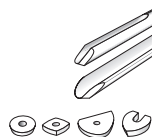


# Gouge Jig SVD-186 (SVD-185)



## TURNING TOOLS

Bowl gouges  
Spindle gouges  
Turning cutters



## CARVING TOOLS

Curved gouges  
Spoon-shaped gouges  
Back bent gouges  
Down bent gouges  
Curved V-tools



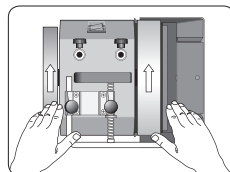
Max tool width 36 mm (1 3/8")

*SVD-186 is a further development of SVD-185.*

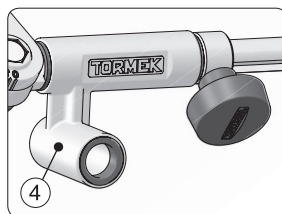
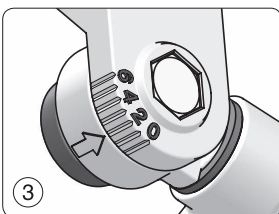
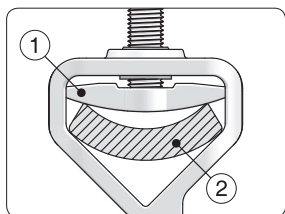
*SVD-186 now fits up to 36 (1 3/8") mm wide tools (2), has an improved disc (1) and an easy and precise click setting (3).*

*The lower sleeve (4) has been shortened in order to work better with the Tormek T-3 and T-4.*

## Positioning of Machine

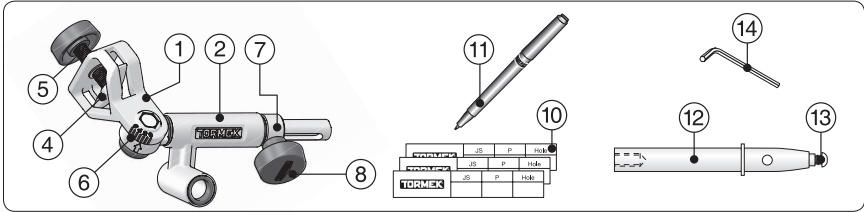


Grinding direction:  
Away from the edge.



## Design

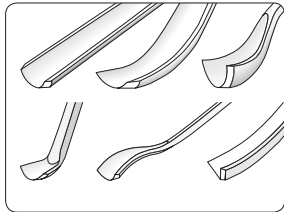
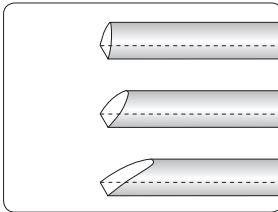
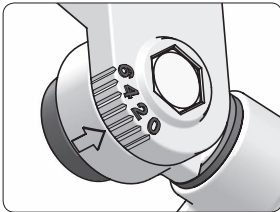
The jig comprises a *tool holder* (1) which runs in a *sleeve* (2). The tool is aligned with a *disc* (4) and tightened with a *screw* (5). Easy and precise *click setting* (6). The *stop ring* (7) can be set with the *screw* (8) in order to round off the heel of the grinding bevel. The setting can be noted on a special *recipe label* (10), which is attached to the ferrule. A special *pen*, which works on these labels is included (11). For turning cutters there is a *shaft* (12) with a *mounting screw* (13) and a 2.5 mm *allen key* (14).



## Jig setting

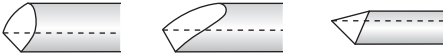
You can grind turning gouges with the so called fingernail shape as well as carving gouges with various shapes. You can also grind straight and curved V-tools.

The jig causes the tool to move towards the grindstone in a special way, according to the setting selected from 0 to 6. This means, that for turning gouges you can decide the maximum length of the side edges. For curved carving gouges, which are not ground with a fingernail shape, the jig setting compensates for the shape of the shank.



The jig can be set from 0 to 6, ... turning gouges with various which permits the grinding of ... lengths of side bevels and ... carving gouges with various shapes and V-tools.

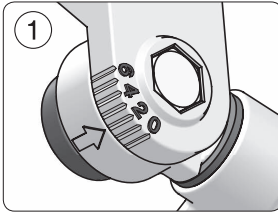
# Turning Gouges



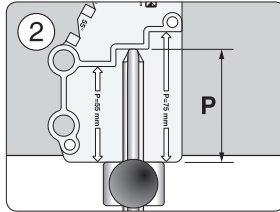
## Shaping

The jig positions the gouge on the grindstone so that you can get a specific and repeatable grinding at any point along the bevel. This enables you to get an even, single bevel around the entire profile from the left to the right wing.

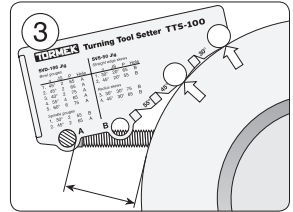
*These three factors determine the geometry of a gouge*



*The setting of the jig, JS.*

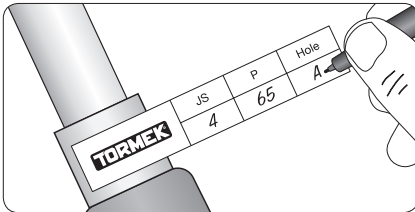


*The protrusion of the tool in the jig, P.*




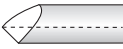
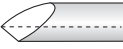
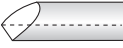
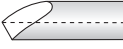
*Universal Support position. Use hole A or hole B.*



With the Turning Tool Setter TTS-100 you control these factors. Select the profile you want from the chart on the next page and use the three settings, which give that shape. Note the settings on the Profile Label and put it in the ferrule. After the initial shaping you can exactly replicate your favourite shape at every sharpening in less than a minute.



