

## Using the Artisan® Ring Boring Head

### Supplies Needed

- Ring Blank
- Ring Chuck or Ring Mandrel
- Double Face Tape
- Sandpaper/Finish
- Eye and Ear Protection
- Chuck
- Scrap Block
- Revolving Center
- Drill Chuck
- Drill bit
- Ring Boring Head
- Finish

### Selecting a Ring Blank

1. Select a blank that is at least 1/16" wider than the ring core you choose to turn. We recommend using a dense exotic wood or a stabilized blank for this project.



### Fitting the Ring Core

1. Mount a 2" square waste block in a chuck and true up the face of the blank.



2. Apply double face tape to the face of the scrap block and attach the ring blank. Make sure the backside of the ring blank is smooth to provide a good bond with the tape.

3. Advance the live center against the disc. This pressure will strengthen the bond of the tape during the rough turning of the disc.
4. Rough turn the blank to round and remove the live center.



5. Select a drill bit half the diameter of the ring you are turning. Mount the drill bit in a drill chuck and drill through the ring blank.



### Using the Boring Head

1. Mount the boring head into the tailstock with the flats parallel to the floor and the dial facing you. Next, mount a boring bar in the center hole with the cutter parallel to the floor and tighten the set screw to lock the boring bar in place.



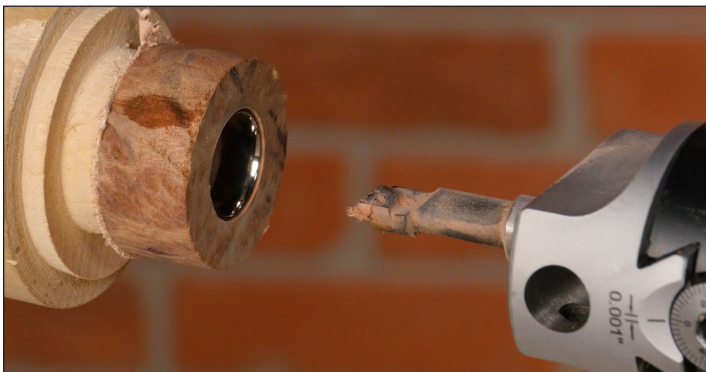
- In order for the boring head to cut accurately the tailstock quill needs to be under tension. Slightly tighten the quill lock handle until there is a bit of resistance when advancing the quill. Your boring head is now ready to use.



- Bring up the tailstock until the cutter is close to the ring blank. Use the allen wrench and turn the dial counter-clockwise to move the cutter. Stop once the cutting edge is positioned to take a 1/8" cut. Turn the lathe on to around 2500 rpm and advance the boring head slowly until completely through the ring blank. Back out the boring head and adjust the dial to take another 1/8" pass. Do not take a cut wider than 3/16". If it starts to chatter, stop and take a narrower cut.



- Repeat this process until you are close to having the ring core fit. Test the fit of your ring core frequently with the lathe off, careful not to oversize the hole. The boring head allows very precise cuts, take your time and make light cuts until the core fits perfectly.



- Remove the ring blank from the waste block. Slowly pry the blank from the waste block using a putty knife and it will release the ring blank. **Do not use too much pressure or the ring blank will break in half.**



Lightly coat the inside of the ring blank with thick or flexible CA glue or Epoxy and insert the ring core. Wipe away any excess glue.

### Turning the Ring

- Mount the blank on a pen mandrel using the ring bushings. Small ring bushings fit rings sizes 4-7, Medium bushings fit rings 8-11, and Large bushings fit rings 12-16. So use the appropriate bushings for your ring. *Note: For 3mm wide cores, sizes 4-7 you may need flip one of the bushings for them to mount securely.*
- Turn the blank to your desired shape. Sand the blank through 320 grit or higher.



Finish the blank with your choice of finish, we recommend doing a CA finish as it will be glossy and resistant to moisture.

- Your ring is now ready to wear!

