



BLACKBURN

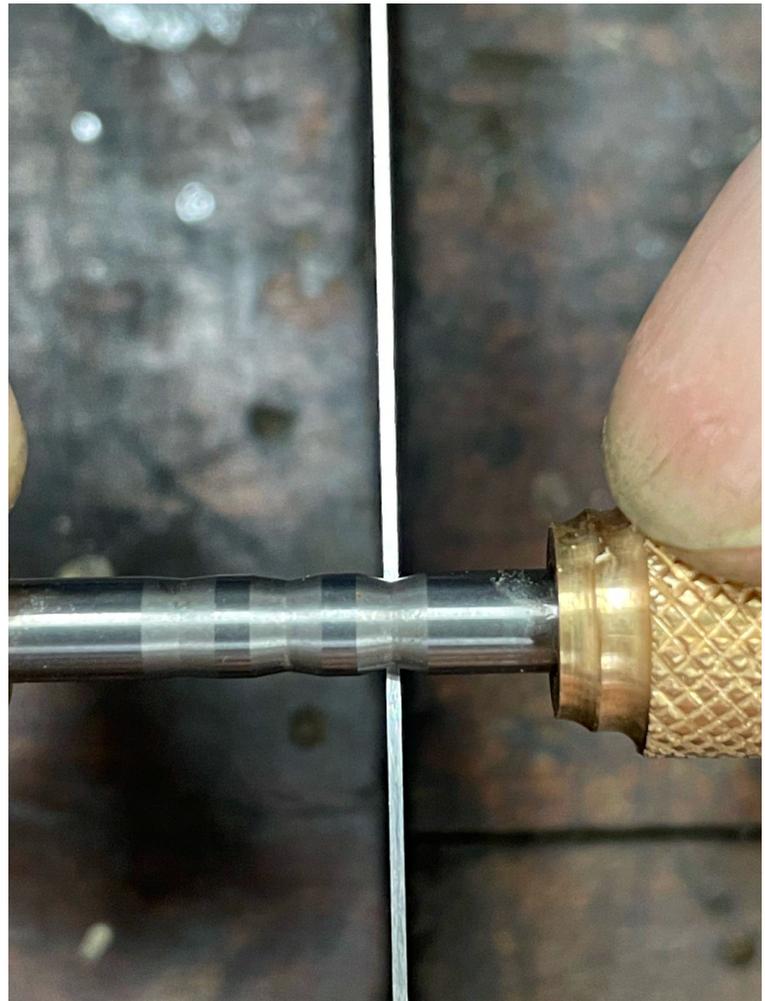


## Accu-Burr™ Carbide Burnisher Kit - Construction and Use

### INSTRUCTIONS FOR USE

Congratulations on your purchase of the Accu-Burr™ carbide burnisher kit. No burnisher gives better results with less effort. The heart of the Accu-Burr™ is a carbide rod of the highest quality available, precision ground on sophisticated machinery so that it forms a precise and repeatable burr simultaneously on both edges of a card scraper. It will work on any shape or hardness of scraper, with none of the drawbacks of conventional burnishers.

Hold your Accu-Burr™ carbide burnisher perpendicular to the prepared scraper edge and centered on either the fine, medium, or coarse groove (the deepest groove is for the coarse burr). Using a moderate downward force on the burnisher, draw it firmly and smoothly along the length of the prepared scraper edge (a drop of oil on the burnisher will make this action even smoother). This burnishing will raise a burr that can be barely felt with your finger; if no burr is felt, repeat as needed, but with increasing force, until a nearly imperceptible burr is formed along the entire length of the scraper.



# Tools Needed for Assembly (BU1 Kit Only)

- Wood Lathe or other shaping tools to shape handle.
- Drill, drill press or Lathe
- Vise to hold blank during boring operation.

## Materials Needed:

- 3/16" Brad Point Drill Bit
- Epoxy Resin and Hardener (Not Provided in the Kit)
- Sandpaper or other finishing implement
- Finish (We recommend Oil, Shellac and Wax)
- Shop Towels (CAUTION: Dispose of any rags that have finish or other oils on them in a fire safe container, as finish or oil soaked rags can spontaneously combust without warning.)

## CONSTRUCTION NOTES

Turn handle to desired shape. For your convenience, a suggested pattern and drawings are included on the following pages.

Turn the ferrule tenon to a 3/8" diameter. Adjust diameter as needed until the ferrule slides onto the tenon with little or no force.

Drill a 3/16" x 7/8" deep hole in the end of the ferrule tenon for the Accu-Burr™ carbide burnishing rod. Check the fit of the rod in the handle. This should also be a slip fit; if the fit is too tight, run the drill bit into the hole several more times to ream it out slightly.

Check the entire assembly with a dry fit; when assembled, the center of the middle groove should be 1/2" from the end of the ferrule (to allow room for excess epoxy, the rod should not be fully seated in the handle).

Clean the inside of the ferrule and the Accu-Burr™ carbide burnishing rod with acetone to remove any traces of oil. Apply epoxy to the interior of the ferrule and to the inside of the 3/16" hole in the handle.