*Note the settings on the Profile Label and put it in on the ferrule. A set of labels comes with the jig.*

## Selection Chart

Bowl gouges				
1	$\alpha=45^\circ$		<b>JS</b> 2 <b>P</b> 65 <b>Hole</b> A	Standard profile. Only lightly swept back wings. For turners of all skill levels.
2	$\alpha=45^\circ$		<b>JS</b> 2 <b>P</b> 65 <b>Hole</b> A	Irish profile. Swept back wings. Swing the tool 180° from side to side.
3	$\alpha=40^\circ$		<b>JS</b> 2 <b>P</b> 75 <b>Hole</b> A	With long swept back wings. Somewhat aggressive. For professional level turners.
4	$\alpha=55^\circ$		<b>JS</b> 4 <b>P</b> 65 <b>Hole</b> A	The larger edge angle is beneficial when turning deep bowls.
5	$\alpha=60^\circ$		<b>JS</b> 6 <b>P</b> 75 <b>Hole</b> A	"Ellsworth" shape. Wings are pronounced convex.

Spindle gouges				
1	$\alpha=30^\circ$		<b>JS</b> 2 <b>P</b> 55 <b>Hole</b> B	For tight spots, detail work and finest finish. For professional level turners.
2	$\alpha=45^\circ$		<b>JS</b> 2 <b>P</b> 65 <b>Hole</b> A	Standard profile. For turners of all skill levels.

These geometries, i.e. the shape and edge, angle are recommended by experienced woodturners and recognized woodturning workshops around the world, e.g. Craft Supplies in USA and Drechselstube Neckarsteinach in Germany.

Since a tool can have an unlimited number of combinations of shapes and edge angles, a new tool has a more or less a different shape compared to any of the shapes on the chart. Therefore, you first need to shape your tool to one of the shapes on this chart. Then the following sharpenings will be an easy task and done in less than a minute.

**Tip** Stick to the shape you have selected and do not switch from one shape to another. Then you will get the full benefit of the Tormek TTS-100 Setter, since you can instantly replicate exactly the same shape every time. Should you need a different shape, then buy another tool and grind it to your alternative shape. This way of working will give you more time for turning and fewer interruptions for shaping and sharpening.

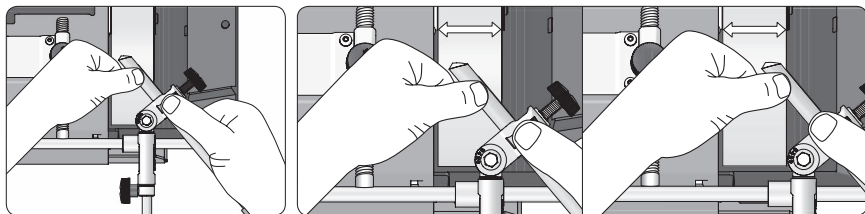
## Shaping

You can do the initial shaping either directly on your Tormek or, if a lot of steel needs to be removed, on a bench grinder using the Tormek Bench Grinder Mounting Set BGM-100 (page 29).

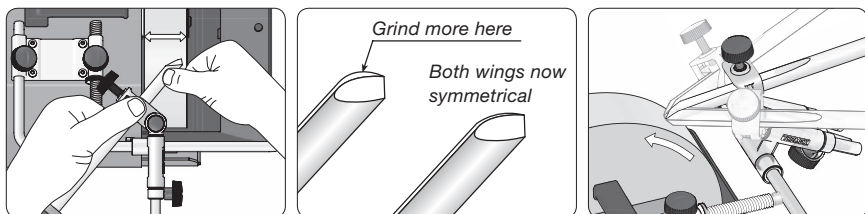
When shaping on the Tormek, contrary to a high speed bench grinder, you need to apply a high grinding pressure. Therefore, press with your hand or thumb on the tool to increase the grinding pressure. Grind one side at the time. This is easier since you do not need to swing the tool from side to side. Finish the grinding with a full swing over the entire bevel. Do not spend too long on the same spot on the grindstone, as it will leave grooves on the stone. Instead, grind on new spots so that you use the whole width of the stone.

By this technique the remaining grooves will not be too pronounced. They will reduce with future grindings of straight edges. If you immediately require a flat surface of the stone, you can true it with the Truing Tool TT-50.

Check your grinding frequently to ensure that the gouge acquires an even shape. Grind more on the spots where it is needed. Your hands and eyes decide the final evenness and shape of the bevel. Remember that once you have created your desired fingernail shape, this can be kept forever and you will always benefit from the time spent on the initial shaping. This initial shaping needs only to be made once. It takes 10–20 minutes depending on the original shape of the tool and on how much steel you need to remove.



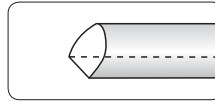
*Make the first rough shaping on one side at the time. Move the tool sideways so you use the whole width of the stone and avoid creating grooves.*



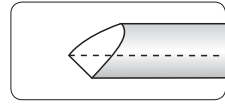
*Grind the other side. Again use the whole width of the stone to wear the stone evenly. Check frequently to ensure that you are grinding evenly. Grind more where it is needed. Decrease the grinding pressure as you complete the shape and finish the grinding with a full swing over the entire bevel.*

## Length of the Wings

The length of the wings depends on how wide you swing the tool from side to side.



