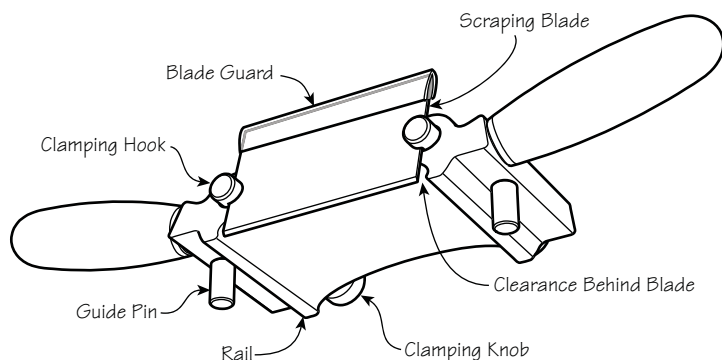


*veritas*®  
**Inlay String Thicknesser**



**05P32.10**

The Veritas® Inlay String Thicknesser is used to scrape veneer or inlay string to a desired thickness. Unlike a conventional scraper, the sole of this tool does not bear against the surface being scraped. Instead, the outer rails slide along the bench surface to straddle the veneer. The thickness of the veneer is determined by the blade projection.



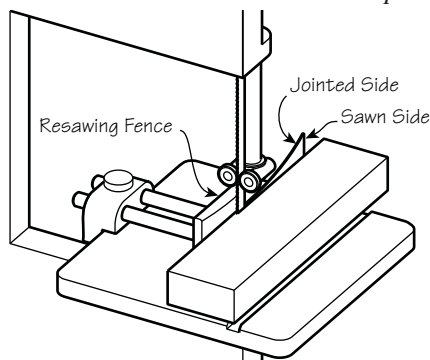
**Figure 1: Features of the inlay string thicknesser.**

## Basic Method for Making Inlay String

Resawing a board efficiently produces thin, rough sheets of veneer that can then be scraped smooth to a uniform thickness. A basic method for making inlay string is described below.

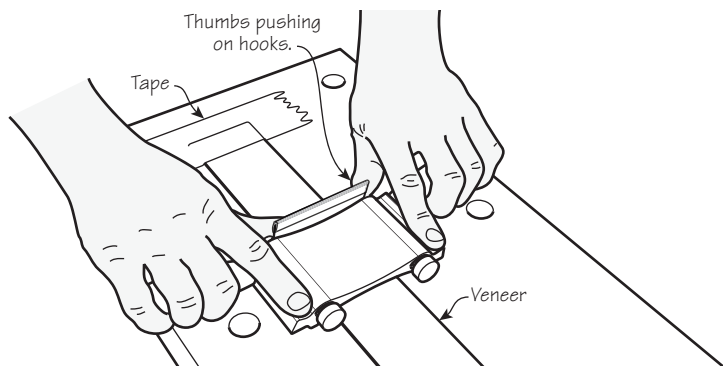
1. Begin by jointing one face of the desired stringing material, then resaw it to obtain a sheet of veneer 25% to 50% **thicker** than the required string thickness and no wider than 2 1/2" to guarantee that the scraping blade can fully span the sheet. Repeat the jointing and resawing steps for as many sheets as necessary for your project.

**Tip:** Jointing before resawing will produce sheets with one flat side that will not need to be scraped.



**Figure 2: Resawing a board.**

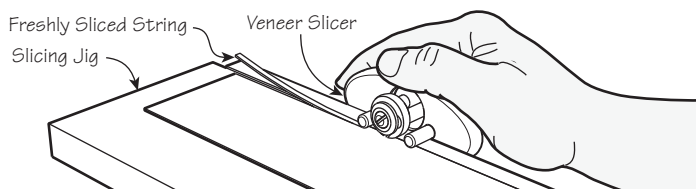
2. Use the inlay string thicknesser to remove the sawing marks from the sheet and reduce the veneer to the desired thickness. (For details on how to do this, see the *Use* section, below.)



**Figure 3: Removing saw marks.**

3. Use the veneer slicer\* or a knife with a fence to slice strings off the sheet of veneer.

\* *Assembled from the components of the Veritas Inlay String Tool System: 05K11.01 Inlay Groove Cutter and Slicing Tool equipped with 05K11.10 Slicing Blade.*



**Figure 4: Slicing strings off veneer.**

## Blade Installation

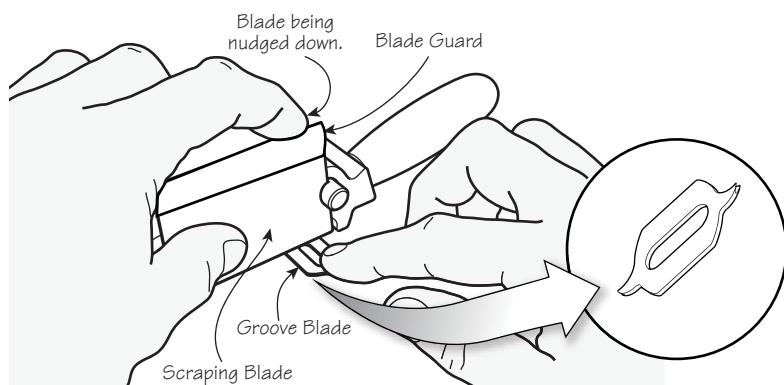
**⚠ Caution:** Be aware that the blade is sharp; careless handling can result in serious injury.

