OneWay EasyCore setup info by Tom Coghill

The Big Stuff

Depth of Cut	Knife 1	Knife 2	Knife 3	Knife 4
	5.00	6.25	7.50	8.25
0	Diameter of Bowl Removed			
1.5	7.14	8.12	9.00	9.49
2	8.00	9.17	10.20	10.77
2.5	8.66	10.00	11.18	11.83
3	9.17	10.68	12.00	12.73
3.5	9.54	11.22	12.69	13.49
4	9.80	11.66	13.27	14.14
4.5	9.95	12.00	13.75	14.70
5		12.25	14.14	15.17
5.5		12.41	14.46	15.56
6			14.70	15.87
6.5			14.87	16.12
7				16.31
7.5				16.43

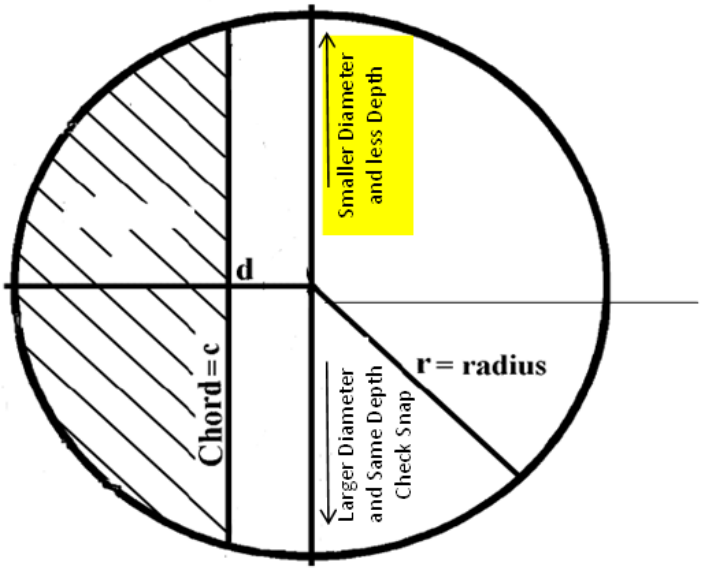

Fig. 1 – Segment of a Circle values identified.

Chord = 2Sqrt (r^2-d^2)

The Little Stuff

Depth of Cut To Adjust	Knife 1	Knife 2	Knife 3	Knife 4
	5.00	6.25	7.50	8.25
0	Offset from Centerline			
0.125	1.11	1.24	1.36	1.43
0.25	1.56	1.75	1.92	2.02
0.375	1.90	2.13	2.34	2.46
0.5	2.18	2.45	2.69	2.83
0.625	2.42	2.72	3.00	3.15
0.75	2.63	2.97	3.27	3.44

Wood Blank Coring worksheet

I have found this worksheet helpful when making more than two bowl blanks from a single piece of wood.
Multiple corings need to be well planned to yeild the most bowl blanks.

By Tom Coghill
January 2017

Dimensions are in inches for this example

				Diameter	Depth	Explaination, Comments and Thoughts
Input the Initial wood Blank Dimensions				**19**	**11**	
	Wall Thickness	1.5	Subtract x 2	-3	-1.5	**Note:** Initial thickness of bowl base must account for connectors (i.e. faceplate screws)
	Maximum Cut Line			16	9.5	
			Select Knife Set based upon max cut line			
From "**The Big Stuff**" table	Knife Set #	4		16.43	7.5	Would be offset away ~ 0.2" from CL resulting in virtually no depth change ↑
	Bowl Cut 1		**Knife #4**	**16**	**7.5**	(These are the minimum of the two sets of numbers)
	Setup		Depth Setting Maximum		Offset 0.2" away	Offset is Determined the difference between the cut diameter and the max cut diameter divided by 2.
	kerf			0.5	0.5	
New Blank				**15.5**	**7**	Subtract keft considerations from Bowl Cut
	Wall Thickness	1	Subtract x 2	-2	1	
	Maximum Cut Line			13.5	6	Offset is Determined the difference between the cut diameter and the max cut diameter divided by 2.
			Select Knife Set based upon max cut line			
	Knife Set #	4		15.87	6	Would be offset away ~ 1.2" resulting in virtually no depth change ↑
	Knife Set #	3		14.7	6	Would be offset away 0.6" resulting in virtually no depth change ↑
	Knife Set #	2		12.4	5.5	Would be offset closer 0.45" resulting in a snap of 0.9" ↓
				Select Knife Set		Decision Time!
	Bowl Cut 2		**Knife #3**	**13.5**	**6**	(These are the minimum of the three sets of numbers)
	Setup		Depth Setting Depth 1.5" setback from Face		Offset 0.2" away	Depth is determined using the knife reach minus cut depth (7.5 - 6 = 1.5)
	Kerf			0.5	0.5	
New Blank				**13**	**5.5**	
	Wall Thickness	1	Subtract x 2	-2	1	
	Maximum Cut Line			11	4.5	
			Select Knife Set based upon max cut line			
	Knife Set #	4		14.7	4.5	Would be offset away 1.85" resulting in 0.2" depth change ↑
	Knife Set #	3		13.75	4.5	Would be offset away 1.38" resulting in 0.125" depth change ↑
	Knife Set #	2		12	4.5	Would be offset away 0.5" resulting in virtually no depth change ↑
	Knife Set #	1		9.95	4.5	Would be offset closer 0.5" resulting in a snap of 1" ↓
				Select Knife Set		
	Bowl Cut 3		**Knife #2**	**11**	**4.5**	
	Kerf			0.5	0.5	
New Blank				**10.5**	**4**	
	Wall Thickness	0.75	Subtract x 2	-1.5	0.75	
	Maximum Cut Line			9	3.25	
			Select Knife Set based upon max cut line			
	Knife Set #	3		12	3	Would be offset away 1.5" resulting in 0.2" depth change ↑
	Knife Set #	2		10.68	3	Would be offset away 0.84" resulting in virtually no depth change ↑
	Knife Set #	1		9.17	3	Would be offset away 0.08" resulting in virtually no depth change ↑
				Select Knife Set		
	Bowl Cut 4		**Knife #1**	**9**	**3.25**	Cut bowls, highest number first, working down and finishing with Bowl Cut 1.
	Kerf			0.5	0.5	
Final Blank				**8.5**	**2.75**	