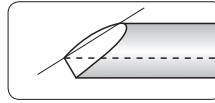
Limited swing.



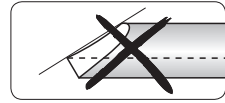
Full swing.

## Shape of the Wings

Watch that you grind on the right spots on the bevel so the wings become symmetrical and slightly convex or straight. They must never be concave.

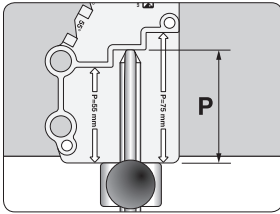


Convex.



Concave. Not suitable!

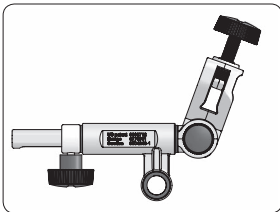
**Note** You decide how much grinding takes place on any one spot and hence the final shape. If the wings tend to be concave, then grind more on the centre of the edge.



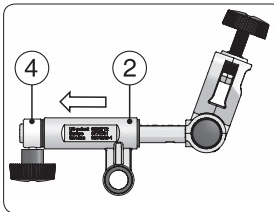
When the desired shape is achieved, check that the protrusion has not decreased during the shaping. If so, re-position the tool to the correct protrusion and then make the final shaping. By doing so, you will ensure that you exactly replicate the edge geometry at future sharpenings.

## Rounding Off the Heel

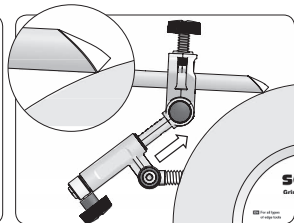
Some turners round off the heel of the bevel on bowl gouges and spindle gouges. The jig is designed so that you can move the tool towards the stone and grind the heel. The heel can be ground either as a flat secondary bevel or rounded off by sliding the jig back and forth during grinding. If you want a more pronounced rounding off, you move the Universal Support a little towards the grindstone.



Normal position.



You can round off the heel by moving the stop ring (4) and the sleeve (2) backwards.

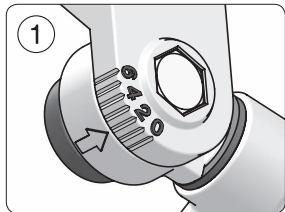


Now you can press the jig towards the grindstone to round off the heel.

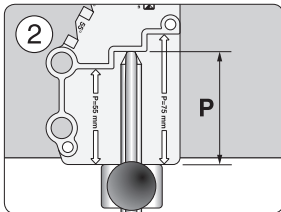
## Sharpening

Once you have created the shape of the edge, it is an easy task to quickly re-sharpen the tool. The sharpening should be done on your Tormek machine for the best finish and to ensure that the edge is not overheated. Make the three settings noted on the Profile Label carefully and you will obtain exactly the same shape every time even when the stone wears and decreases in diameter.

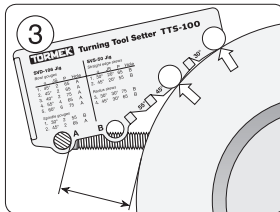
*These three factors determine the geometry of a gouge*



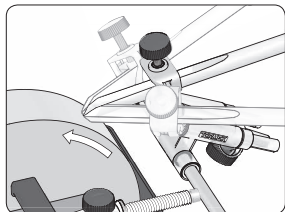
Set the jig, JS.



Mount the tool with a fixed protrusion, P.



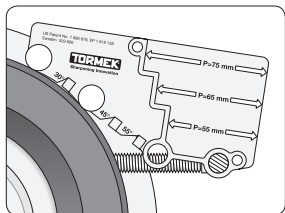
Set the Universal Support. Use hole A or hole B.



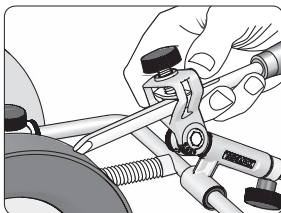
Sharpen with a light pressure and swing the tool from side to side. Since the shape is exactly replicated and the edge is just touched up, the sharpening takes just 20–30 seconds.

## Honing

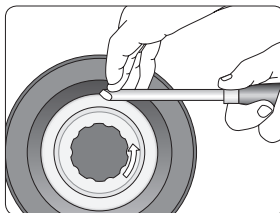
Honing and polishing the bevel and the flute to a finer finish will make the sharpness more durable. Also, use the Setter and jig for this operation and you are sure that you are honing to exactly the same shape as the sharpening plus you do not risk rounding off the very tip of the edge.



Move the Universal Support to the honing wheel and make the same setting with the Setter.



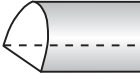
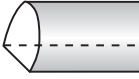
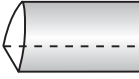
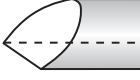
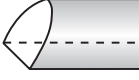
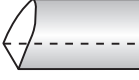

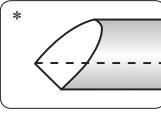

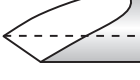


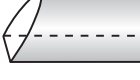

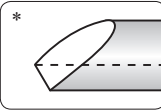
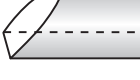



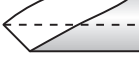

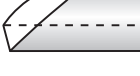
Hone by swinging the tool from side to side. You now have an extra fine finish.



Polish the flute and remove the burr on the Profiled Leather Honing Wheel LA-120.

### Other Shapes

You can of course shape your gouge to a different geometry from those provided with the TTS-100 Setter. This graph shows examples of shapes which you can achieve on a bowl gouge at various jig settings and edge angles. In each example, the protrusion of the tool in the jig (P) is 65 mm (2½"). The gouge is swung fully 180° from side to side.

