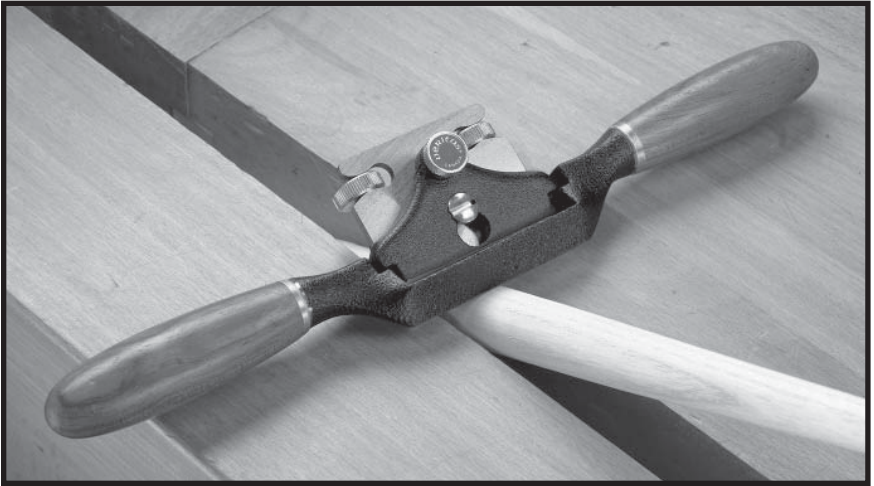


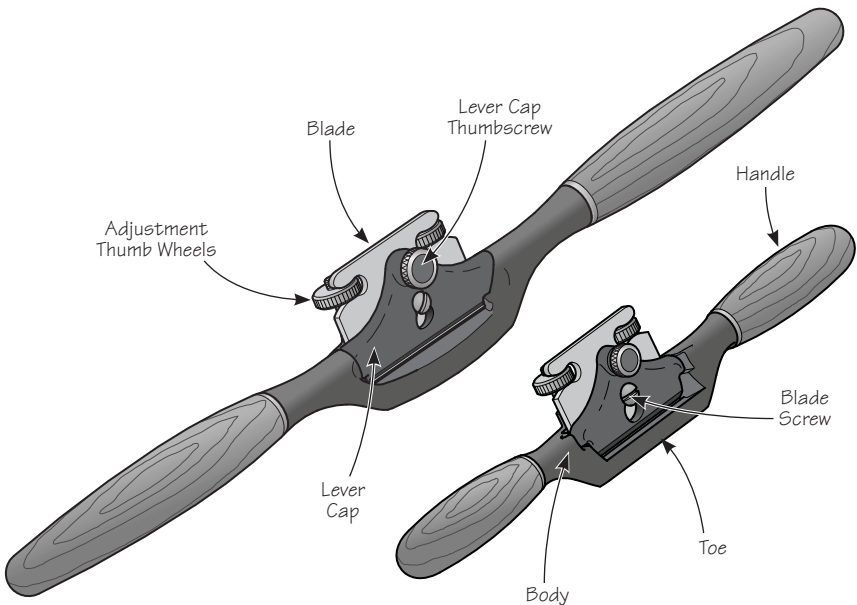
*veritas*<sup>®</sup>  
**Spokeshaves**



U.S. Des. Pat. D499,770

# Introduction

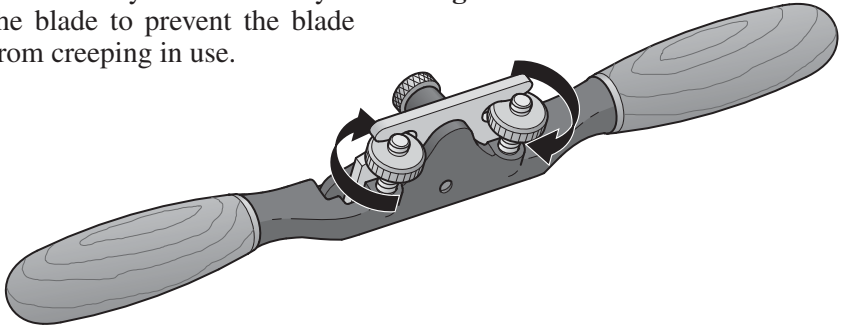
The Veritas® spokeshaves have been designed for smooth, effective shaping of chair spindles, tool handles, panel edges, paddle shafts, etc. The large spokeshave is ideally suited for shaping large, gently curved projects such as pails, barrels, coopered doors, masts, and paddle blades. The thick blade, carefully machined lever cap and blade bed all combine to produce chatterfree cutting in virtually all conditions. The 1/8" (0.125") thick blade (A2 or O1 tool steel) is seated at 45° to the sole. The ductile cast iron body is fitted with African rosewood handles that are shaped for comfort and control, offering several ways to grip the tool comfortably with no corners or edges to cause discomfort when either pulling or pushing. The toe provides a convenient thumb rest that allows the user to choke up on the body to achieve an unusual degree of control for fine work. The twin adjustment thumb wheels quickly and accurately control the depth of cut and skew. Together with the lever cap, the thumb wheels also ensure the blade may be easily removed for sharpening and other maintenance, then re-installed into the same position.



