

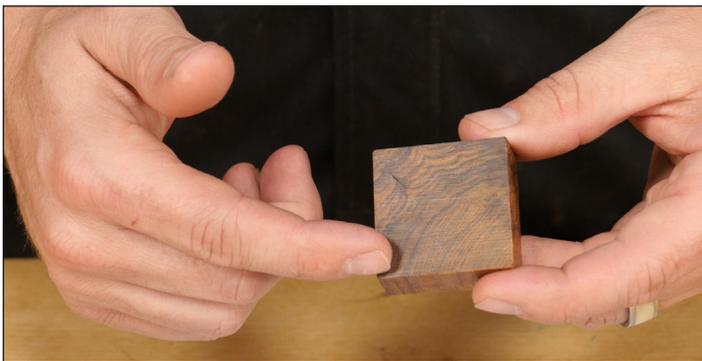
## Turning a JDG SS 2-Piece Ring Core

### Supplies Needed

- Ring Blank
- Ring Core
- Digital Calipers
- Double Face Tape
- Sandpaper/Finish
- Eye and Ear Protection
- Chuck
- Scrap Block
- Revolving Center
- Drill Chuck/Collet Chuck
- Drill bit
- (Opt.) JDG Ring Mandrel
- (Opt.) Ring Chuck
- (Opt.) Plastic Polish/Dremel

### Selecting a Ring Blank

1. Select a blank that is at least 8mm wide. We recommend using a dense exotic wood or a stabilized blank for this project.



### Separating the Ring Core

1. Use a flat bar that will fit in the 6mm channel of the ring core and twist side to side to separate the two halves. Be careful not to damage the ring core.

### Fitting the Ring Core

1. Mount a 2" square waste block in a chuck and true up the face of the blank.
2. Apply double face tape to the face of the scrap block and attach the ring blank. Make sure the backside of the ring blank is smooth and perfectly flat to provide a good bond with the tape.
3. Advance the live center against the disc. This pressure will strengthen the bond of the tape during the rough turning of the disc.



4. Rough turn the blank to round, then remove the live center.
5. Carefully square up the face of the ring blank until the ring blank is roughly 6.5mm wide. Use calipers to measure the width of the ring blank.



6. Select a drill bit half the diameter of the ring you are turning. Mount the drill bit in a drill chuck and drill through the ring blank.
7. Now with a skew or narrow scraper flat on its side open up the drilled hole until the ring core fits in the hole.



8. We recommend using the ring core to test the fit frequently to avoid an oversized hole. Ideally the ring core should just barely fit in the hole.



- Once the ring core fits in the blank remove the ring blank from the waste block. It's critical here that the blank is exactly 6mm wide for a precise fit. Lay some 220 grit paper and sand the turned side of the blank in a figure 8 pattern until it is exactly 6mm wide.



- Use acetone or denatured alcohol and thoroughly clean the ring core and ring blank.
- Using an epoxy, coat the inside of the ring blank and insert the ring halves. Make sure they are completely pressed together and that the seam is nice and tight. Wipe away all excess epoxy and let cure.



### Turning the Ring

- Mount the ring core/blank on a JDG Ring Mandrel, or the Artisan Ring Turning Chuck.



- Turn the blank flush with the metal. Sand the blank and core through 600 grit.
- Finish the blank with your choice of finish. We will use Scratch Free to polish the wood and the core including the sides. Now apply plastic polish for a final sheen, following the same procedure as the wax.



- Your ring is now ready to wear!



### (Optional) Deburring and Polishing

- If you want a more polished finish you can use any metal polish or Micro Magic to refine the surface finish. This can be accomplished by holding the ring in a chuck and polishing, or using a dremel with a small polishing wheel. If you want a uniform satin finish you can use steel wool to achieve a nice satin finish.

