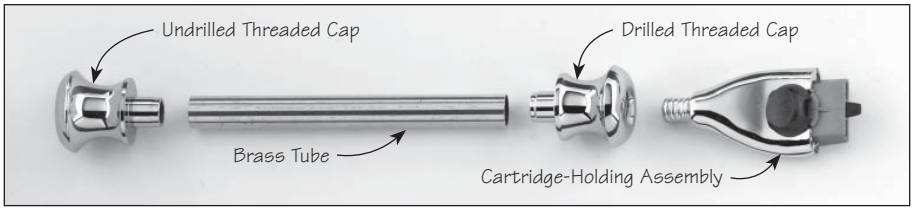
Razor Hardware Kit

Requires standard "A" mandrel, razor bushings (88K80.19), 7 mm drill bit, and minimum 3/4″ square by 2 5/8″ long blank.



Razor parts

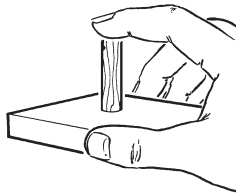
General Instructions

Cut the turning square to length, center-drill the piece to accept a brass sleeve, and glue the brass sleeve into the turning blank. Mount the bushings and blank on the mandrel and turn the blank to size, using the bushings to gauge the proper diameter of the component to be turned.

Cutting the Turning Blank to Length

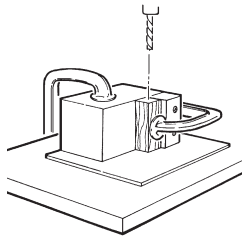
When cutting the turning square to length, cut the blank 1/32″ longer than the brass tubing. To ensure a seamless fit between the wood and the razor hardware, the length can be sanded flush and square at either end after the component has been turned.

You can make a small sanding jig from a 1 1/2″×1 1/2″×3/4″ square piece of wood with an accurately drilled hole matching the outside diameter of the turned component to ensure that the end is sanded squarely.



Drilling the Stock

It is strongly recommended that you drill your turning blank on a drill press. A drill press vise or homemade jig to help keep your blank centered and vertical is also a necessity.



You can use a standard twist bit; however, there is a chance that you will split the blank when the bit breaks through the bottom. You will not have this problem if you use a HSS lipped brad-point bit or a HSS parabolic-flute bit (which is ideal for use in dense hardwoods, epoxy-stabilized woods, acrylic acetate, or other challenging materials). Whichever bit you choose, withdraw the drill frequently to clear chips from the flutes.

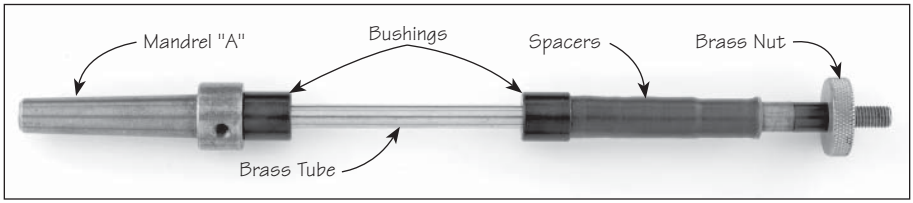
For exotic woods that have unstable moisture content, you can prevent cracking by first drilling a 1/8″ diameter hole. Let the wood blank dry for about a week, and then redrill with the size of drill required for the sleeve. Other turners prefer to drill the wood and insert the sleeve immediately on bringing the wood in the shop, since thin walls are less likely to crack.

Gluing the Brass Sleeve

Use quick-setting epoxy, polyurethane or cyanoacrylate to glue the brass sleeve into the wood blank. Spread a small amount of glue on the outside of the brass sleeve and slide the sleeve into the wood. Do not put the glue into the hole in the wood because you will inevitably end up with glue inside the brass sleeve.

Turning the Body

Mount the bushings and turning blank on the mandrel, as shown in the photograph below. Additional spacers will be required to fill the remaining gap so that all the components on the mandrel fit tightly. (You can use the bushings used to turn a standard 7 mm pen/pencil, or make your own by cutting a hardwood blank to length and drilling a 7 mm center through hole.) Clamp the components in place by threading the nut onto the end of the mandrel only finger tight.



Turn the blank to the desired size and contour. Use the bushings as guides for the exact diameter that each end of the turned component should be. Sand and finish the turned piece on the lathe.

Assembly

Refer to the parts photograph for the correct order. The components press-fit together. Once the components are pressed together, it is almost impossible to take them apart. **Do not** try to dry fit the assembly before the components are completely finished.

1. Press the undrilled threaded cap into one end of your finished blank.
2. Press the drilled threaded cap into the other end of your finished blank.
3. Screw the cartridge-holding assembly into the drilled threaded cap.
4. Attach a Gillette Mach 3® cartridge (not included).

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