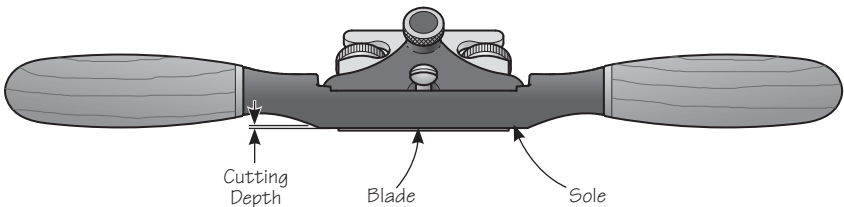
**Figure 1: Spokeshave components.**

## Blade Adjustment

**Depth of Cut:** To increase or decrease the depth of cut, loosen the lever cap thumbscrew so that it just holds the blade in position. Turn each thumb wheel in the same direction an equal amount, as shown in **Figure 2**, until the desired depth of cut is reached. Sight along the sole as shown in **Figure 3** to gauge the degree of blade projection. Re-tighten the lever cap thumbscrew when adjustment is complete. The depth of cut should always be reached by **advancing** the blade to prevent the blade from creeping in use.



**Figure 2: Turn thumb wheels to set the depth of cut.**



**Figure 3: Checking the depth of cut.**

**Skew:** To achieve consistent and predictable cutting, you may set the cutting edge parallel to the sole. However, by using the thumb wheels to set the blade at a slight angle so that one side is higher than the other, you can achieve cuts of differing depths without having to re-adjust the depth of cut. With the right side of the blade set lower, you could make larger, roughing cuts with the right side of the blade and then shift over to the left side of the blade for finer, finishing cuts. This, of course, works only when the contact area of the workpiece is substantially less than the width of the blade, such as when working spindles.

