

HOCK Scratch Stock Instructions

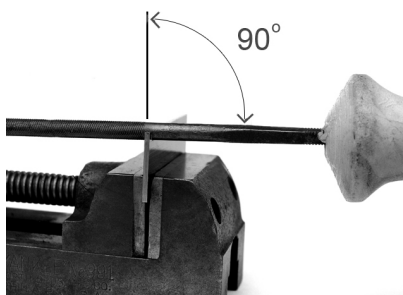
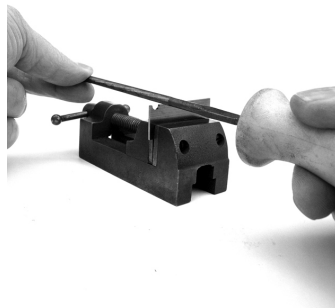
View the Video at HOCKTOOLS.com



The Scratch Stock is an old tool dating back centuries to a time when furniture was made one piece at a time in the workshops of master craftsmen. It was used to shape edge profiles, cut grooves for inlaid stringing, and many other such detailed tasks. Although the Scratch Stock

has become less familiar since the advent of modern router technology, it still holds an important place in the tool chest of the well-equipped woodworker. Its versatility, ease of setup and control, and ability to access difficult areas make the Scratch Stock especially useful in the repair, restoration and reproduction of antique furniture.

Making new cutters for your Scratch Stock is not difficult and takes only a few minutes. Begin by drawing the desired profile on the spring steel blank using a fine-point permanent marker or machinist's layout dye. Clamp the blank in a vise and use fine-toothed files to remove the bulk of the waste. Parts of the profile that are straight can be cut with rectangular, square, or triangular files. Radius sections require a round file. Common rat-tail round files are tapered and do *not* work well. Instead, use chainsaw files, which are parallel-sided, have fine teeth, and are available in a wide variety of sizes. Dremel-type hand grinders can also come in handy here.



When the rough shaping is complete, you are ready to make the final cuts. Use a light touch and be sure to keep the file perpendicular to the face of the blank. The goal is to file the edge at 90° to the face. When you are satisfied with the shape, polish the edge

with a hard Arkansas or other fine slipstone. When you are done with the edge, polish *both* faces to remove any burr that has formed, to improve the quality of your cut.

When you are satisfied with your cutter, insert it into the body in one of the two slots. The slot cut *perpendicular* to the body is for working along straight or convex edges. Place the cutter in the slot and tighten the screw to secure it. Only light pressure is necessary to secure the cut-

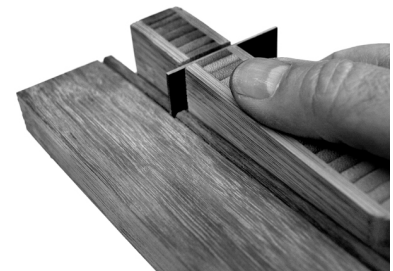
ter. Depending on the situation, the working part of the cutter can project from either side of the body. The slot running the *length* of the body is for following concave edges. Place the cutter in the slot so that it extends out of the rounded end then tighten the screw. Again, use only light pressure. Excessive tightening may strip



the threads or damage the body. Do *not* loosen the black socket-head screws in the body. These screws strengthen the body against splitting and are not meant to be adjusted.

The Scratch Stock cutter scrapes away wood, while the body

acts as a fence to guide the cut parallel to the edge. The tool can be pushed if necessary, but pulling will provide a much more satisfactory cut. For best results, take light cuts, holding the cutter at 90° to the surface of the wood. A properly tuned Scratch Stock should produce light, fluffy shavings similar to those made by a card scraper. When it no longer produces shavings, the cutter should be re-sharpened.



For cuts that need to be stopped at a specific depth, a small stop block can be attached to the face of the cutter with double-stick tape above the cutting edge. When full depth of cut is reached the block will come into contact with the wood, preventing further removal of wood.

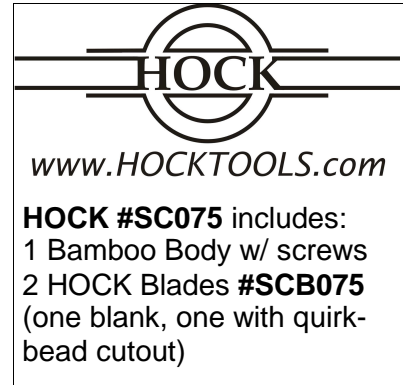
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www.HOCKTOOLS.com

HOCK #SC075 includes:

- 1 Bamboo Body w/ screws
- 2 HOCK Blades #SCB075 (one blank, one with quirk-bead cutout)