

The Rosette Cutterhead includes the body, wedge-type gib and shank with J.T. #6 taper. The wedge-type gib locks in place against an optional knife by tightening 3 setscrews. The 3 sided shank fits into a 1/2" chuck. The J. T. taper presses into the rosette body and is held in position by friction. Optional M.T. #2 and M.T. #3 arbors are available to mount the Rosette Cutterhead directly to your drill press or lathe tapered spindle.

SAFETY CONSIDERATIONS

As with all woodworking tools, there is a certain degree of hazard associated with the use of this tool. Operating it with respect and caution will considerably lessen the possibility of personal injury. If safety precautions are ignored, injury to the operator or others in the area can occur. It should not be assumed that all safety measures are listed, or that other additional measures are not needed under particular or exceptional circumstances or conditions.

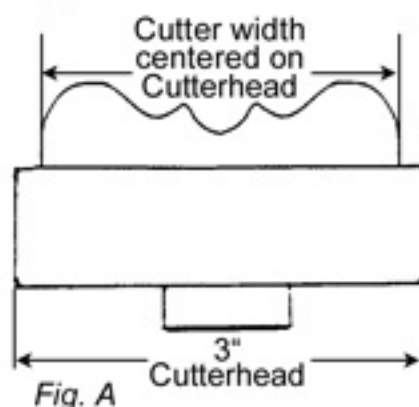
1. Ensure that your drill press or lathe is properly grounded.
2. Use safety glasses and ear protection. Use a dust mask or respirator to prevent breathing dust.
3. Ensure that knife, cutterhead arbor or shank is firmly secured before turning drill press or lathe on.
4. Wear proper apparel. Do not wear loose clothing, gloves, neckties or jewelry which may get caught in moving parts.
5. Remove adjusting keys and wrenches. Develop a habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
6. Secure your work. Use clamps or a fixture to hold workpiece. Ensure that your holing method does not interfere with the cutterhead or spindle travel.
7. Before making any adjustments, ensure that the tool is turned off, all moving parts have stopped and the plug is disconnected from the outlet.
8. When feeding work, feed against the direction of cutterhead rotation only.
9. Follow all manufacturers recommended safety instructions when using your drill press or lathe.

MOUNTING OPTIONAL KNIVES

1. Place the knife against the 90° face along the centre of the cutterhead. Centre the knife point where the two opposite grinding bevels meet with the centre of the hole drilled through the cutterhead. (See Fig. A)
2. While holding the knife in position, slide the wedge-type gib into the cutterhead. Ensure that the beveled gib mates with the dovetailed face of the cutterhead.
3. Evenly tighten the three set screws with a 3mm Allen Wrench.

MOUNTING CUTTERHEAD TO THE CHUCK

1. **IMPORTANT:** You must completely remove all oil film from the J.T. taper.
2. Tap the 3 sided shank into the J.T. #6 taper in the cutterhead with a mallet.
3. Insert the shank into a 1/2" chuck and tighten with a chuck key. Ensure that the jaws of the chuck contact the 3 faces of the shank.



MAKING ROSETTES

This Rosette Cutterhead will produce a rosette profile by scraping action. The Rosette Cutterhead can be mounted either in a drill press or lathe, mount the cutterhead in the tail stock and the workpiece in a 4 jaw chuck mounted in the head stock. If using a drill press, ensure that the workpiece is centered under the cutterhead and secured to the drill press table.

1. Your drill press or lathe speed should be set at the lowest speed, or 250 to 350 rpm. Operating at higher speeds will cause burning and/or unsatisfactory results.
2. Feed the Rosette Cutterhead slowly into the workpiece.
3. Routinely clear sawdust and chips away during operation.

KNIFE REMOVAL

1. Loosen the 3 setscrews with a 3mm Allen wrench.
2. Hold fingers against the gib and knife and loosen the gib by tapping with a dead-blow hammer or hammer and block of wood. Do not tap against the knife.
3. Slide the knife and gib cut of the cutterhead body.

KNIFE SHARPENING

Since the Rosette Cutterhead shapes by scraping action, the knives will dull faster than if they were to cut by slicing. To achieve consistently good results, it is important that the knives be sharpened and/or honed regularly. When sharpening, ensure that the knife profile is maintained and both sides are sharpened equally. Remove knife from the cutterhead and sharpen with round slip or flat sharpening stones depending upon profile.