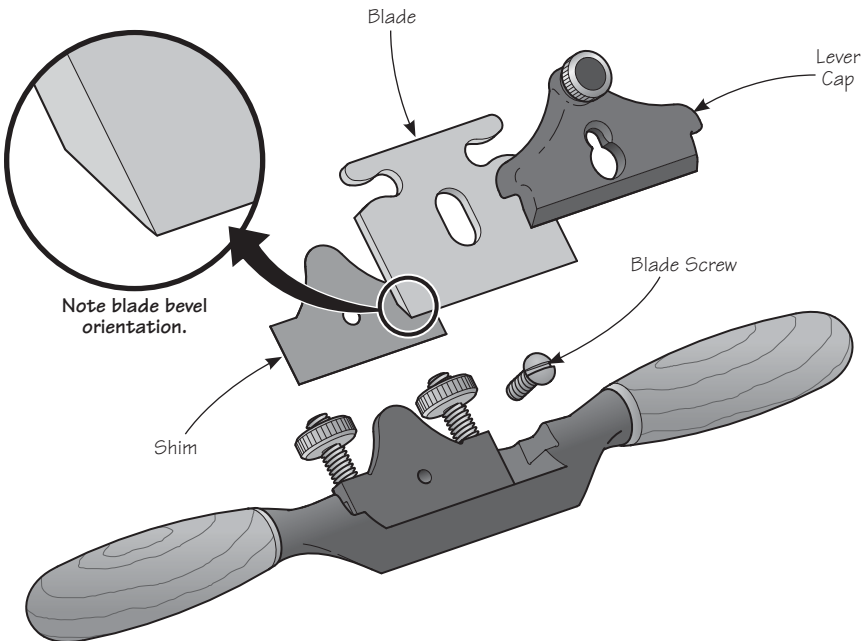
## Blade Bed Shims

A small envelope with two colored shims has been included with the spokeshave. These may be placed under the blade to modify the mouth opening for very fine work with minimum tear-out. Before installing the shims, use a feeler gauge set to determine the size of the mouth opening. The shims themselves may be used to get a rough idea of the size. Plain bond paper (typically 0.0035" to 0.004" thick) can also be used. Before checking, adjust the blade so the cutting edge is aligned with the sole. The purple shim is 0.005" thick while the blue shim is 0.010" thick. The 0.005" shim will close the mouth by 0.007", the 0.010" shim will close the mouth by 0.014", and both together will close the mouth by 0.021". To install the shims, slacken the lever cap thumbscrew, remove the lever cap, and then carefully remove the blade.



**Caution:** At all times when handling the blade and lever cap be aware that they are very sharp and careless handling can result in serious injury.

Use a slot screwdriver to remove the blade screw. Put the desired shim(s) in place and replace the blade screw as shown in **Figure 4**. Replace the blade and lever cap.



**Figure 4:** Using shims to adjust the mouth.

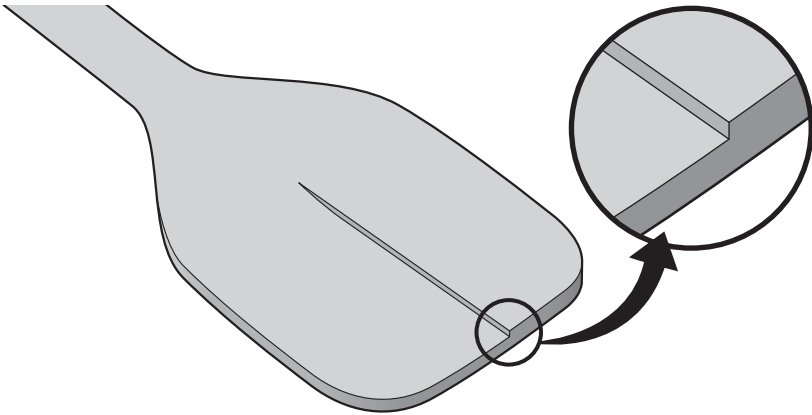
## Sharpening

The spokeshave blades come with a finely ground  $30^\circ$  primary bevel and a  $35^\circ$  micro-bevel. This configuration provides a strong, long-wearing edge that can be quickly honed many times before the primary bevel needs to be reground. The  $35^\circ$  micro-bevel leaves a  $10^\circ$  relief angle, more than adequate to accommodate the springback of the wood fibers. Additional honing will improve performance. The finely ground blade face can be readily lapped to a mirror finish.

## Blade Profile

Your spokeshave comes equipped with a general-purpose, straight-blade profile, good for most shaving tasks and the easiest profile to sharpen.

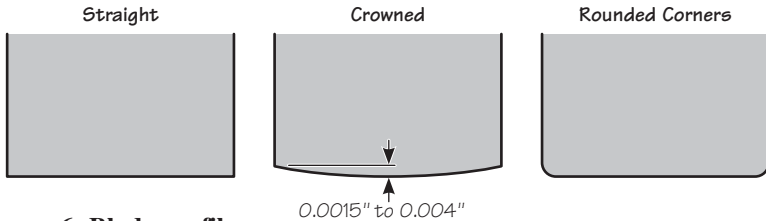
If you are shaving flat or slightly crowned wide surfaces such as paddle blades or coopered doors, the sharp corners of the blade may dig into the workpiece. To prevent this, you can crown or round the corners of the blade.



