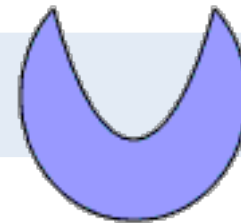


What is wrong with my bowl  
gouge?

Why does it seem to work different  
than that one?

# A Little History

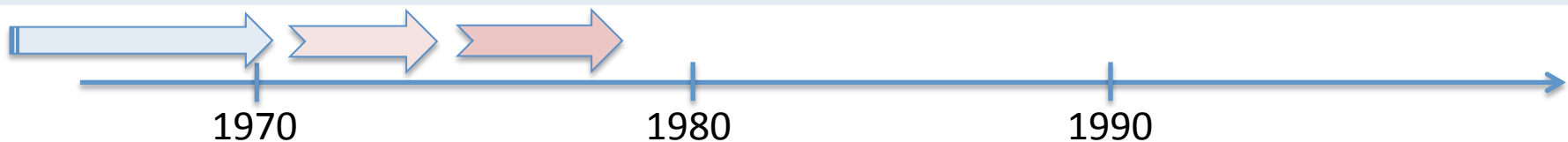
- The first commercial “bowl gouge” was likely made by Peter Child & Son in the UK in the mid 70’s as what they called the “long and strong bowl gouge”.
- Made from heat treated carbon steel rods with the flutes milled out rather than forged.
- Tool was attached to a longer handle to improve control.
- The flute was milled in this shape



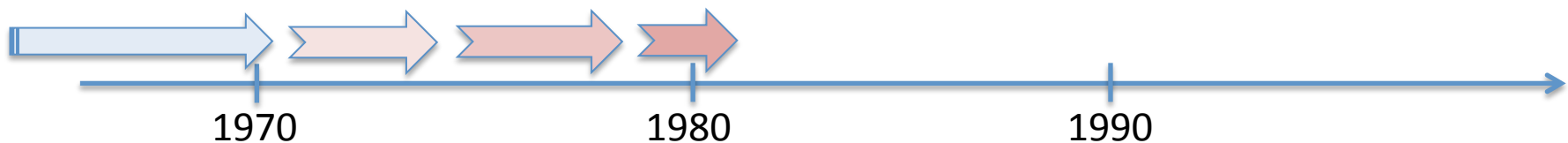
- In Europe, Henry Taylor took the tools and started making them out of 5/8" M2 High Speed Steel rods in Sheffield, England in the late 70's.

- They called their tool the "Superflute".
- The tool initially came ground like a roughing gouge, square across the nose.

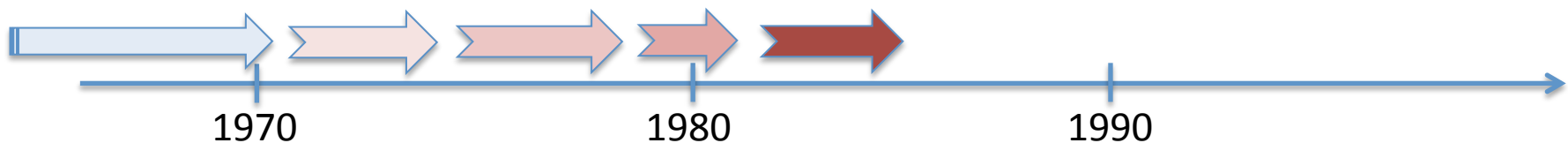
- Many manufacturers started making similar gouges, as milling the flute was cheaper than forging it.



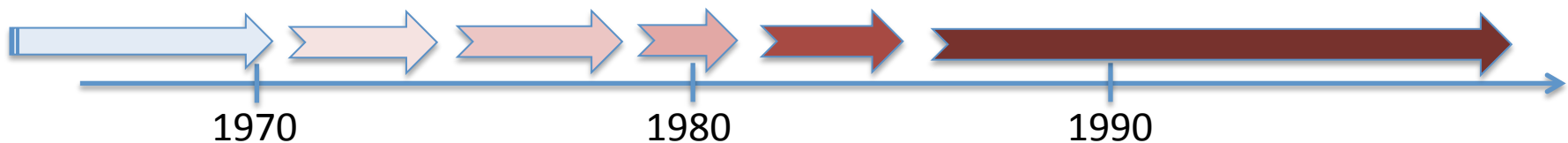
- So the basic bowl gouge was now manufactured and available from several suppliers around the world. One was an American turner named Jerry Glaser.
- The milled flute shapes between manufacturers were slightly different as each tried to make “the” tool.
- Those early English tools, through stronger and easier to control when hollowing bowls, they were awkward to use due to the nose shape.



- It did not take long for turners to start to grind back the ears at the top of the flutes to have a more versatile tool.
- Some of the earliest demo's using the new "long grind" bowl gouges were by the Irish woodturners in the early 80's (ie. Liam Oneill), though others had likely been using similar ground tool in their shops.



- Jerry Glaser was an aviation engineer & tool maker and one of the early producers of powdered metal tools in the early 80's.
- He had started using a higher quality, longer wearing tool steel to make deep fluted gouges after working with Bob Stockdale on a few other turning tools.
- He initially provided wooden handles on his tools, but changed to a multisided hollow aluminum handles that would allow lead shot to be added to dampen the tool vibration.
- Since then, more companies have started producing similar powdered metal tools as well as hollow metal handles.



- Bowl gouges today are milled from bars of molybdenum based High Speed Steel (HSS)
  - M2 (heat treating makes the difference)
  - M4 (6% Tungsten & 4% Vanadium added)
  - ASP2030 (6.5% Tungsten & 8.5% Cobalt added)
  - M42 (2% Tungsten & 8% Cobalt added)
  - ASP2060 (7% Tungsten & 10.5% Cobalt added)
- Tools steels
  - AISI A11 / CPM10V (10% Vanadium added)
  - CPM15V (15% Vanadium added)

- To sharpen your gouges...

Metal	Wheel matrix
M2 M4	Aluminum Oxide ( I / J / K ) - White / Pink / Blue
ASP2030 M42 ASP2060 AISI A11 / CPM10V CPM15V	Silicon carbide (sanding belts) Ceramic Aluminum Oxide Diamond Cubic boron nitride (CBN)



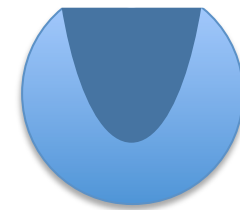
- Some of the flute shapes



DICTUM



Cross-section



- A variety of grinds





70°-80°

Scrapers



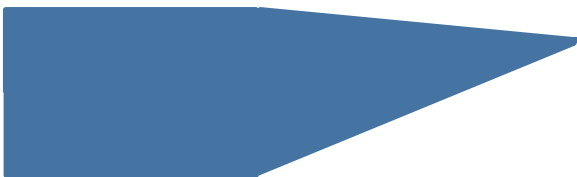
40°-65°

Bowl gouges



35°-50°

Detail gouges



30°-40°

Spindle gouges

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