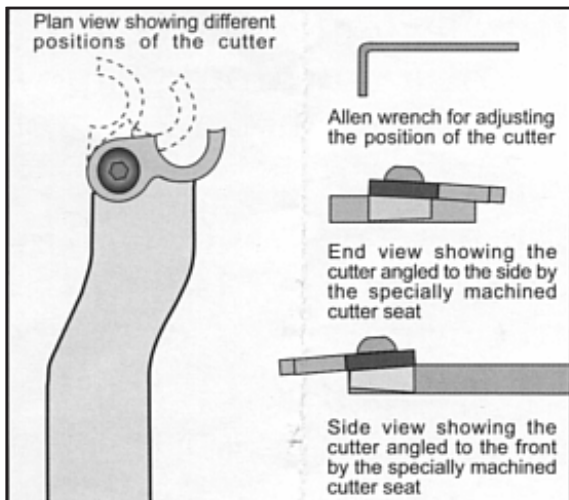
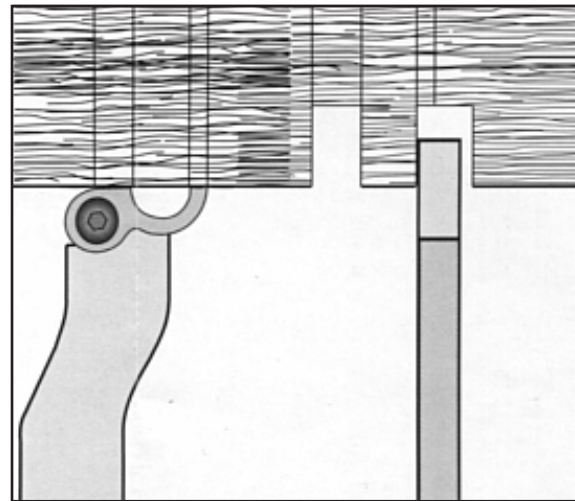


Instruction/Data Sheet

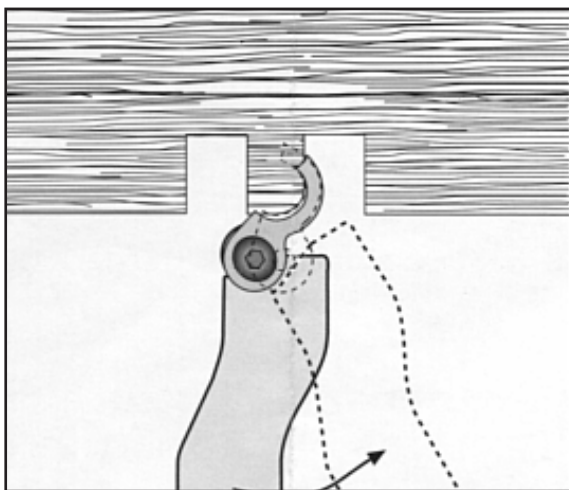
The Captive Ring Tool from *Robert Sorby* has some unique and innovative features. The cutters are double sided so that only one cutter is required to create the desired captive ring. Captive ring cutter sizes available are 3/16" (5mm), 1/4mm" (6mm), 3/8" (10mm) and 1/2" (13mm).



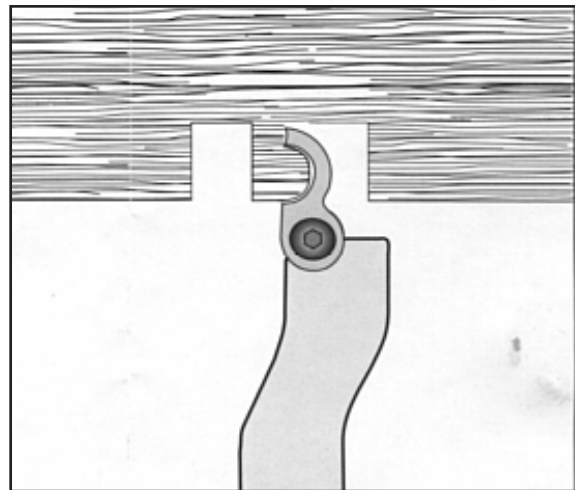
Included with the tool is one captive ring cutter, a machine screw and allen key/wrench.



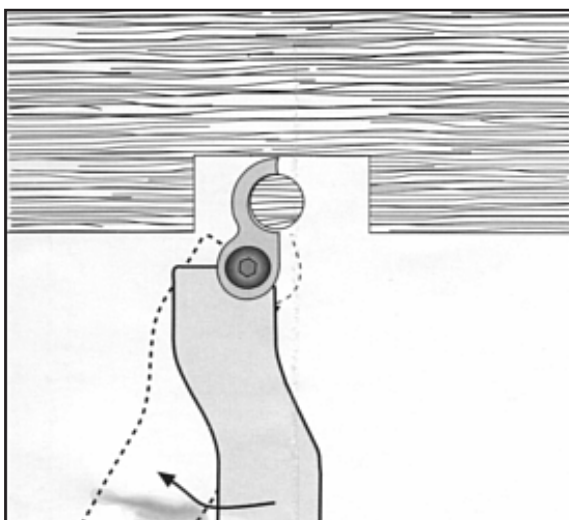
Adjust the cutter back as above and mark on the wood where the ring will be formed and then remove waste either side of the lines using a parting tool.



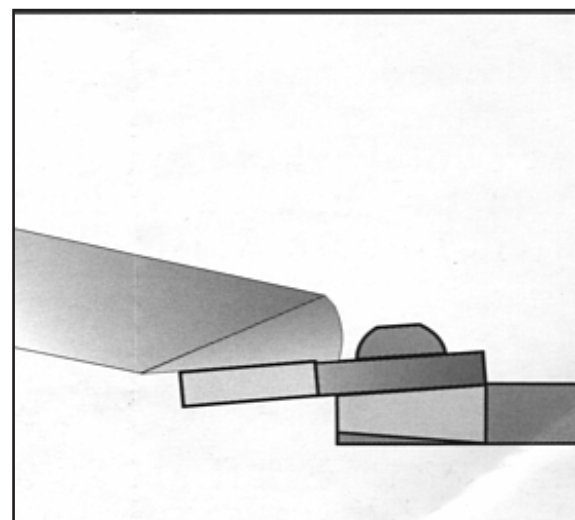
Now move the cutter as above and with just the fluted cutting edge cutting, gently sweep the tool so that the right hand side of the ring can be formed.



Adjust the cutter so that it is parallel with the shaft and finish the right hand side of the ring.



Remove the screw and cutter. Turn the tool over and replace the cutter so that it is facing right. Now repeat the previous 2 operations from the left side.



Sharpen across both the top and bottom face of the cutter using a honing stone or diamond file.