

## 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

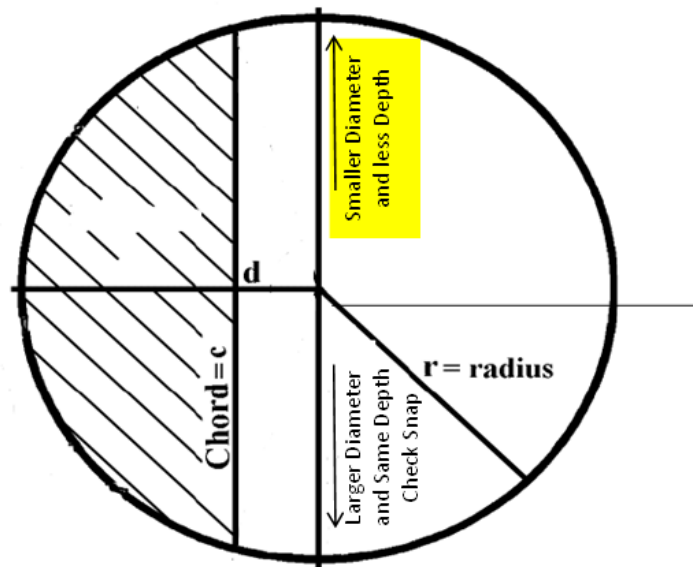


Fig. 1 – Segment of a Circle values identified.

$$\text{Chord} = 2\sqrt{r^2 - d^2}$$

The Little Stuff				
Depth of Cut To Adjust	Knife 1	Knife 2	Knife 3	Knife 4
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 yield the most bowl blanks.

By Tom Coghill  
January 2017

*Dimensions are in inches for this example*

		Diameter	Depth		
<b>Input the Initial wood Blank Dimensions</b>		19	11		
Wall Thickness	1.5 Subtract x 2	-3	-1.5	<b>Note:</b> 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 ↑
	<b>Bowl Cut 1</b>	<b>Knife #4</b>	<b>16</b>	<b>7.5</b>	(These are the minimum of the two sets of numbers)
	Setup	Depth Setting		Offset	Offset is Determined the difference between the cut diameter and the max cut diameter divided by 2.
		Maximum		0.2" away	
	kerf		0.5	0.5	
<b>New Blank</b>		15.5	7		Subtract kerf considerations from Bowl Cut
Wall Thickness	1 Subtract x 2	-2	1		Offset is Determined the difference between the cut diameter and the max cut diameter divided by 2.
Maximum Cut Line		13.5	6		
		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			
	<b>Bowl Cut 2</b>	<b>Knife #3</b>	<b>13.5</b>	<b>6</b>	(These are the minimum of the three sets of numbers)
	Setup	Depth Setting		Offset	Depth is determined using the knife reach minus cut depth (7.5 - 6 = 1.5)
		Depth 1.5" setback from Face		0.2" away	
	Kerf		0.5	0.5	
<b>New Blank</b>		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			
	<b>Bowl Cut 3</b>	<b>Knife #2</b>	<b>11</b>	<b>4.5</b>	
	Kerf		0.5	0.5	
<b>New Blank</b>		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			
	<b>Bowl Cut 4</b>	<b>Knife #1</b>	<b>9</b>	<b>3.25</b>	
	Kerf		0.5	0.5	
<b>Final Blank</b>		8.5	2.75		Cut bowls, highest number first, working down and finishing with Bowl Cut 1.