As supplied, two edges of the scraping blade are ground at 45°. The double-edged blade halves the number of sharpening sessions, but do keep the blade guard on the edge not in use so that you do not inadvertently cut yourself.

To install the scraping blade, remove the bottom blade guard and loosen the two clamping knobs. Insert the blade (bevel out) between the clamping hooks, and then tighten both clamping knobs. (See **Figure 1.**)

## Blade Adjustment

To set the scraping blade height to the required veneer thickness, first remove the guide pins and keep the upper blade guard on the blade, then place the tool on a flat surface such that both rails fully contact it. Loosen the clamping knobs just enough to nudge the blade up and down, but not enough for it to drop under its own weight. The brass clamping hooks have O-rings so the blade will not slip out. Place the groove blade that you plan to use for cutting the grooves for the string under the right end of the scraping blade, as shown in **Figure 5**. Nudge this end of the scraping blade down or up until it contacts the groove blade. Carefully slide the groove blade to the left end of the scraping blade and nudge the blade down or up until it touches as well. Tighten the left clamping knob.



**Figure 5: Setting the scraping blade height.**

Check that the right end is still at the correct height, adjust as needed, then tighten the right clamping knob. Slide the groove blade along the entire width of the scraping blade as a final verification of the scraper offset. Adjust if required.

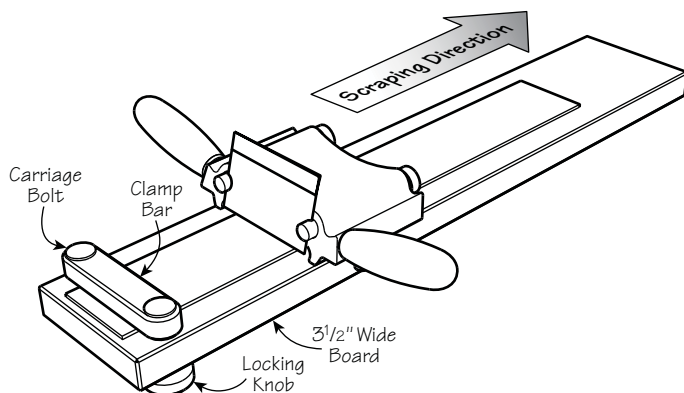
## Workspace

To use the inlay string thicknesser, you will need a flat solid surface to scrape against and a hold-down for restraining the veneer.

If your workbench top is solid and has a flat area at least 4" wide and as long as your veneer, the scraping can take place there. For this set-up, remove the guide pins so that the rails glide along the workbench surface.

To hold the veneer in place, you can simply tape one end to your workbench with a fiber-reinforced tape, such as duct tape or gaffer's tape. Alternatively, you can build a dedicated hold-down, such as the one shown in **Figure 6**. Just about any hold-down will work, but a low-profile clamp will be easier to work around.

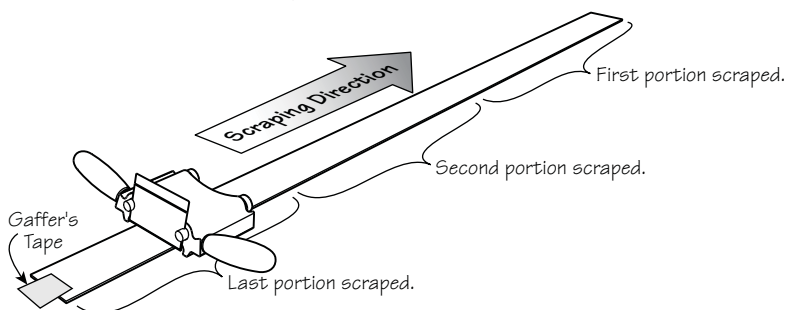
You may also create a scraping jig. The inlay string thicknesser is equipped with guide pins that can straddle a board  $3\frac{1}{2}$ " wide by at least  $\frac{3}{4}$ " thick. The board can be made from any dimensionally stable hardwood or composite, such as maple, ash or Baltic birch plywood. Materials such as phenolic or dense plastics can also be used.