Jig Setting	Edge angle <b>35°</b>	Edge angle <b>45°</b>	Edge angle <b>55°</b>	Edge angle <b>75°</b>
<b>JS 0</b>				
<b>JS 1</b>				
<b>JS 2</b>				
<b>JS 3</b>				
<b>JS 4</b>				
<b>JS 5</b>				
<b>JS 6</b>				

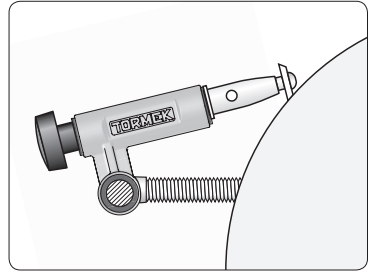
\* Geometries achieved with the TTS-100 Setter.



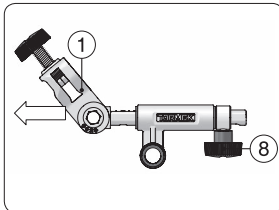
# Turning Cutters



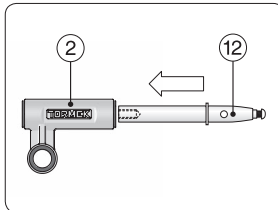
There are various types and sizes of exchangeable cutters for hollowing and scraping. The holes vary from 4–8 mm ( $\frac{5}{32}$ – $\frac{5}{16}$ " ), but due to a shoulder on the shaft they can all be mounted with the same screw. The cutters can be sharpened to their existing shape or to a new shape.



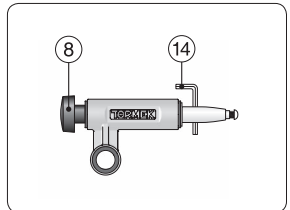
## Mounting the jig



Loosen and remove the screw (8) and the tool holder (1).

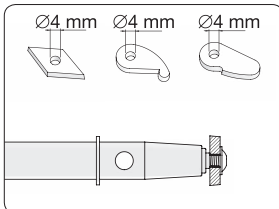


Insert the shaft (12) into the sleeve (2). Note: Position the sleeve according to the picture!

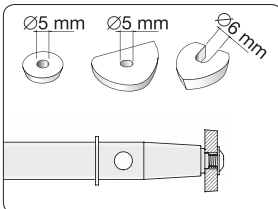


Mount the screw (8). Lock the shaft with the Allen key (14) when tightening.

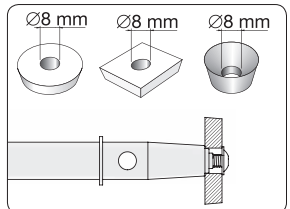
## Mounting the cutter



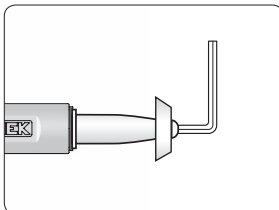
Cutters with 4 mm ( $\frac{5}{32}$ " ) holes are centered by the M4 screw.



Cutters with 5 and 6 mm ( $\frac{3}{16}$ "– $\frac{1}{4}$ " ) holes are centered on the first shoulder on the shaft.

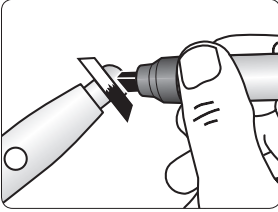


Cutters with 8 mm ( $\frac{5}{16}$ " ) holes are centered on the second shoulder on the shaft.

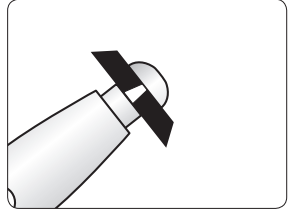
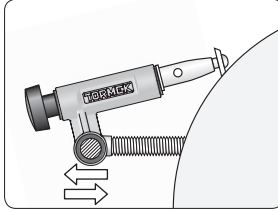


Use the Allen key (14), which comes with the jig.

## Setting the edge angle

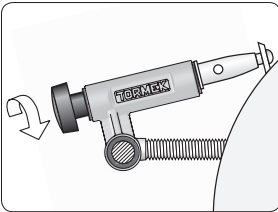


Colour the bevel with a marker. Set the universal support so that the grindstone touches the entire length of the bevel when rotating it by hand.

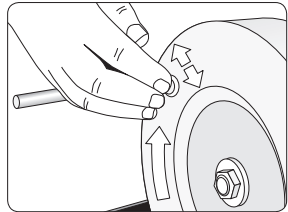
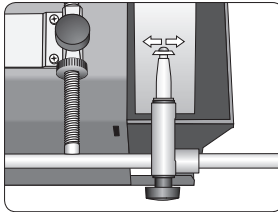


At the right setting the stone removes the colouring along the whole length of the bevel.

## Sharpening

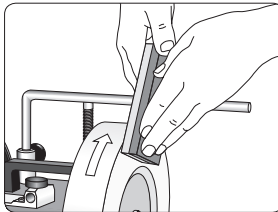
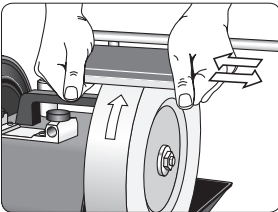


Rotate the jig all the time during the sharpening so you achieve an even grinding around the whole circumference. Use only a light pressure for the best result. Slide the jig sideways on the Universal Support so the grindstone wears evenly.



