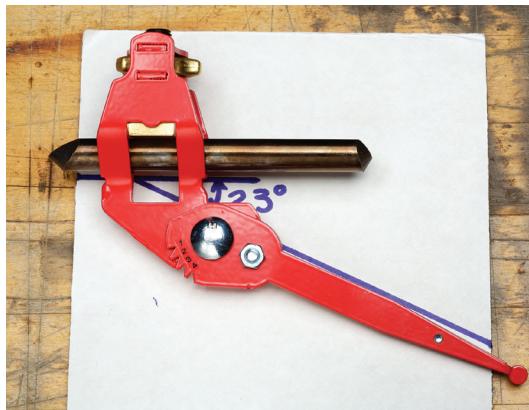
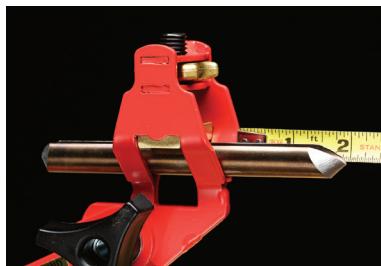


Profile Pro Setup Instructions

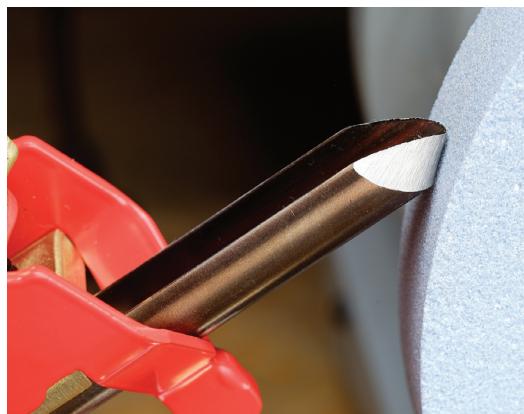
Profile Pro set up tools provide woodturners with tool profiles most commonly used by teaching professionals at Craft Supplies USA as well as many of the world's top professionals. Although these profiles are not suitable for every situation, they work well for the vast majority of woodturning applications. These profiles are easiest to control and are moderately aggressive making them less likely to catch. If you have your own special grind you want to remember, simply grind your profile on a Profile Pro set up tool.



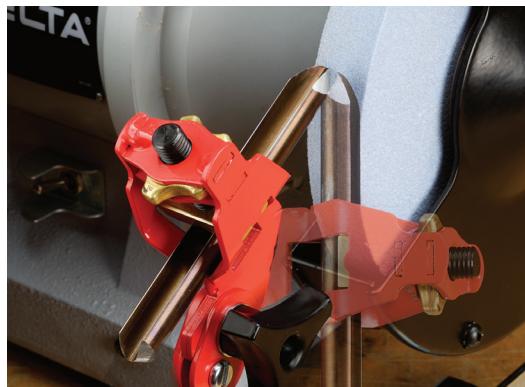
1. Using a protractor, set the angle of the of tool holder support leg to 23 degrees in relationship to the axis tool holder clamp. Depending on the type of system you have, you may find it easiest to mark a piece of paper with the 23 degree angle then use the paper for visual alignment when setting the jig as shown. Placing a Profile Pro set up tool in the tool holder as shown helps with visual alignment. Tighten the knob as you will not need to change this angle in the future when using Profile Pro set up tools.



2. Clamp the set up tool in the tool holder with 2" protruding beyond the front of the tool holder. This can be done using a measuring tape or the Jamieson Grinding Jig Guide that mounts on a workbench top for easy set up. Note: When setting up for the "Irish" grind, 2 1/8" of tool must protrude beyond the front of the tool holder.



3. With the grinding wheel stationary, position the tool holder in the sharpening jig slide. With the tool in the upright position, place the bevel of the set up tool against the face of the wheel. Adjust the slide in or out as needed until the bevel of the set up tool rests flat against the wheel face.



4. Roll the tool holder side to side, checking all the while to make sure that the bevel remains flat against the wheel face at all times. Clamp the support slide firmly in position.

5. Replace the set up tool with the turning tool to be ground. Remember to clamp the set up tool in the tool holder with 2" protruding beyond the front of the tool holder (2 1/8" for the "Irish" profile).



6. Wearing proper eye protection, grind the tool to chosen profile. Be careful not to roll the tool holder too far side to side as this lateral movement determines how far up the tool the cutting edge will go.