

# ACCU-BURR JR™

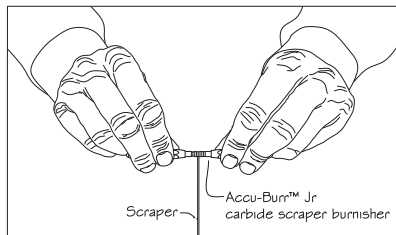


Fig 2 Grasp the Accu-Burr™ Jr with your forefingers and thumbs. Pressing downward with light force, draw it along the edge several times until a nearly imperceptible burr is formed.

## Using Your Accu-Burr™ Jr Burnisher

The Accu-Burr™ Jr is designed to work on nearly any scraper. With the scraper in a vise and grasping the Accu-Burr™ Jr in your thumbs and forefingers (Fig. 2), hold the burnisher perpendicular to the scraper faces and edge (Fig. 3) and draw it along the edge using light to moderate force. Multiple lighter passes are preferable to a heavy hand. No more than approximately 15 pounds (7 kg/70 N) of downward force is needed - **excessive force will break the carbide rod.**

After each pass, feel for a burr on the edge. This burr should be nearly imperceptible (on the order of a thousandth of an inch (0.025mm) or less, which is about ¼ the thickness of an ordinary sheet of printer paper). A larger burr is fragile, with little or no added benefit.

After using the scraper for a while, the burr will need to be turned again. If the burr isn't too dull, we've had good luck skipping over the jointing and sharpening, and simply turning the burr again with the Accu-Burr™ Jr. This can be repeated several times before the preparation process needs to begin again with jointing.

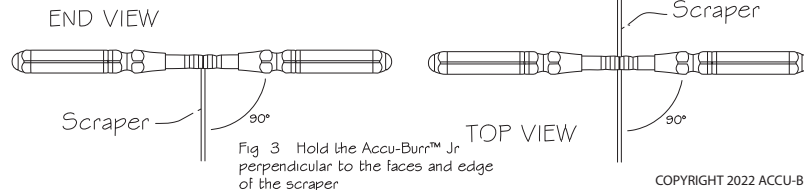


Fig 3 Hold the Accu-Burr™ Jr perpendicular to the faces and edge of the scraper.

**Accu-Burr™ Jr - one burnisher, any scraper.** Meticulously designed in every detail to be the most versatile burnisher ever, the Accu-Burr™ Jr is the first and only burnisher you need at your bench. The heart of the Accu-Burr™ Jr is a 3/16" diameter carbide rod with three v-shaped grooves, precision ground to turn a fine, medium, or coarse (5°, 10°, or 15°, respectively) burr simultaneously on both sides of any prepared scraper edge (Fig. 1). Paired with attractive brass handles permanently affixed to the carbide rod, the Accu-Burr™ Jr turns consistent and accurate burrs on scrapers of nearly any shape, thickness, or hardness.

## A Brief Overview of Scraper Sharpening

There are three steps to ready your scraper for use. Proper preparation of the edge before burnishing is critical.

**Jointing** uses a file to square the edge in preparation for honing. Use an 8" or 10" single cut file with either bastard cut or second cut teeth. Use a jointing guide or a block of wood or angle aluminum to hold the file perpendicular to the face of the scraper while jointing.

**Sharpening/honing** uses a sharpening stone (usually diamond or oilstones) to further refine the squared edge before turning the burr. Again, use a block of wood or angle aluminum to hold the scraper perpendicular to the stone while honing. Work on a fine diamond stone; going finer than this yields somewhat finer results, but with diminishing returns. Jointing and honing the edges raises a wire burr on the faces of the scraper, so work these off with the stone as you sharpen the edge. When done properly, the intersections of the edge and the faces are sharp with no burr. This edge removes very fine shavings or dust from wood.

**Burnishing** is the controlled shaping of the scraper's edge into a sharp hook, or burr. This burr removes fine shavings of wood in a measured and predictable manner.

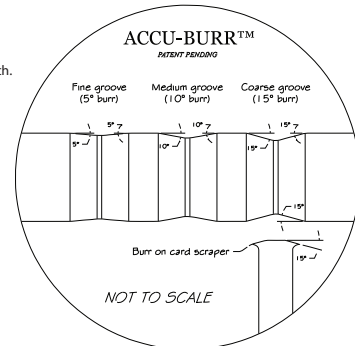


Fig 1 Close-up of the Accu-Burr™ grooves, showing simultaneous formation of a burr on both sides of the scraper.

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## Using Your Scraper

Hold the scraper with your thumbs as low as possible, touching or nearly touching the wood. Pushing both down and forward, vary the angle of the scraper to the wood until the edge bites deeply. This is the most aggressive position; you may increase or decrease this angle to cut less aggressively to suit your needs. Flex the scraper to concentrate the force behind the scraper and remove a narrower and thicker shaving; flatten it out to achieve the opposite.

## Cautions and Care

While carbide is extremely hard, making it the preferred material for burnishing steel, this superior performance comes with a trade-off – carbide is somewhat brittle. Because of this, **do not use excessive force to turn a burr.** If your edge is properly jointed and sharpened, little force is required to turn a burr that can be barely felt with your fingertip. Trying to turn an excessive burr, or turning a burr on an improperly prepared edge runs the very real risk of breaking the carbide rod.

A prepared scraper edge is a sharp precision tool. Handle your scraper with the care and respect you would show a chisel or plane iron.

**Do not drop the Accu-Burr™ Jr, as impact will break it.**

If you don't like the natural patina that brass develops over time, the original luster can be restored with light buffing or the use of a metal polish like Autosol.



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