Smooth the back on the machined, flat outside of the grindstone. Move the cutter in order to use the whole surface of the stone.

**Tip** When smoothing the back of the cutter, hold it towards the grindstone before you start the machine. This is easier and you do not risk dropping it into the water trough.



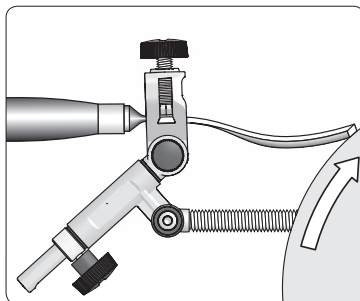
If you want an extra fine surface on the bevel, grade the grindstone with the Stone Grader SP-650 so it grinds more finely corresponding to a 1000 grit grindstone.

**Important** Do not hone these small tools on the leather honing wheel! They can easily get caught on the leather surface and spoil the leather.

# Carving Gouges



Carving gouges can be straight, curved or spoon shaped. They can also be back bent, down bent or tapered. The jig can be set to compensate for any radius on the curve so that the grinding takes place evenly across the edge, so creating a constant edge angle from the centre to the sides of the gouge.



Unlike turning gouges, carving gouges should not be ground with side bevels. The edge should form a straight line viewed from above and the corners must be sharp.

## The Principle

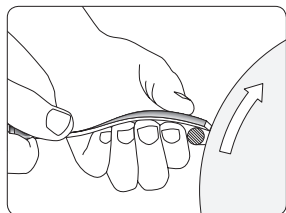
Use the technique as described in *Sharpening Techniques for Carving Gouges and V-tools* on page 20.

## Edge Angle

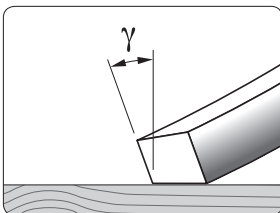
As described in the above chapter on page 24, the choice of edge angle is very important for a carving gouge. The method of setting the jig for a certain angle depends on whether you want to replicate an existing edge angle or if you want to put a new edge angle on your tool.

When replicating an existing edge angle, you should use the *Marker Method*, which is described on page 41. If you want to put a new edge angle to your tool, you can either set the angle by eye or you can use the AngleMaster (page 142).

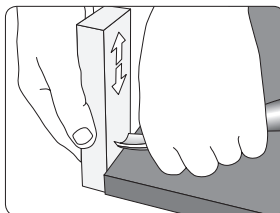
## Shaping the edge



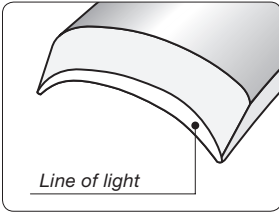
Shape the edge by resting the tool on the Universal Support placed horizontally and close to the stone.



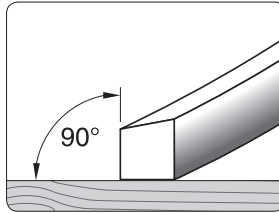
The edge plane angle ( $\gamma$ ) should be approx. 20° (page 21).



Flatten and smooth the blunted edge with the fine side of the Tormek Stone Grader, SP-650.

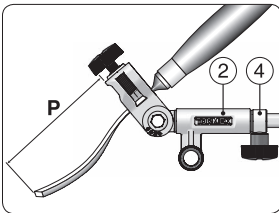


Now you have a line of light, which is your guide as to where to grind.

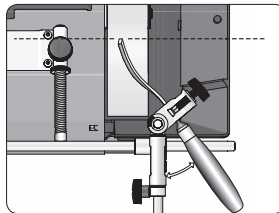


When cutting steep bowls using a curved or a down bent gouge, the edge plane angle can be decreased. Here it is 0°.

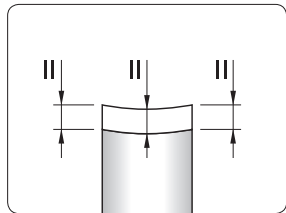
### Setting the jig



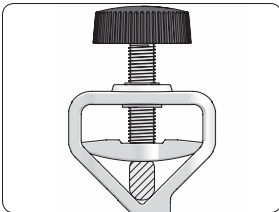
Mount the gouge in the jig protruding approx. 100 mm (4"). The stop ring (4) must be locked close to the sleeve (2).



Put the jig on the Universal Support and swing it to one side. Set the jig so that the plane of the edge is approx. parallel to the axis of the stone.

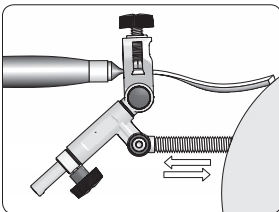


The edge angle will now be equal across the edge. If the thickness of the steel is even, the bevel length will also be equal along the edge.



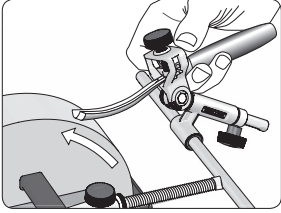
If the shank has a convex upper side, you should grind it flat to make sure that the tool does not turn in the jig.

### Setting the edge angle

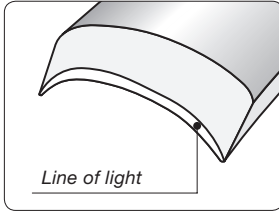


Set the edge angle by adjusting the Universal Support. When replicating an existing angle, use the Marker Method. When setting a new angle you can use the AngleMaster.

