GUIDELINE FOR GRINDING WOODTURNING TOOL ANGLES

- **Spindle Roughing Gouge**: 40 - 50 deg.
- **Bowl Gouge**: Standard Grind, 40 - 50 deg.
- **Spindle Gouge**: 40 - 45 deg.
- **Bowl Gouge**: Bottom 1/3 of Bowl, 55 - 65 deg.
- **Spindle Gouge**: Fingernail Grind, 35 - 45 deg.
- **Bowl Gouge**: Swept back or Irish Grind, 40 - 50 deg.
- **Detail Spindle Gouge**: 25 - 35 deg.
- **Gouge Side Bevel Profile**: Best, OK, No, No
- **Scraper**: 70-80 deg.
- **Reverse Angle or Negative Rake Scraper**: Sum of angles equals 60-70 deg.
GRINDER WHEEL SAFETY

- **Eye Protection**
  Always wear eye protection (face shield and safety glasses).

- **Wheel Condition**
  Check condition of wheel.

- **Tool Rest Clearance**
  Check clearance between tool rest & wheel; adjust if it exceeds 1/8".

- **Tongue Rest Clearance**
  Check clearance between tongue rest & wheel; adjust if it exceeds 1/4".

- **Side of Wheel**
  Do not grind on side of wheel unless designed for side grinding

- **Wheel Grooves**
  Do not gouge wheel by grinding in one spot

- **Restrictions**
  Do not grind aluminum, brass, copper, or wood

- **Ring Test**
  Check maximum rotational speed & "ring test" new wheels before installing

"RING TEST"
TAP WHEEL 1-2" FROM PERIPHERY 45° EACH SIDE OF VERTICAL WITH NON METALLIC SCREWDRIVER HANDLE; "DEAD" SOUND INDICATES CRACK

FOR ADDITIONAL INFORMATION, SEE OSHA SECTION 1910.215