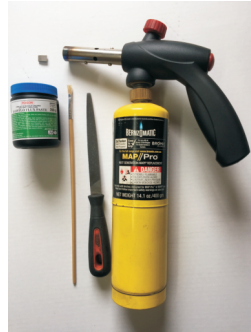




INSTRUCTION FOR REPLACING BOWLSAVER STELLITE TIPS

Equipment Required:

- A gas torch suitable for braising
- A fine or medium toothed file
- Flux paste or flux powder
- A small brush to apply the flux



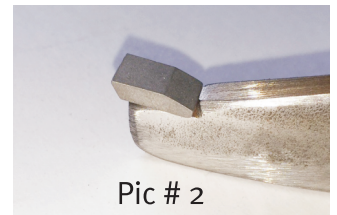
Procedure:

1. You first need to remove the old stellite tip.

Do this by applying heat to the tip and blade end until the tip falls off.

2. Use a file or emery cloth to clean the surface of the blade that will receive the new tip.

3. Place the new stellite tip on the Bowlsaver blade with the attached solder on the underneath side - see pic #2.



Pic # 2

If you have previously ground back the end of the steel blade with continuous sharpening, you may need to grind back the blade to increase the platform that the stellite tip sits on.

If the tip does not fit evenly on the blade, you may need to file a flat on the bottom of the tip.

4. Apply heat to the blade and tip until the blade and tip glows. At this point, the solder on the tip should melt and the tip will fuse to the blade.

Sharpening the new tip.

This should be done on your bench grinder with the help of a toolrest and your steady hand:

1. Grind both sides of the tip without reducing the width of the front, so that you achieve an even taper back to the steel.

2. Grind the top of the tip evenly across its surface.

3. Grind the front of the tip, lightly only, evenly across its width.

The ground surface at the front needs only to be approximately 2mm high.



If any questions, email us at: sales@woodcut-tools.com

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