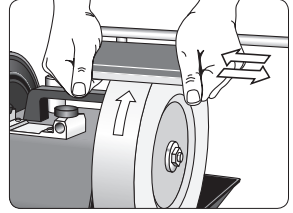
## Grinding



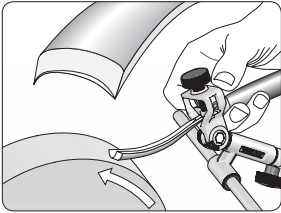
Always grind where the line of light is the thickest while swinging the tool.



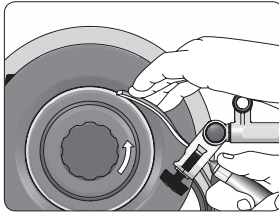
Check frequently where the grinding takes place. Grind until you get an even and thin line of light.



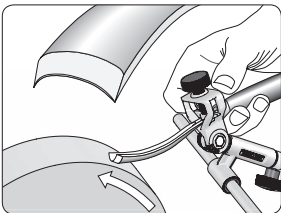
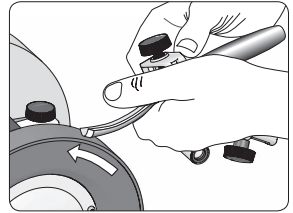
Grade the grindstone for fine sharpening with the fine side of the Stone Grader SP-650.



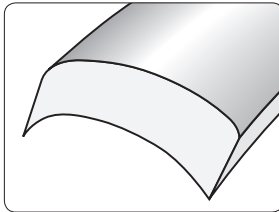
Continue sharpening. Check the result frequently.



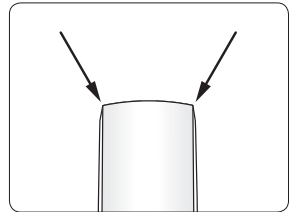
Remove the burr on the leather honing wheels to observe the line of light more clearly. The tool is left mounted in the jig.



Sharpen again. Now with a very light pressure. Check frequently so that you do not over-sharpen.

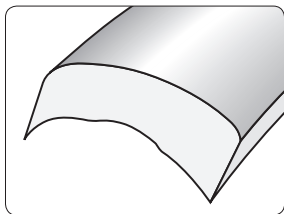


Stop sharpening immediately when the line of light disappears, which is a sure sign that the edge is sharp.



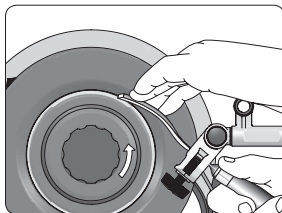
Be careful so you do not round off the corners. Woodcarving tools should have sharp corners!

**Important** It is very easy to be misled by the burr and mistake the burr for the line of light! Therefore you must remove the burr frequently during the finishing of the grinding operation, so you clearly can watch the progress of a gradually thinner the line of light.

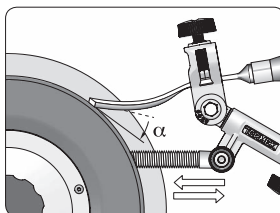


*It is very easy to over-sharpen the edge at the end of the sharpening. If this happens, you need to reshape the edge and start again from the beginning.*

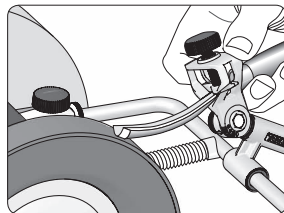
## Honing



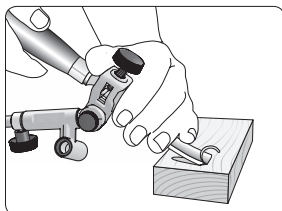
*Keep the tool in the jig and hone and polish the inside on the Profiled Leather Honing Wheel LA-120.*



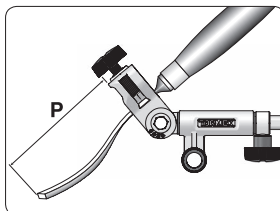
*Hone and polish the bevel. Set the Universal Support so that the honing angle is the same as the grinding angle. Use the Marker Method. Hone away the burr and polish the bevel to a mirror finish.*



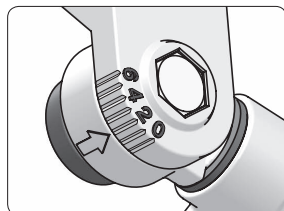
## Testing the sharpness



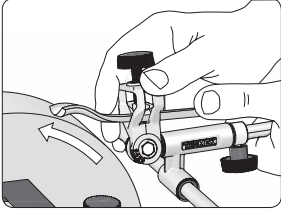
*Leave the tool in the jig and test the sharpness by pushing the edge across the fibres in a piece of wood. The edge should cut easily and leave a smooth surface without tearing the fibres.*



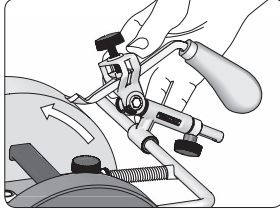
*If the edge needs further honing or sharpening on some spots, you can continue with the same setting. When you are satisfied with the result, you remove the tool from the jig after having measured and noted the protrusion (P) and the jig setting. Please see the next page.*



# Back Bent and Down Bent Gouges



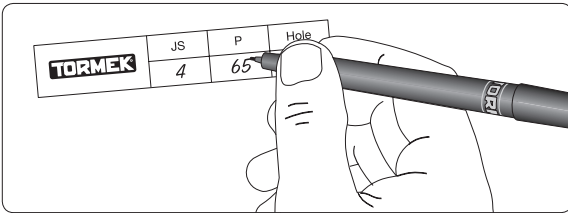
A back bent gouge is ground with the jig setting 0.