**Figure 6: Example of a veneer hold-down.**

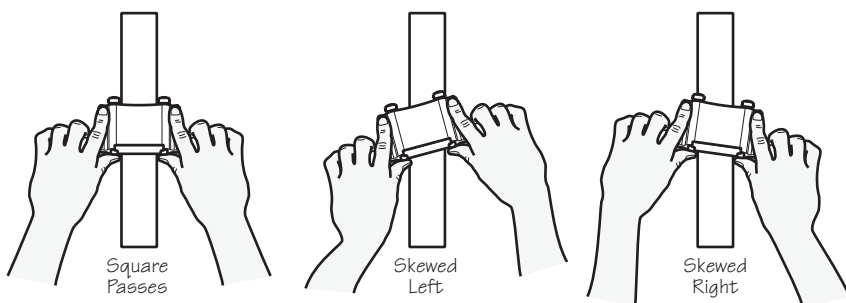
## Use

With the sheet of rough veneer held down, scrape it smooth using push strokes. Ideally, the entire length of the sheet should be scraped in single, long strokes; however, for sheets longer than 18", this isn't practical. Instead, scrape the sheet in increments, starting at one end and working backwards, as shown in **Figure 7**.



**Figure 7: Scraping long sheets incrementally.**

Between every few strokes, adjust the skew of the tool to prevent chattering resulting from the undulating sawing marks on the sheet of veneer. If you are using the guide pins with a  $3\frac{1}{2}$ " wide board, you can skew the inlay string thicknesser up to  $20^\circ$  from square in either direction. With wider sheets of veneer, it may not be possible to skew the tool this much, as a rail could ride up on the veneer. However, the amount of skew is not important, only that it be changed frequently.



**Figure 8: Varying the skew between scraping passes.**

**⚠ Important Note:** When scraping a wide sheet of veneer, you can work with or against the grain and expect nearly the same results. However, when scraping a single string or a sheet of veneer less than 1/2" wide, be sure to work with the grain; otherwise, you run the risk of breaking the string.

## Sharpening

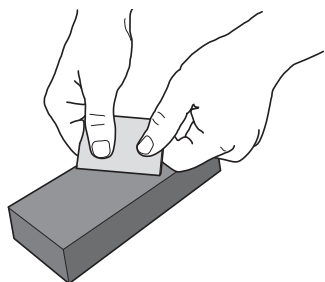
The bevel angle on the scraping blade is ground at 45°.

### Step 1 – Preparation

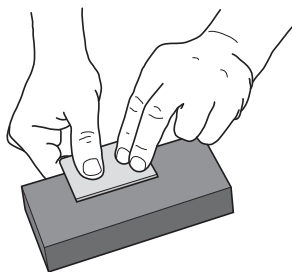
This step is not necessary with a new blade. Before you start honing, the blade should be shaped to maintain a straight cutting edge and a 45° bevel. Hold the blade in a vise and use a 6" or 8" bastard cut mill file to prepare the blade. Check the bevel periodically with a straightedge and a protractor (or sliding bevel set to 45°) as you work. The Veritas Jointer/Edger (05M07.01) is ideal for this process. A bench-top belt sander with an 80x or 120x abrasive belt may also be used for this step.

## Step 2 – Honing

Start with an 800x or 1000x stone to remove the marks from filing. Either an oil stone or water stone is suitable. Hold the blade as shown in **Figure 9** with the bevel flat against the stone. Stroke it back and forth, covering the whole stone. Check the bevel often to evaluate your progress. Continue until all file marks are gone. As shown in **Figure 10**, lap the face of the blade near the cutting edge to achieve the same finish as on the bevel. A sharp edge can only be achieved by creating two intersecting surfaces honed to the same degree. Using the same technique, transfer to a 4000x water stone or hard Arkansas oil stone to finish honing. A bench-top belt sander with 320x (40 $\mu$ ) followed by 1200x (9 $\mu$ ) abrasive belt will provide the same results a bit faster.



**Figure 9: Honing.**



**Figure 10: Lapping.**

## Care and Maintenance

The scraping blade comes treated with rust preventative. Remove this using a rag dampened with mineral spirits.

We recommend that you periodically apply a light coat of silicone-free paste wax or other corrosion inhibitor to protect the blade from rust. First wipe off any fingerprints with a cloth dampened with a small amount of light machine oil. Remove any residual oil, then apply a light wax coating, let dry, then buff with a clean soft cloth. At the same time, the solvents in the wax will remove any harmful oils left from your fingers that can lead to corrosion.

If storage conditions are damp or humid, your inlay string thicknesser should, in addition to the treatment outlined above, be wrapped in a cloth or stored in a plane sack. This precaution will also guard against dings and scratches.

The bright finish on the brass components can be maintained as above. If a patina finish is preferred, simply leave the brass components unprotected until the desired level of oxidation has occurred, then apply a sealant. If you want to make them bright and shiny again, you can revitalize the surface with a brass polish.

The rosewood handles have a lacquer finish and should require nothing more than a wipe with a clean cloth from time to time.

## Accessories

**05P32.06** Replacement Blade

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