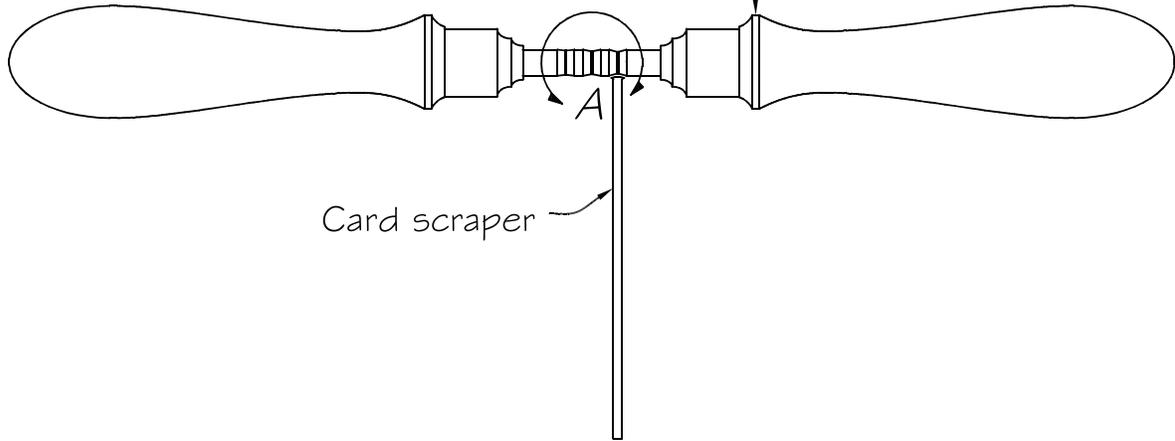
Press and twist the Accu-Burr™ carbide burnishing rod into the handle. Before the rod is fully seated, install the ferrule on the handle tenon, twisting to distribute the epoxy.

Push the Accu-Burr™ carbide burnishing rod into the handle until the center of the middle groove is 1/2" from the end of the ferrule. Clean up any excess epoxy with a rag and acetone. If needed, clamp the rod, ferrule, and handle until the epoxy dries (air pockets formed during assembly tend to separate the parts).

If you're building your Accu-Burr™ burnisher with only one handle, you're done. If you are using two handles, repeat steps 1-6 for the other handle and ferrule after the first glue-up has dried.



Accu-Burr™ carbide burnisher  
(PAT PEND)

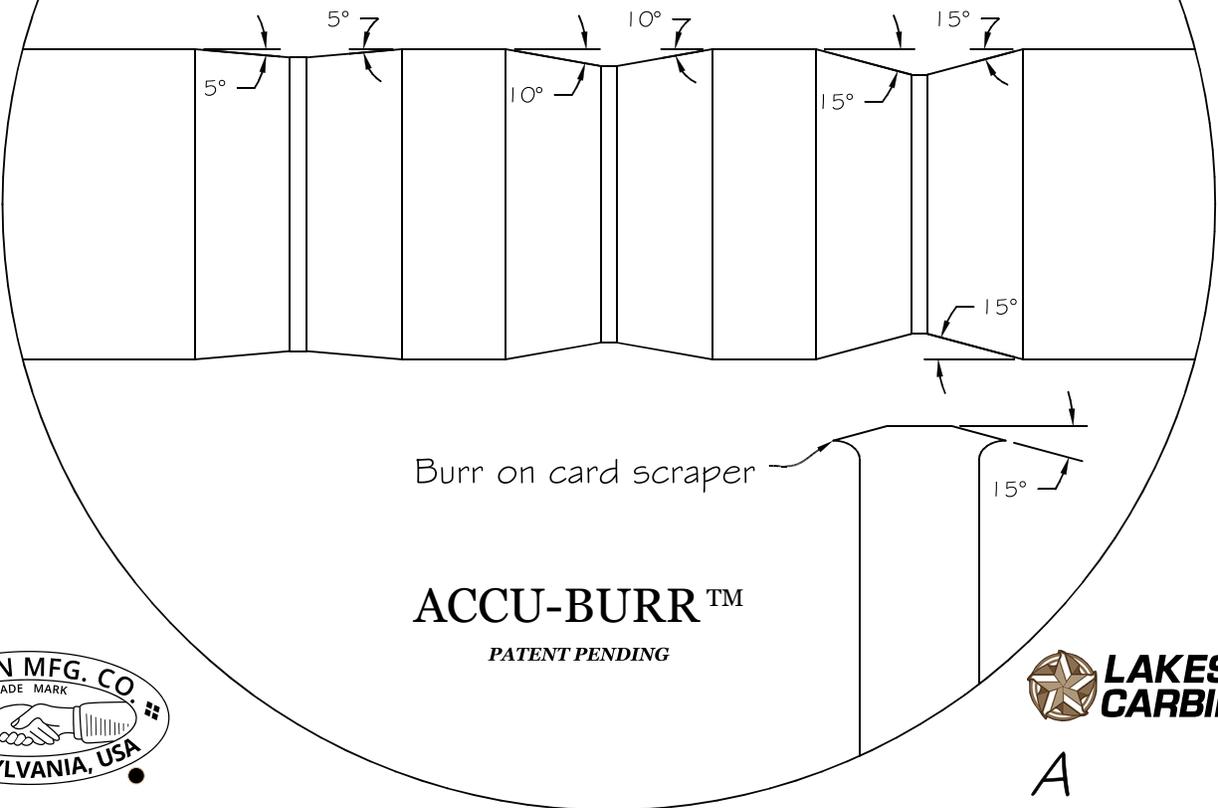


# BLACKBURN

Fine groove  
(5° burr)