**Figure 5: Blade corner may dig into the workpiece.**

**Crowned** – The goal is to conceal overlapping strokes on a wide surface by having the middle portion of the blade project from the sole while the corners are safely out of the way. The resultant surface will have a series of broad, shallow, parallel flutes, but the panel will appear to be flat to all but the most careful observer. Ideally, the height of the crown will be slightly more than the intended shaving thickness (e.g., for fine smoothing this may be as little as 0.0015"). This profile is easy to produce since most stones (especially water stones) that have not been freshly trued will naturally produce a crowned blade. When working on a hard, flat, oil stone (such as a hard Arkansas), the crown can still be achieved by alternately applying more pressure on the corners.

**Rounded Corners** – According to many authorities on the subject, this is the best all-purpose profile because it ensures the maximum width of cut and allows overlapping strokes on a wide surface. It is, however, a bit of a challenge to do well. All the requirements to sharpen a straight edge must be met, plus a smoothly rounded transition needs to be ground and honed on each corner or the edges of the blade will leave lines in the workpiece. There are no jigs sold for this process, so a bit of practice freehand grinding and honing is needed to get the profile just right.



**Figure 6: Blade profiles.**

## Care and Maintenance

The body of your Veritas spokeshave is ductile cast iron and comes treated with rust preventative. Remove this using a rag dampened with mineral spirits. Clean all machined surfaces, including the blade bed.

We recommend that you initially, then periodically, apply a light coat of paste wax to the sole to seal out moisture and prevent rusting; this has the added bonus of acting as a lubricant for smoother shaving. Wipe off any wood dust from the sole, apply a light wax coating, let dry, then buff with a clean soft cloth. At the same time, the solvents in the wax will remove any harmful oils left from your fingers that can lead to corrosion.

Keep in mind that paste wax contains silicone that, if transferred to your workpiece, could cause finishing problems such as "fish eyes". To avoid this problem, use silicone-free products, such as Waxilit® sliding agent and glue release, or a tool surface sealant and lubricant. Either is an excellent alternative to regular paste wax. However, before treating with a sealant, wipe off any fingerprints with a cloth dampened with a small amount of light machine oil. Remove any residual oil; then apply the sealant to the spokeshave's sole.

If storage conditions are damp or humid, your spokeshave should, in addition to the treatment outlined above, be wrapped in a cloth or stored in a plane sack. This precaution will also guard against dings and scratches.

Every so often, take the spokeshave apart to clean and lubricate it where necessary. Remove the lever cap, blade and adjustment mechanism. Clean all parts with a cloth dampened with a dab of light machine oil. The blade bed and other machined surfaces, as well as the adjustment components, will benefit from a light coat of oil to keep them working freely. For corrosion, we recommend you first remove the rust with a fine rust eraser, then treat as described above.

The bright finish on the brass components can be maintained as above. If a patina finish is preferred, simply leave the brass components unprotected until the desired level of oxidation has occurred, then apply a sealant. If you want to make them bright and shiny again, you can revitalize the surface with a brass polish.

The rosewood handles have a lacquer finish and should require nothing more than a wipe with a clean cloth from time to time.

## Accessories

<b>05P33.01</b>	Flat Spokeshave, A2 Blade
<b>05P32.51</b>	Flat Spokeshave, O1 Blade
<b>05P33.03</b>	Round Spokeshave, A2 Blade
<b>05P32.53</b>	Round Spokeshave, O1 Blade
<b>05P33.04</b>	Replacement Shims for Spokeshave
<b>05P33.05</b>	A2 Blade for Spokeshave
<b>05P32.55</b>	O1 Blade for Spokeshave
<b>05P33.20</b>	Hardware Kit for Spokeshave Handles
<b>05P33.90</b>	Large Spokeshave, A2 Blade
<b>05P33.91</b>	Large Spokeshave, O1 Blade
<b>05P33.98</b>	Replacement Shims for Large Spokeshave
<b>05P33.92</b>	A2 Blade for Large Spokeshave
<b>05P33.93</b>	O1 Blade for Large Spokeshave
<b>05P33.97</b>	Hardware Kit for Large Spokeshave Handles

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