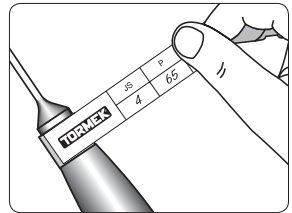
You can also grind a down bent gouge. The jig is set as shown on page 86.

## Documentation of the Shape

The shape of the gouge is determined by the jig setting (JS) and the protrusion (P). Note these settings on the profile label, which comes with the jig. Now you can exactly replicate this shape at future re-sharpenings. Set the edge angle with the *Marker Method* or the *Spacer Block Method*.



Note the jig setting (JS) and the protrusion (P) on the label. Use the water proof pen which comes with the jig.



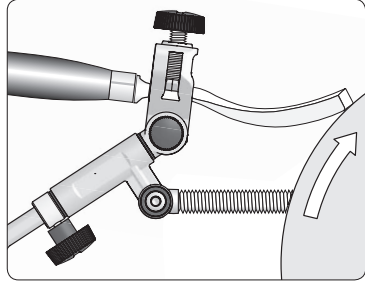
Attach the label to the ferrule and you are assured that you have the same settings at future sharpenings.

# V-tools

These tools are considered the most difficult to grind. The reason is that it has two edges joined with a radius.

However, with the method described here, you will also manage to achieve a sharp and correctly shaped edge on these tools.

The principle is the same as for carving gouges, i.e. you first give the tool its right shape and then let the line of light guide you as to where to grind.



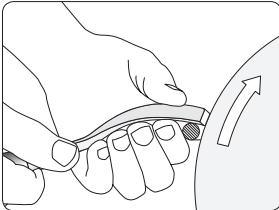
## The Principle

Use the technique as described in *Sharpening Techniques for Carving Gouges and V-tools* (page 20).

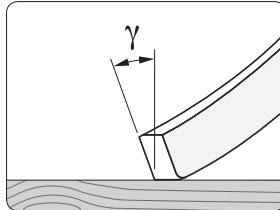
## Edge Angle

As described in the chapter above on page 24, the choice of edge angle is very important for a carving gouge. The method of setting the jig for a certain angle depends on whether you want to replicate an existing edge angle or if you want to put a new edge angle on your tool.

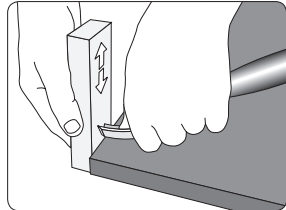
### Shaping the edge



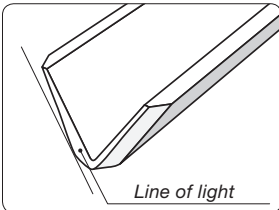
Shape the edge. Rest the tool on the Universal Support positioned horizontally.



The edge plane angle ( $\gamma$ ) should be approx. 20° (page 21).



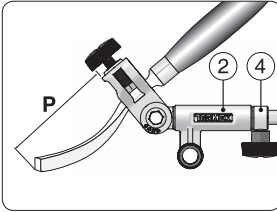
Flatten and smooth the blunt edge with the fine side of the Tormek Stone Grader, SP-650.



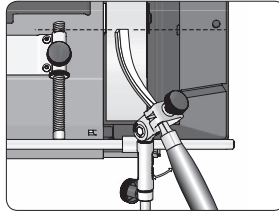
The blunt edge appears as a line of light, which is your guide as to where to grind.



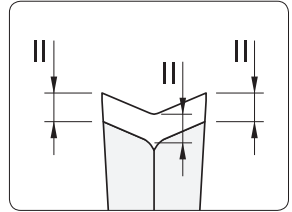
## Setting the jig



Mount the tool in the jig protruding approx. 100 mm (4"). The stop ring (4) must be locked close to the sleeve (2).

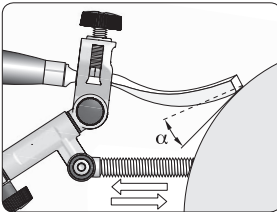


Turn the jig so one wing lies flat on the grindstone. Set the jig so that the edge is approximately parallel to the axis of the stone.



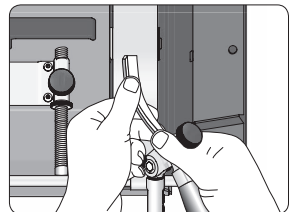
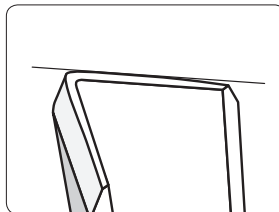
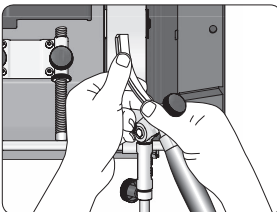
Now the jig is set to suit the shape of the tool, the edge angle will be uniform.

## Setting the edge angle

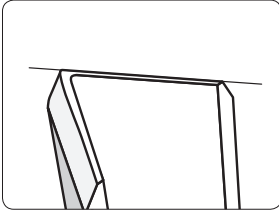


Set the edge angle by adjusting the Universal Support. When replicating an existing angle, use the Marker Method. When setting a new angle you can use the AngleMaster.

