

Making a turning tool to use carbide inserts.

These inserts are available for the helical blade planers.

See

<http://globaltooling.bizhosting.com/products/carbide-insert-knives.html#ick151525byrd>

(Shipping is \$26 for 10 or 20)

also marketed by "Easy Wood Turning Tools" in Lee Valley.

The steel shaft of the tool is a piece of 5/8" Sq Key Stock 14' long the tang is 4" long X 5/8" Dia



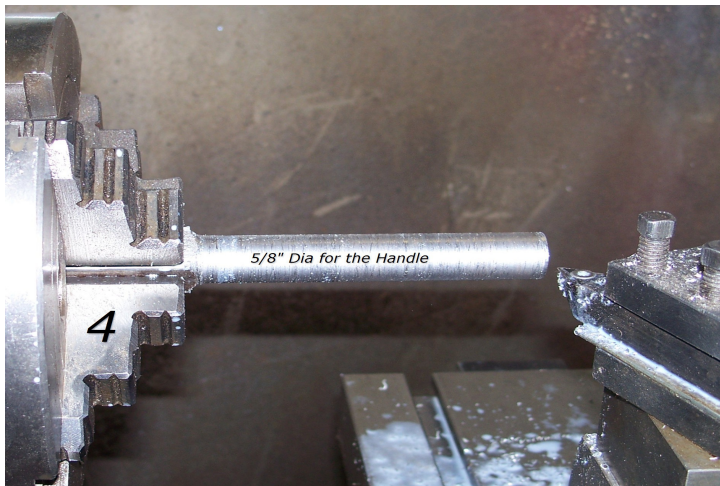
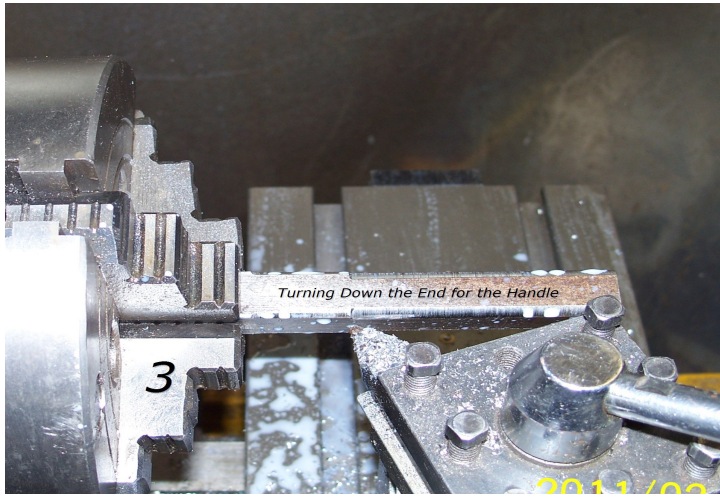
Photo 1

Here a fly cutter sharpened on the end to cut an angle on the back of the recess the same as the carbide insert, is used to cut the recess.



Photo 2

The carbide insert is used to set the depth and width of the recess note the top of the insert is about 3/32" below the top of the shaft and the front lower edge is flush with the end of the shaft.



Photos 3 & 4
Show the tang being turned down to 5/8" Dia for a length of 4"

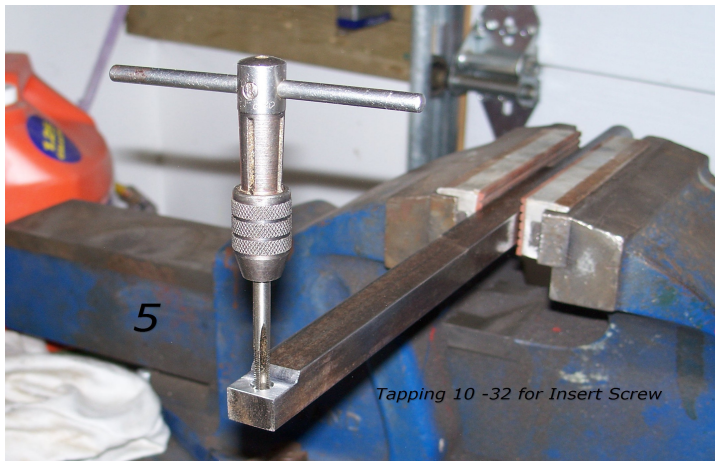


Photo 5
The recess has been deburred then using the insert pushed back into the corner the centre of the hole is scribed, center punched, drilled and tapped. The top of the hole is chamfered to clear the bottom of the 10 X 32 screw

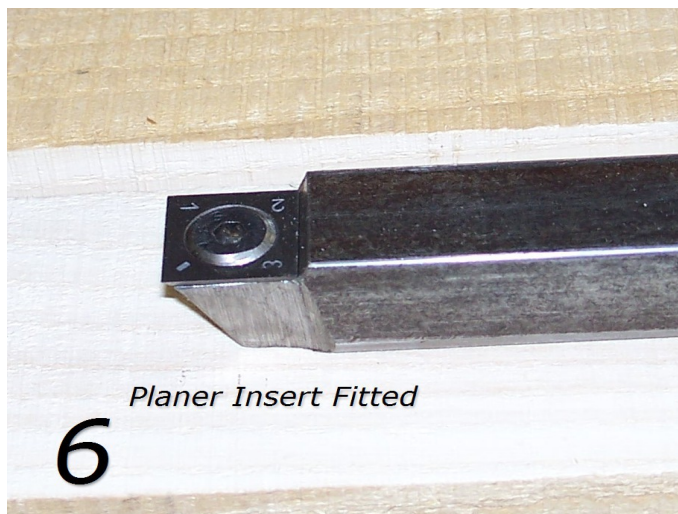
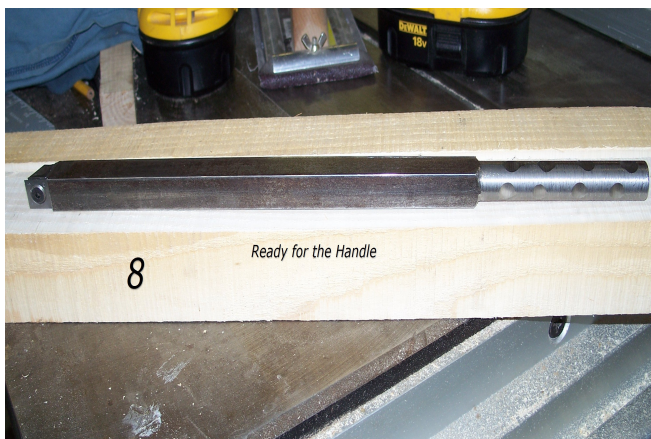


Photo 6

The carbide insert is fitted note the top of the screw has a chamfer ground on the top edge to encourage the chips to go over the top of it. Also the edges under the cutter have been ground away with clearance angles up to the bottom corner of the sides and front of the insert.



Photos 7 & 8

The finished tool shaft is shown laying on the piece of ash that will be used for the wooden part of the Handle.



Photos 9 , 10 & 11

This is a simple steady rest used to support the handle while the tang hole is drilled.



Photo 12

A couple of tools waiting for the glue to set sitting in a vice. Usually left over night.

You can see a video of how to make the 15min wooden handle on You Tube

<https://www.youtube.com/watch?v=CLJuEEIUaJE&t=119s>

This is a video of a tight fitted ferrule,

Note I recommend you remove the chuck with the handle in it, stand it vertical on a block of wood on the floor to pound the ferrule on. (Save the headstock bearings)

RJF.....