

ensure a perfect grind; it will give a perfect one facet bevel but you have to watch what you are doing and control the shape of the tool that is being ground.

Areas of some tools may grind faster or slower than other areas. If the long cutting edge is not straight, but curves up, grind a bit more off. If the edge curves down next time grind less off. Pay special attention to the nose of the tool. The nose grinds very quickly so use a light touch on the nose and try to keep the radius on the nose as big as possible. Try not to let the tool get too pointy.

Start grinding on the side of the gouge. If you are side grinding a tool for the first time, there is a tremendous amount of material to come off. Work on one side and part of the nose, then do the other side and part of the nose. Finish by smoothing out the nose.

When grinding the nose there is a tendency for the jig to slide forward in the pocket of the vee-arm, so watch what you are doing.

Re-Grinding a Tool

If you are regrinding a tool set the position of the vee-arm by matching the bevel on the side of the tool, not the nose. Slide the arm in or out to match the existing bevel on the side as close as you can. Turn on the grinder and then lightly touch the side of the tool to the grinding wheel. If the angle doesn't match exactly, loosen the clamp and just tap the vee-arm in or out to fine tune the angle.

What if I don't have the Wolverine Grinding Jig?

If you are using the jig without a **ONEWAY** Wolverine Grinding Jig, you will need to grind the 65° angle on the front of the gouge freehand. Next put the gouge in the Vari-grind and line up the bevel you just ground with the grinding wheel and with the jig touching the bench in front of your grinder. Mark where the jig touched and drill a dimple. Use a standard 3/8" drill and drill a hole as deep as just the point. This will allow the jig to pivot freely in the hole.



Figure 3.
Vari-Grind in the "down" position -
ready for a side ground tool



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Vari-Grind Attachment

The ONEWAY VARI-GRIND Attachment can be used to quickly and easily grind a fingernail profile on a shallow spindle gouge and a side grind configuration on a deep fluted bowl gouge.



Part No. 2480