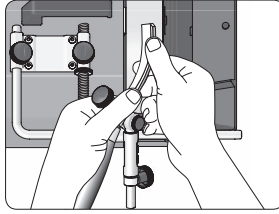
## Grinding



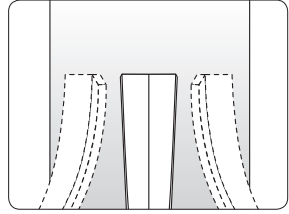
Control the grinding pressure with your thumb and control where the grinding takes place by gently turning the tool with your hand. Check frequently where the grinding is taking place. Only grind where the line of light is the thickest. Do not slide the tool sideways. Keep it on the same spot on the grindstone for the best control. Rest your hands on the Universal Support all the time and you get a good control.



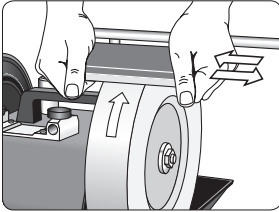
Grind until you get an even and thin line of light.



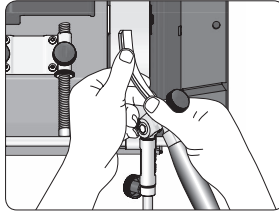
Now grind the other wing in the same way.



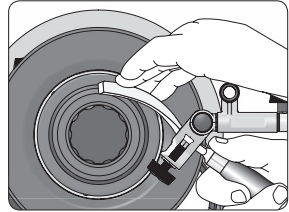
Then grind the keel. Turn the tool from side to side to equalise the grinding towards the wings.



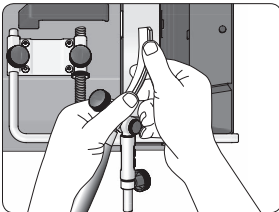
Grade the grindstone for fine sharpening with the fine side of the Stone Grader SP-650.



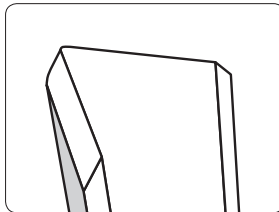
Continue sharpening one wing at a time and then the keel. Check the results frequently.



Remove the burr on the leather honing wheels so that you can better observe the line of light.



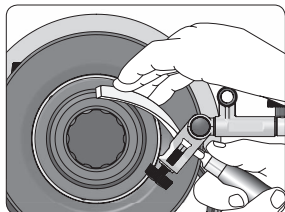
Now sharpen again with a very light pressure. Check frequently so that you do not over-sharpen.



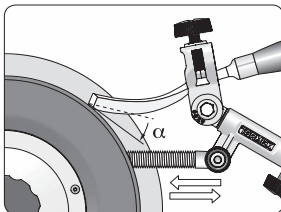
Stop sharpening immediately when the line of light disappears, which is a sign that the edge is sharp.

**Important** It is very easy to be misled by the burr and mistake the burr for the line of light! Therefore you must remove the burr frequently during the finishing of the grinding operation, so you clearly can watch the progress of a gradually thinning line of light.

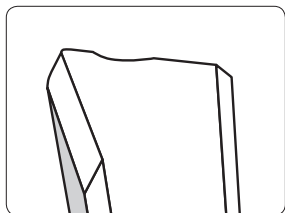
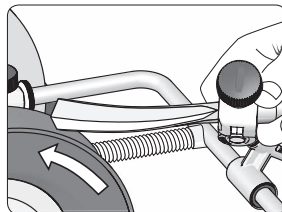
## Honing



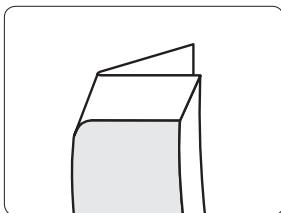
Keep the tool in the jig and hone and polish the inside on the Profiled Leather Honing wheel LA-120.



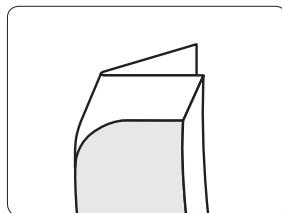
Hone and polish the bevels. Set the Universal Support so that the honing angle is the same as the grinding angle. Use the Marker Method. Hone away the burr and polish the bevels to a mirror finish.



It is easy to over-grind the edge at the end of the grinding. If this happens, you need to reshape the edge and start again from the beginning.

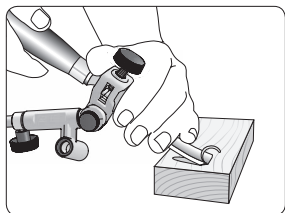


This is now how the tool should appear. The keel is slightly longer than the bevel of the wings since the steel is thicker in the centre.



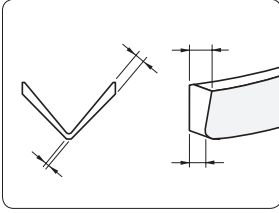
The tool cuts more easily if you round the keel. Move the Universal Support slightly towards the grindstone and grind gently while swinging the tool from side to side.

## Testing the sharpness

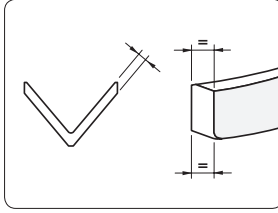


Keep the tool in the jig and test the sharpness by pushing the edge across the fibres in a piece of wood. The edge should cut easily and leave a smooth surface without tearing the fibres. If the edge needs further honing, you can continue with the same setting. When you are satisfied with the result, you remove the tool from the jig.

## Uneven thickness of the steel



Uneven thickness



Even thickness

*If the steel thickness varies, the length of the bevel will also vary despite the fact that the edge angle is the same. This has no influence on the function of the tool, as it depends on the edge angle. A V-tool with an even steel thickness has the same bevel length on the whole wing.*