



The Sorby ProEdge will require the following items to replicate the Glenn Lucas grinds.

**Finger nail profile arm
Long Grind Jig (PELGJ)
Standard Profile Jig (PEVB V
block)**

The fingernail profile arm may vary in design depending on the year of manufacture. In order to follow the prescribed jig settings the arrow should point at zero when the profile arm is in the 90° position.



Finger nail profile arm with adjustable collar (AC)

If the arrow does not line up with zero, the procedure is as follows:
Set the finger nail profile arm to the 90° position. Use a fine permanent black marker to draw a line corresponding with the zero setting which will replace the arrow. The profile arm is now ready to follow the jig settings (JS) provided in the table.

The adjustable collar (AC) should be placed in the no.2 or no.3 position depending on the tool being sharpened.

ProEdge



Long grind jig holes 3, 2 & 1

The long grind jig (PELGJ) has 3 holes. The holes 2 and 3 will be used to sharpen these tools. (hole no.1 is closest to the grinder.)

The secondary bevel on the tool can be created by using the standard profile Jig (V block) using the appropriate angle.

- JS = 'Profile Arm' jig setting No. 0-6
- P = Protrusion of tool from 'profile arm'
- AC = Adjustable Collar No. 1-3
- H = 'Long grind jig' Hole No. 1-3

GL3	JS	2
	P	65mm
	AC	3
	H	3
	Remove brass insert from profile arm	
GL4	JS	2
	P	65mm
	AC	3
	H	3
GL5 / GL5s / GL7 / GL8	JS	1
	P	65mm
	AC	3
	H	2
GL6	JS	0
	P	30mm
	AC	2
	H	3

In the design and choice of these tools, I have thought carefully about the needs of the experienced and amateur woodturner making bowls and platters. I have also considered the challenge in replicating the cutting edge profile on signature tools and have researched how to reproduce my cutting edge on various sharpening jigs. This chart, will help you to sharpen the tools on any of the four jigs listed.

I have been using **Hamlet** tools for most of my professional turning life. On first using the **Masterflute** bowl gouges I enjoyed their versatility and ease of sharpening. They can easily accept my desired edge profile and achieve the ultimate cut.

For the few who really master free-hand sharpening, the parabolic flute profile will be a pleasure to use and sharpen.

The negative rake scrapers are favourites with my students around the world. They are less likely to get a catch and the focus will be on the shape of the piece.

Enjoy your time at the lathe and stay sharp!



Glenn Lucas

Getting started

Take note of the tool reference number on the packaging, GL1-GL8. I recommend using electrical tape to colour code the bowl gouges which will help to identify the tools in the workshop and on the chart. My future DVDs will use the same colour coding. The tools will have to be sharpened before use and kept sharp. If in doubt - sharpen!

Important

Please refer to your sharpening system handbook for safe use and set up. The jigs used to obtain these settings have all been manufactured in 2018 and their future design may change.