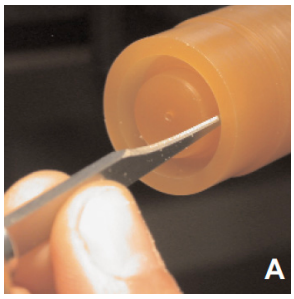
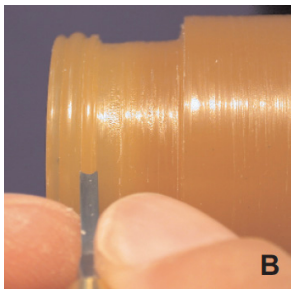
How-To: Using a Lathe

Wolf Carving Waxes™ *are ideal for hand carving and lathe work. These Carving Waxes melt at approx. 240ºF (115.6ºC). Use safety glasses and dust mask when working with rotary tools! To avoid or get rid of chatter when free cutting (holding the cutting tool by hand, not using a tool rest) support the tool firmly with both hands and position index finger on blade of the tool, close to turning wax. Continually alter the angle of of the tool as you scrape the surface of the wax. Chatter is an imperfection of the surface of the wax that looks like corduroy. Chatter is caused by vibration of the tool while scraping. Pivot the tool slightly to find the optimum cutting angle. Adjust the pressure of the tool on the wax and speed of rotation to ensure effective cutting. The object is to cut the wax, not melt it.*

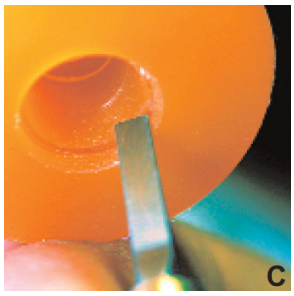
(A) When turning wax on a flex shaft, a flat graver is positioned at 3:30 with the heel of the tool slightly lower than the tip of the tool. When opening up the inside of shank, it is important to make the groove that you are cutting wider than the tool, so the tool doesn't get stuck.



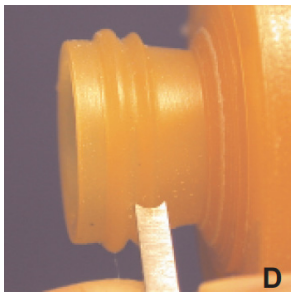


(B) Use Wolf's Precision Wax Carver #14, to make rounded ridges on the shank.

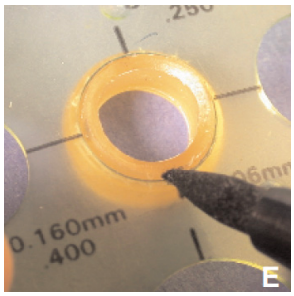
(C) Open up bezel with 90°Tool #10.



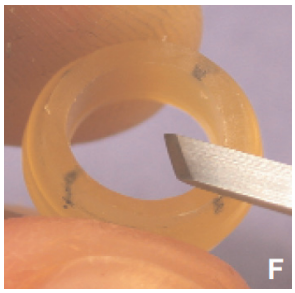
(D) Make round decorative bands on outside of bezel with Rounding Tool #13.



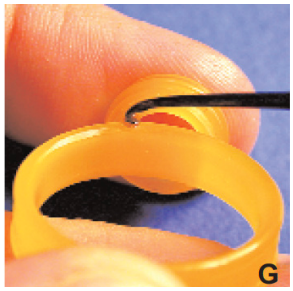
(E) Bezel is positioned in template and N,S,E and W marks are made with a non-permanent marker or a scribe. These marks make it easy to carve away the bottom of the bezel while keeping it symmetrical.



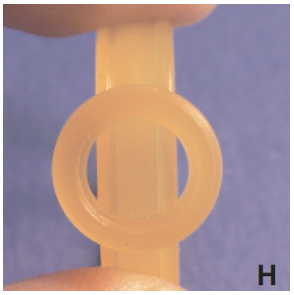
(F) Bottom of bezel is scraped with Carving Knife #3 so that it echoes the contour of the shank. It is not important for bezel to fit to shank tightly. The gap between bezel and shank will be filled in with waxes.



(G) Bezel is postitioned on shank (using N,S,E,W marks to line it up evenly). Hot wax pen is poked into seam between bezel and shank, tacking it in one place on each side.



(H) Examine ring from every angle, making sure the bezel is level and centered. If it isn't, break apart, reposition and tack again.



How-To: Using a Lathe

(I) Pick up some Wolf Build-Up/Repair Wax™ with a hot wax pen or heated dental pick. This wax melts at approximately 230°F (110°C).

