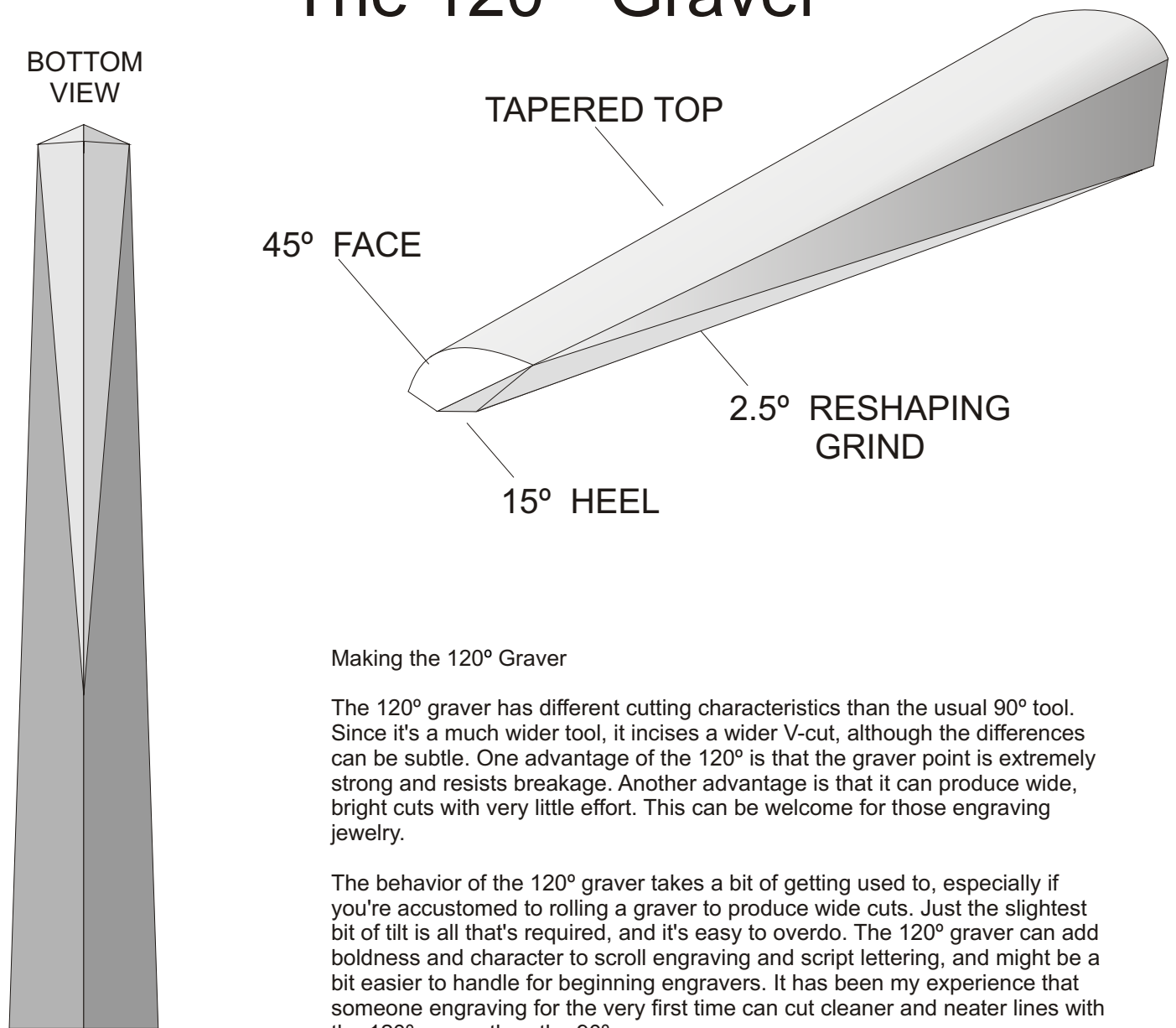


The 120° Graver



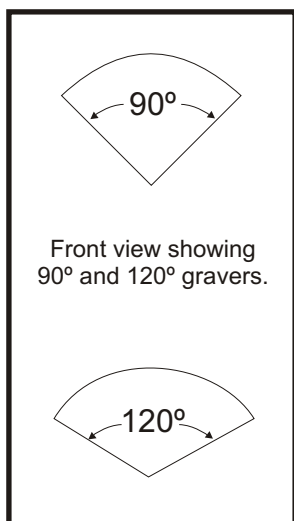
Making the 120° Graver

The 120° graver has different cutting characteristics than the usual 90° tool. Since it's a much wider tool, it incises a wider V-cut, although the differences can be subtle. One advantage of the 120° is that the graver point is extremely strong and resists breakage. Another advantage is that it can produce wide, bright cuts with very little effort. This can be welcome for those engraving jewelry.

The behavior of the 120° graver takes a bit of getting used to, especially if you're accustomed to rolling a graver to produce wide cuts. Just the slightest bit of tilt is all that's required, and it's easy to overdo. The 120° graver can add boldness and character to scroll engraving and script lettering, and might be a bit easier to handle for beginning engravers. It has been my experience that someone engraving for the very first time can cut cleaner and neater lines with the 120° graver than the 90°.

1.) RESHAPING THE GRAVER BLANK - With a graver blank mounted in the Dual Angle sharpening fixture, set the tool post angle to 2-1/2 degrees (or about halfway between 0 and 5 degrees). Now rotate the fixture head to 30° to the right of zero and sharpen back to about 1/2 inch. Rotate the fixture head to the left of zero to 30° and sharpen the other side the same way. The object here is to create two symmetrical grinds on the bottom of the graver which will change its shape from 90° to 120°. The length of these grinds is not very important, as you are just changing the graver's front end from a 90° square to 120°.

2.) SHARPENING THE HEEL - Change the toolpost angle to 15° (or whatever amount of lift you normally use) and sharpen the left side of the heel as you would any other graver. Rotate the fixture past zero to 30° and sharpen the opposite side of the heel, and the 120° graver is complete.



120° Graver Sharpening with the Dual Angle fixture

