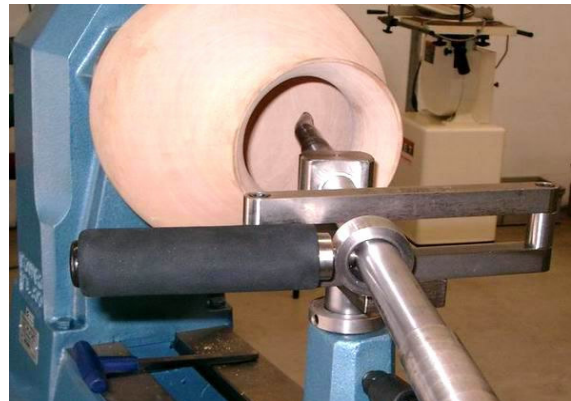




Ultimate Deep Hollowing System

User Instructions

(Code: WTT-050)

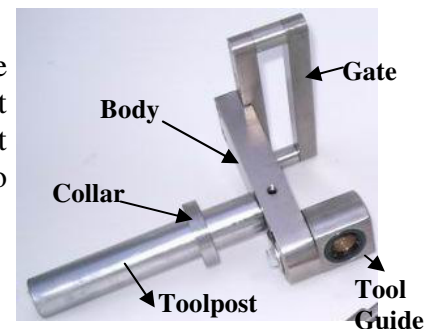


Ultimate Hollowing System has been designed for fast easy hollowing of all timber from soft wet wood to very hard dry species such as Burls. It's major advantages are that it will not clog up, does not dig in and is safe and easy to use up to its maximum design depth of 350mm.

The system consists of the handle, a side handle, the main shaft, 2 cutting heads and the tool support. This system is only recommended for rigid lathes.

CAUTION: Any tool is potentially dangerous - the user should take every precaution to avoid injury. The purchaser is responsible for ensuring that the product is suited to their needs.

The Tool Support: This is the key to the safe and efficient operation of the system. It fits in the normal tool post location and includes a collar for height adjustment. It consists of one fixed rear gate and a pivoting bush at the front which is supported by two Ball bearings. The front support also has a seal to prevent the ingress of dust.



The Handle: The handle is constructed of high quality Stainless Steel machined to a fine finish. It is weighted with lead shot for better balance and shock absorption and has a hard foam rubber grip. The 12mm bore of the handle will also fit most of the P&N range of chisels and gouges.



Handle

The Side Handle: Fits on the front end of the main handle. Made from Stainless Steel and encased in foam, it can be adjusted to any angle in relation to the cutting head.



Side Handle

The Main Shaft: 22mm diameter solid high tensile steel. It is long enough, with the cutting head fitted, to provide a working depth of 350mm. The grub screw on the main shaft can damage the bush if it is protruding so ensure the grub screw is below the surface of the shaft when inserting or withdrawing the main shaft.

Important: Make sure after each use that you lubricate the main shaft to prevent rusting.



Main Shaft

The Cutting Heads:

There are 2 cutting heads:

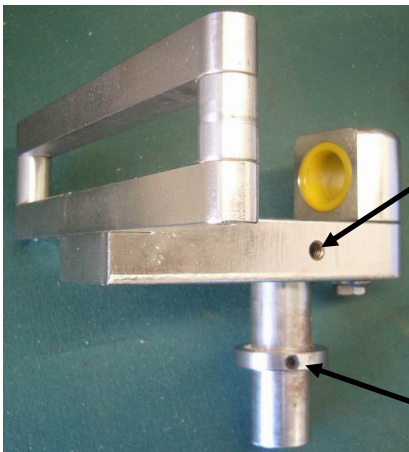
- 10mm diameter Tungsten Carbide (TC) cutter for roughing out. The TC cutter is curved for better undercutting. **Caution:** The cutting edge of the TC cutter is very brittle and can be easily damaged if knocked against the gates or dropped.
- 25mm diameter high speed steel shear scraper used to remove tool marks with a shear scraping action, to achieve a fine finish. Both are angled downwards at 12 degrees for safety.



