ONEWAY **MANUFACTURING**

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Quality Products, Designed by Woodturners for Woodturners.

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Sharpening the Cutter

Successful coring with the Oneway Easy-Core system is very dependent on a sharp cutter.
If the cutter is dull you will need to use excessive pressure on the handle, causing the knife to be forced off-line in the cut. As the cut goes deeper the groove will get more off-line and the cutter will widen the groove when you retract and re-insert the knife. If the groove gets too wide the knife will fall off the support causing a jam, and possible tool damage or breakage. Keeping the cutter sharp is the easiest way to avoid this.
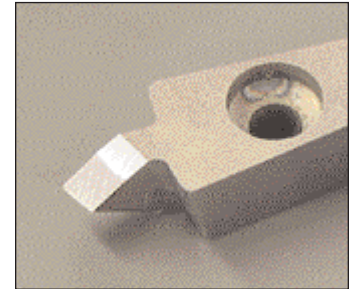
How often should I sharpen my cutter?
You should consider sharpening the cutter on the largest knife every core, on the second largest knife every other core, and on the smaller two knives every five or six cores. Rotate the cutters from the large knife to the small knife to extend the life of your cutters.

Honing vs Grinding
Sharpening on a honing stone will work if you remove enough material to get the edge sharp. Most people do not. Sharpening on a grinder works much better, and it's much easier to get the edge sharp.

Which surfaces should I sharpen?
When sharpening it is necessary to sharpen the **top face** and the **pointed nose**. Sharpening the top is done with the long length of the insert across the face of the wheel. This will give a slight hollow grind from the long side of the insert towards the hole, and will help the tool cut a tiny bit easier. It is difficult to get one continuos hollow grind across the face and is **not** critical.

Sharpen the Cutter as two sides
Sharpen once with the nose of the tool pointed left and once with the nose pointed right. The top of the cutter is flat, therefore you will have to remove a bit more material on the first grind to put in the hollow, than you will on subsequent grinds.

Pointing Right

Caution: *Keep some water near the grinder for the first time you sharpen the cutter, as it can get hot.*
After sharpening the top it is perfectly acceptable to see a feint line down the middle of the cutter (on top of the cutter).

Recent trials with the geometry of the cutter have resulted in a change to the nose configuration. If you own one of the old cutters, we recommend re-grinding it to this new geometry.
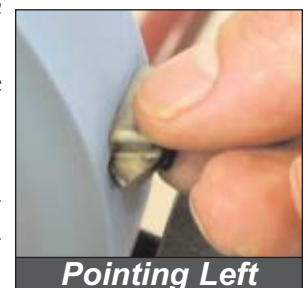
Pointing Left

SHARPENING THE CUTTER WITHOUT THE CUTTER SHARPENING JIG
Set the angle of your platform at 20 degrees. With the Cutter lying on it's left side, grind both the top and bottom of the nose while maintaining the 45 degree to the bottom of the cutter (as viewed from the side). You are finished once you have a 20 degree angle on the nose (as seen from the top of the cutter).
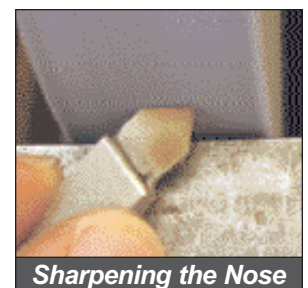
Important: Never grind on the grooved bottom of the cutter.

Sharpening the Nose

SHARPENING THE CUTTER USING THE CUTTER SHARPENING JIG (PN 3677)

You may use Method One OR Method Two. For either method the grinding wheel must be in good condition; round and flat. If you have grooves in your grinding wheel, Method One should **not** be used as satisfactory sharpening cannot be achieved. Once you decide on a method, do not change. Our preferred method would be Method One as both the point and top surface can be sharpened in one setting. We recommended using an 80 or 120 grit grinding wheel.

This item can be purchased separately.

Method One
1. With template #3676, set your grinding platform to angle "A" and Radius "R".
2. Using the 4 - 40 screw (supplied), fasten the insert on the grinding block.
3. Lay the fixture with the part number facing up on the grinding platform and sharpen both sides of the control point. Remove only a very small amount of material.
4. Set the fixture on its base and sharpen the face. Please note: the initial sharpening should be an area between the top cutting edge and the screw hole. Future grinding will enlarge this area.

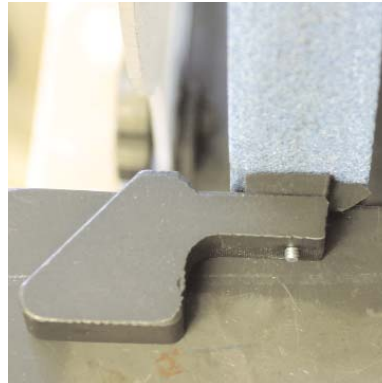| *Step 1* | *Step 3a* | *Step 3b* | *Step 4* |

Method Two
1. Sharpen the point as per Method One, parts 1 - 3 above.
2. To grind the face adjust the platform to template #3675. Lay the fixture down with the Part No. side up and sharpen the face.

| *Step 2a* | *Step 2b* |