(J) Fill in gaps on sides of ring, between bezel and shank with Build-Up Repair Wax. (Don't fill in gap where the top of shank meets the bezel, the rounded detail would be ruined by the hot wax. For best results, melt the wax you are adding onto as well as the Build-Up/Repair Wax to achieve a good bond. While the wax is molten look for trapped air bubbles and coax them to the surface with a wax pen. If repaired area has inclusions or strings when pen is removed, increase heat and be sure to melt the wax well. If the wax pen tip is smoking, turn down temperature.

(K) Use Carving Knife #3 to blend bezel into shank. Use a wax bur to open up inside of bezel, through shank.

(L) Use Hollowing tools #5 and #17 to smooth inside of bezel. Make bezel walls approximately 1.2 mm.

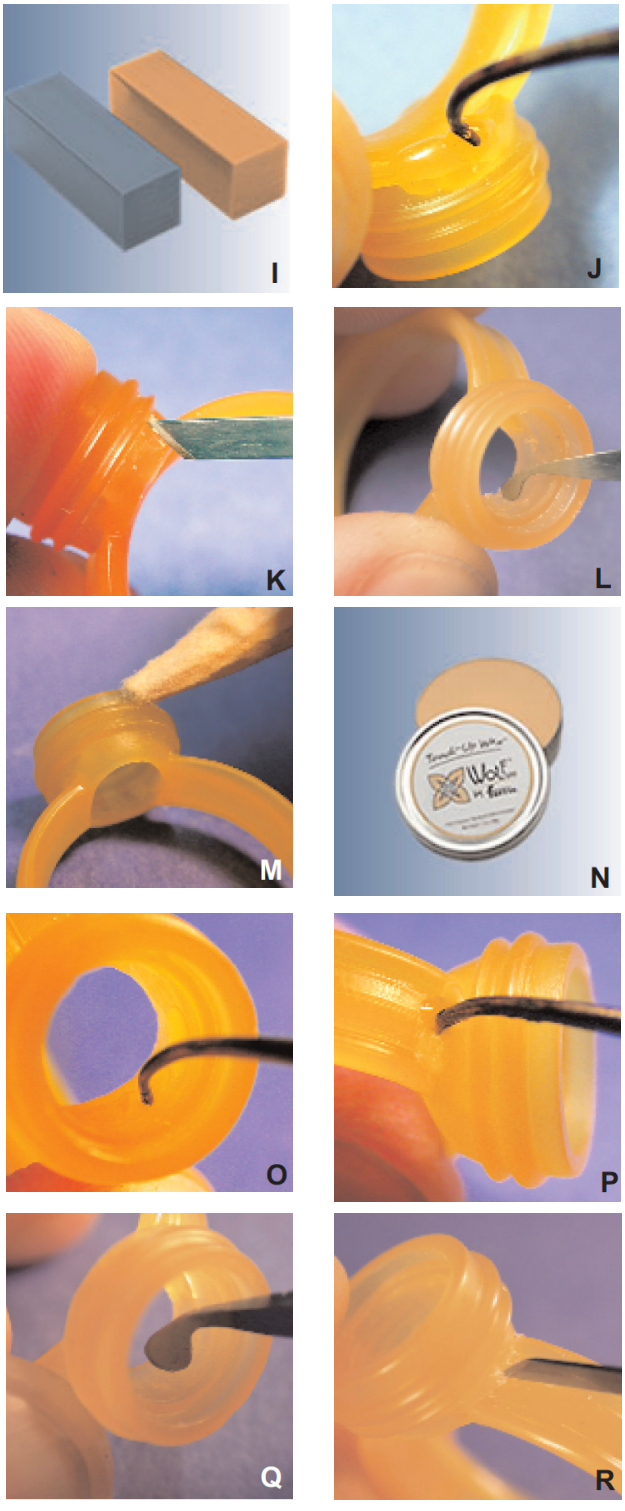
(M) Use felt stick to smooth tool marks on surface of the wax. Touch up Wax is softer than Carving Wax and Build-Up/Repair Wax. If you are using finishing tools and solvents it is important to do so before proceeding to next step, as they attack Touch Up Wax more aggressively than the Carving and Build-Up Waxes.

(N) Wolf Touch-Up Wax™ is ideal for final touch ups, filling in surface imperfections and gaps. It flows by capillary action. It is not necessary to heat up the wax that it is being added onto for a good bond.

(O) Pick up some Wolf Touch-Up Wax™ with a wax pen, fill in any gaps inside of bezel.

(P) Fill in gaps between bezel and rounded ridges of shank.

(Q) Smooth off excess Touch-Up Wax from inside of shank with Hollower #5.



(R) Inspect ring and fill in any surface imperfections with Touch-Up Wax. Use Wolf's Precision Wax Carvers to blend in Touch-up Wax.