tools.



The jig can be set from 0 to 6, which permits the grinding of ...



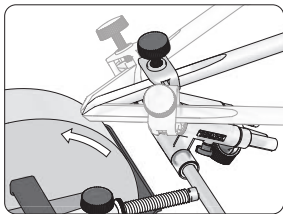
... turning gouges with various lengths of side bevels and ...



... carving gouges with various shapes and V-tools.

## Shaping and Sharpening Turning Gouges

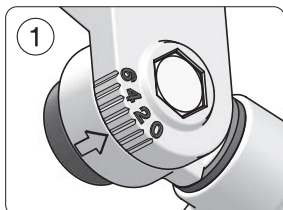
You can do the initial shaping either directly on the Tormek machine or on your bench grinder using the Tormek Bench Grinder Mounting Set BGM-100. When you need to remove a lot of steel, e.g. when decreasing the edge angle or changing the shape, you can use a bench grinder which removes steel faster. For best result, use the Gouge Jig SVD-186 R together with the Tormek Turning Tool Setter TTS-100. It enables you to exactly create and replicate the edge on your bowl and spindle gouges. Once you have created the shape of the edge, it is an easy task to quickly re-sharpen the tool. The sharpening should be done on your Tormek machine for the best finish and to ensure that the edge is not overheated.



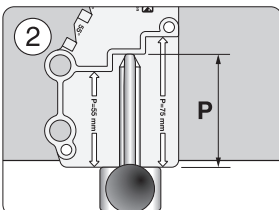
Sharpen with a light pressure and swing the tool from side to side. Since the shape is exactly replicated and the edge is just touched up, the sharpening takes just 20–30 seconds.

For woodcarving tools, please see the Tormek Handbook HB-10.

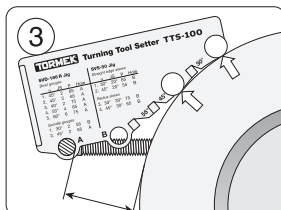
These three factors determine the geometry of a gouge



Jig setting, JS.

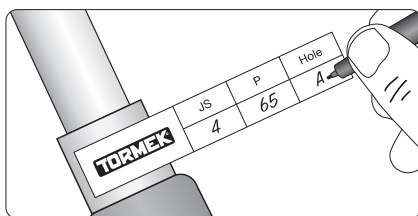


Protrusion, P.



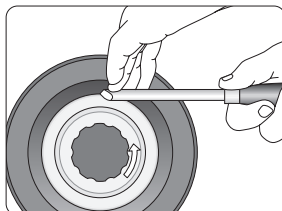
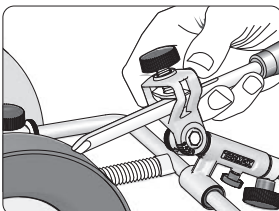
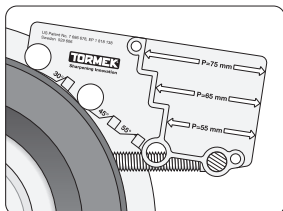
Distance to stone, hole A or B.

With the Turning Tool Setter TTS-100 shown above you control these factors. Note the settings on the Profile Label and put it on the ferrule. After the initial shaping you can exactly replicate your favourite shape at every sharpening in less than a minute.



## Honing

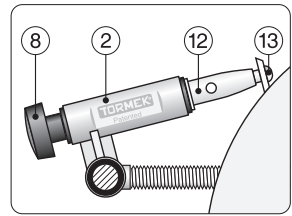
Honing and polishing the bevel and the flute to a finer finish will make the sharpness more durable.



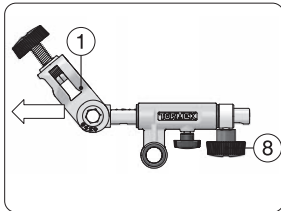
## Turning Cutters



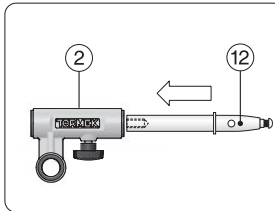
When sharpening turning cutters, the shaft (12) replaces the tool holder (1) and it is mounted in the sleeve (2) with the screw (8). The tool is fixed with the screw (13).



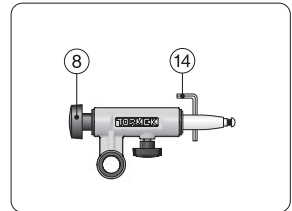
### Mounting the jig



Loosen and remove the screw (8) and the tool holder (1).

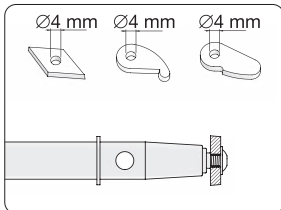


Insert the shaft (12) into the sleeve (2). Note: Position the sleeve according to the picture!

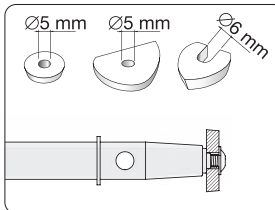


Mount the screw (8). Lock the shaft with the Allen key (14) when tightening.

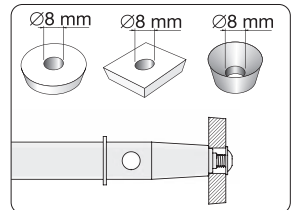
### Mounting the cutter



Cutters with 4 mm ( $\frac{1}{8}$ " ) holes are centered by the M4 screw.

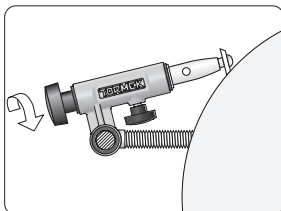


Cutters with 5 and 6 mm ( $\frac{3}{16}$ " -  $\frac{1}{4}$ " ) holes are centered on the first shoulder on the shaft.

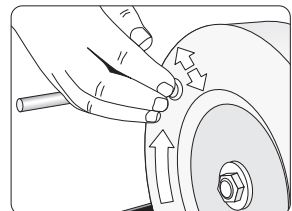
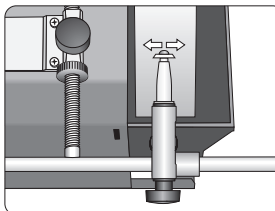


Cutters with 8 mm ( $\frac{5}{16}$ " ) holes are centered on the second shoulder on the shaft.

### Sharpening



Rotate the jig all the time during the sharpening so you achieve an even grinding around the whole circumference. Use only a light pressure for the best result. Slide the jig sideways on the Universal Support so the grindstone wears evenly.



Smooth the back on the machined, flat outside of the grindstone. Move the cutter in order to use the whole surface of the stone.