

# Instructions for the 1/4", 3/8", 1/2" Combination Left and Right Hand Captive Ring Tool

With a parting tool, make a square groove on each side of the ring, each groove slightly wider than the diameter of the ring.

These tools work with a scraping action and therefore the toolrest should be raised slightly above centre height and the tool used nose down, but with the top face pointing at the lathe centre line.

Initial entry into the rib is easier if the corners of the rib are removed by a light chamfer on each of the two corners.

Both faces of the tool will cut, one face at a time, on both sides of the ring.

When the tool starts to eat with the inside section of the hole located on the part - turned bead, dissectional control becomes quite easy.

The tool should be honed (and only on the two bevelled cutting faces) rather than ground when sharpening which will ensure a much longer life.

