

Initial Setup

Before using your *ONEWAY* Vari-Grind Attachment a setting block should be made so that distance "A" as seen in Figure 2 can be quickly and easily duplicated. This can be done by drilling a 5/8" dia. hole into a block of wood 1-3/4" deep.

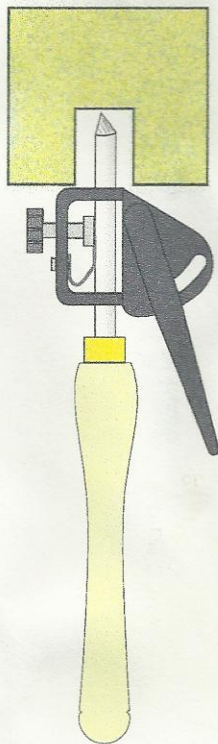


Figure 1.
Setting the Vari-Grind using a block of wood.

To use the setting block:

1. Slip the tool into the Vari-Grind Attachment
2. Put the Vari-Grind Attachment on the block.
3. Slide the tool into the drilled hole as far as it will go.
4. Tighten the knob

All tools ground using the Vari-Grind can use the same setting block.

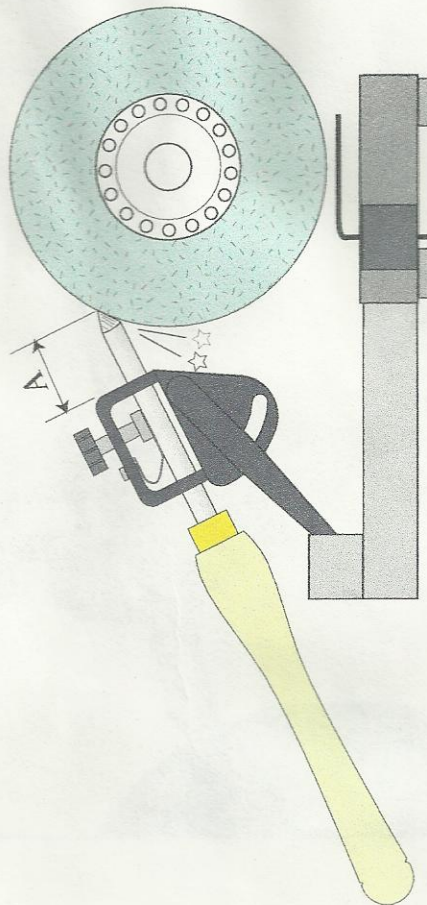


Figure 2
The Vari-Grind in the "up" position grinding a fingernail profile.

Dimension "A" should be between 1-3/8" and 2", with 1-3/4" being just about ideal. The exact dimension is not critical but it should be the same every time you regrind the tool. The reason for this is twofold: less material will be removed every time you regrind your tool, and it will be much easier to keep the same shape of the tool.

Using the Vari Grind

To use the Vari-Grind Attachment, perform the following:

1. Insert the leg into the vee-pocket of the Grinding Jig.
2. With the wheel stopped, lay the tool on the wheel and slide the arm in or out until the entire length of the bevel on the tool is touching the wheel.
3. Lift the tool off the wheel and turn on the grinder.
4. Touch the tool lightly to the wheel and check that the grind marks are even along the whole bevel.
5. Adjust the arm in or out to exactly match the bevel if necessary.
6. Swing the tool handle back and forth to grind the tool. Let the weight of the tool do the work.

Keep in mind that the Attachment does not control the shape of the tool. If, for example, you find that the tool nose is getting more pointy than you like, spend more time grinding the tip until you get the profile you want.

Instructional Video on how to use the Vari-Grind Attachment can be downloaded from our website at <http://www.oneaway.ca/multi-media.htm>

Using the Vari-Grind To Create a Side Grind

A side-ground gouge should have a bevel angle on the front of the tool of about 65° (the bevel on the nose of the tool should be short) and the sides should be ground back about 3/4". Most lathes don't have the power to remove a shaving larger than this, and grinding the edge back further will only make grinding the tool more difficult.

To grind a gouge, set the gouge into the fixture while it is in the "down" position as shown in Fig. 3. You may have to adjust the amount the tool sticks out from the jig to get enough clearance from guards or other things that may get in the way.

Slide the Vee-arm in until you get the 65° angle on the nose. The gouge is basically ready to be ground but there are some things to keep in mind. The jig won't

