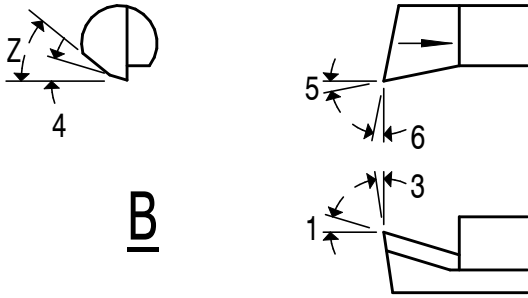


**A**



**B**

A. COMPARISON BETWEEN BORING TOOL AND CONVENTIONAL KNIFE TOOL  
 B. TO AVOID CONFUSION FOR THOSE READERS WHO MAY ALSO READ "TOOL AND CUTTER SHARPENING" NO. 38 IN THE "WORKSHOP PRACTICE SERIES" I AM USING THE SAME NAMES AND NUMBERS THROUGH OUT THE TEXT FOR THE VARIOUS ANGLES THAT MAKE UP THE CUTTER.

- 1. SIDE RAKE  $10^{\circ} - 15^{\circ}$
  - 3. SIDE CLEARANCE  $5^{\circ}+$
  - 4. FRONT CLEARANCE  $5^{\circ} - 10^{\circ}$
  - 5. FRONT RELIEF  $5^{\circ}+$
  - 6. SIDE RELIEF  $5^{\circ}+$
  - Z. SECONDARY CLEARANCE AS REQUIRED.
- SEE TEXT FOR FURTHER DETAILS REGARDING THE ANGLES QUOTED

**BORING TOOL**

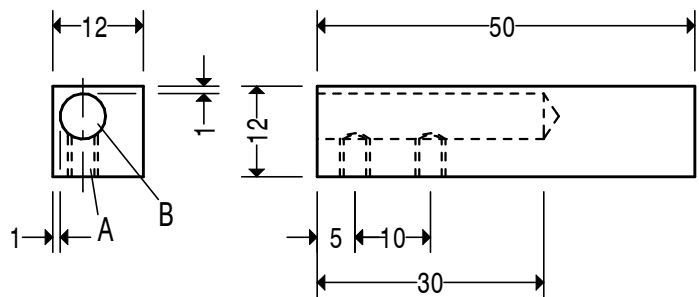
**ANGLES SK.2**



2. TOP RAKE  $10^{\circ} - 15^{\circ}$   
 SEE SK.3 FOR DETAILS OF OTHER ANGLES

**ALTERNATIVE BORING**

**TOOL SHAPE SK.3**



- A. M4
- B. TO SUIT CUTTER SIZES  
 WOULD SUGGEST 3, 4, 5 AND 6MM DIAMETERS

MATERIAL 12MM SQ STEEL 070M20

**TOOL HOLDERS**

**SK.1**