

Step #1 – Rough shaping

- Cut 3/8” Mild Steel Rod into 8” length
- Grind a 3/8” slot to the half way point of the rod
 - Take time to make the surface as flat as possible
 - Fine tune with a file to increase flatness
- Place cutter on rod and mark position of hole
- Drill 2.5mm hole
- Tap hole for Torx screw
- TEST FIT the cutter using the Torx screw with a T8 Torx key
 - **DO NOT USE TOOL UNTIL STEP #2 AND #3 ARE COMPLETED**
 - It is not recommended to use a Drill Chuck Handle with this tool as the tool will not be held in by the required 2” minimum
 - A Hosaluk Handle Insert can be used if you desire to use a removable handle (available in the Woodturners Catalog)

Step #2 – Finish shaping

- See pictures below for tool end profiles
- With the cutter mounted on the tool, mark the area of the rod to be ground off by using a Sharpie pen
- Remove cutter and carefully grind rod to shape for the round cutter (DO NOT GRIND ROD WITH CUTTER ATTACHED)
- Remount as many times as necessary to ensure a good fit
- Using a file is very useful when making the final adjustments
- Be sure to grind an under cut on the rod so the tool will not rub keeping the cutter away from the turning wood

Step #3 – Mounting tool on handle

- Test fit finished tool into handle and ensure the tool does not extend over 6” (adjust depth of hole as necessary)
- Epoxy tool into handle (see picture below)
- Cutter should be rotated regularly to allow for even wear
- Be sure to protect the cutter as it is very sharp but also very brittle and could be ruined if the tool is dropped or bumped against your other tools

RESOURCES -----

Carbide Depot - www.carbidedepot.com - 800.786.6921

Wood Turning

Carbide Depot specializes in metal cutting tools for the metal machining industry, however we have been getting many calls from home hobbyists looking for carbide inserts to use in wood turning. Unfortunately, because of the way inserts and holders are marketed in our industry, we are not able to answer many of the questions from our wood turning customers. However we can now offer the following inserts and screws from our own brand Carbi-Universal, which are used by the vast majority of our wood turning customers using homemade built holders. We keep plenty of stock on each of these inserts and screws at our Carbide Depot warehouse in Birmingham, Alabama.

Screw-on Inserts

Carbi-Universal

■ RCGT-FX

catalog number	D	L10	S	Rc	D1	screw	thread pitch	plug taps			
	mm	in	mm	in	mm	in					
RCGT0803M0 FX CU313	8.00	.315	-	3.18	1/8	-	3.40	.134	TS-3.5-7M1	3mm X 0.5 pitch (7mm long)	M3 X 0.5 D3 3FL PLUG TAP
RCGT10T3M0 FX CU313	10.00	.394	-	3.97	5/32	-	4.40	.173	TS-3.5-9M1	3.5mm X 0.6 pitch (9mm long)	M3.5 X 0.6 D4 3FL PLUG TAP
RCGT1204M0 FX CU313	12.00	.472	-	4.76	3/16	-	4.40	.173	TS-3.5-9M1	3.5mm X 0.6 pitch (9mm long)	M3.5 X 0.6 D4 3FL PLUG TAP

Hosaluk Handle Insert (HHI)

- 2011 Woodturners (800.551.8876) Spring/Summer Catalog on page 14 for \$19.99 each
- 3/8" HHI Item number 462-1138
- 1/2" HHI Item number 462-1112

PICTURES BELOW ILLUSTRATE THE FINISH GRIND NEEDED FOR THE TOOL

Do not grind with carbide cutter mounted