Medium groove  
(10° burr)

Coarse groove  
(15° burr)



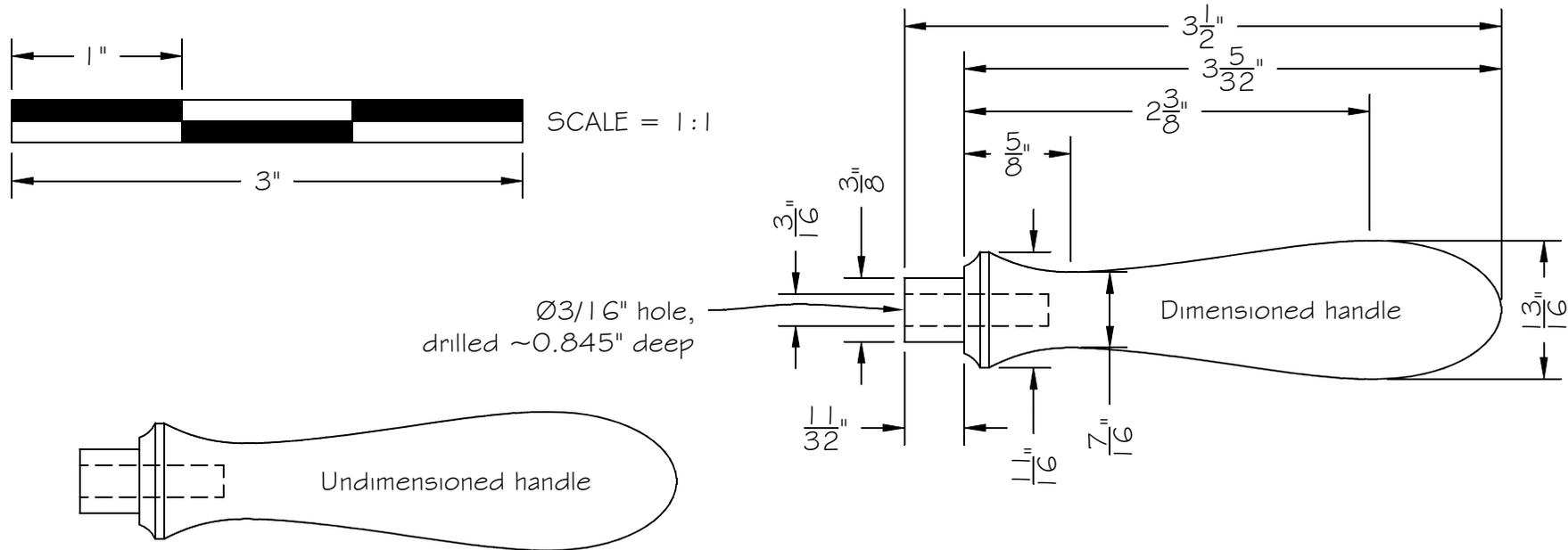
**ACCU-BURR™**

PATENT PENDING



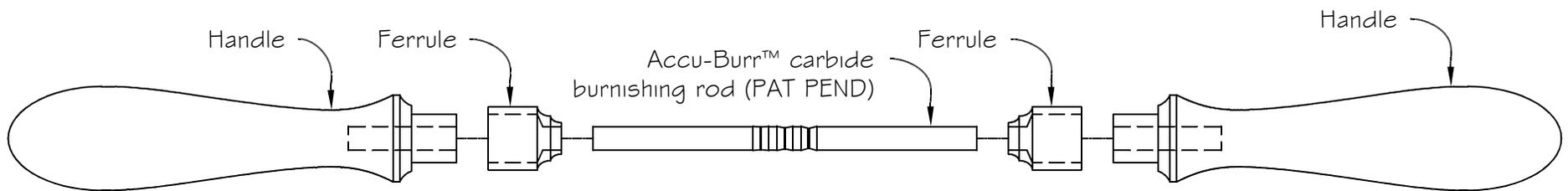
A

Revised 07.25.22



## ACCU-BURR™ BURNISHER HANDLE TEMPLATE

### ACCU-BURR™ BURNISHER EXPLODED ASSEMBLY (4:5 SCALE)



Date	2 August 2022	Scale	1:1 (Unless noted)
Notes	<p>© 2022, Isaac Smith. All rights reserved.          Authorized for personal use only; commercial use or redistribution is prohibited.</p> <p>BlackburnTools.com</p> <p>Page 1 of 1</p>		
<p>ISAAC SMITH          PO BOX 263          UNIONVILLE, PA 19375          BlackburnTools.com</p>		Title	
		Accu-Burr™ burnisher (PAT PEND) handle template	