10mm TC Cutter for Roughing



25mm Shear Scraper for Finishing

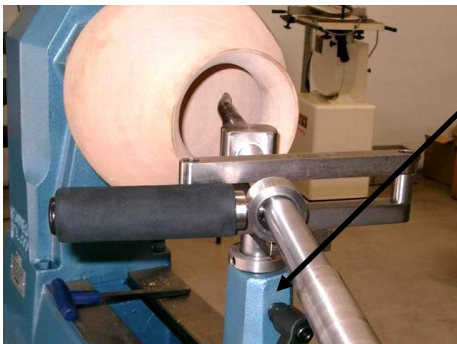


Setting Up:

Screw toolpost into body - make sure it is screwed in fully.
Tighten the grub screw to clamp on to the toolpost.

Insert the main shaft through the gate and the front bush, then fit the 10mm TC Roughing Cutter. With the main shaft suspended in the gates, raise or lower the tool post until the front edge of the cutter is at the centre height of the lathe. This can be measured from the bed of the lathe or at the point of a drive dog.

The collar on the tool post can now be locked by tightening the grub screw and the tool support can be removed and refitted to the same lathe without further adjustment.



Important: Ensure the toolpost is locked into the camlock/tool support properly when in use.

Operation:

The vessel to be hollowed should be shaped on the outside and mounted in a chuck.

Drill a hole down the centre of the vessel to the required depth.

Assemble the Ultimate Deep Hollowing Set using the 10mm TC cutter for Roughing and commence hollowing, working from the neck of the vessel progressively to the depth of the drilled hole.

Important - The cutter should always be on a 30 to 45 degree angle.

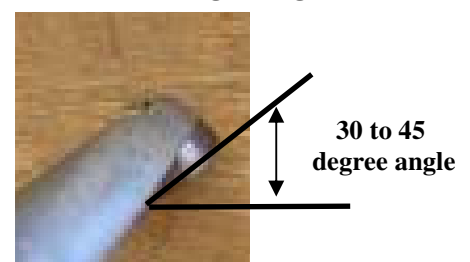
Cut from the centre out to close to the desired wall thickness.

Set the side handle horizontal when the cutter is horizontal, therefore the side handle will indicate the cutter angle when the cutter is hidden.

Never raise the side of the cutter that is cutting above horizontal. The amount of cut can be controlled by rotating the shaft. Lowering the cutting edge will reduce the cut.

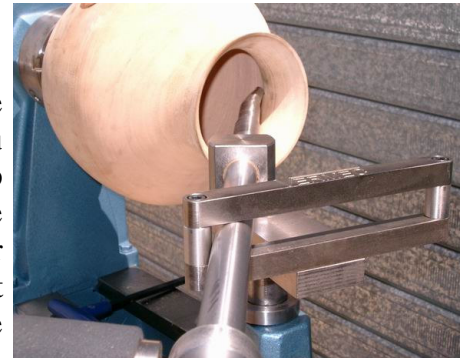


Cutter should always be on a 30 to 45 degree angle



Alternative Turning Method:

If you are using a long bed lathe there is an alternative way to use the tool. To avoid having to bend over the lathe bed to view the cut, you can use the tool inverted. Because the tool support gates prevent kick up and kick down it is possible to use this tool upside down on the opposite side of the vessel with the normal direction of rotation. With the cutter upside down and horizontal, set the side handle horizontal (in the left hand). Therefore the action is the same as normal rotation. To reduce the cut lower the sidehandle.



Cutting on the Right Hand Side

Finishing:

When the wall thickness is close to that desired, remove the 10mm TC Roughing Cutter then insert the 25mm Shear Scraper Finishing Cutter. Starting at the centre bottom of the vessel cut outwards with a Shear Scraper Finishing Cutter angle of between 30 to 45 degrees . Continue up the wall of the vessel maintaining the same angle.



**25mm Shear Scraper for Finishing
(Shown for photo purposes only)**

Information on Vermec products is available at:

www.vermec.com

VERMEC

39 Dalton Street
Kippa-Ring Queensland 4021
AUSTRALIA

Phone: 07 3284 3733 Overseas Phone: +61 7 3284 3733

Fax: 07 3284 2733 Overseas Fax: +61 7 3284 2733

Email: vermec@netspace.net.au

Web: www.vermec.com