

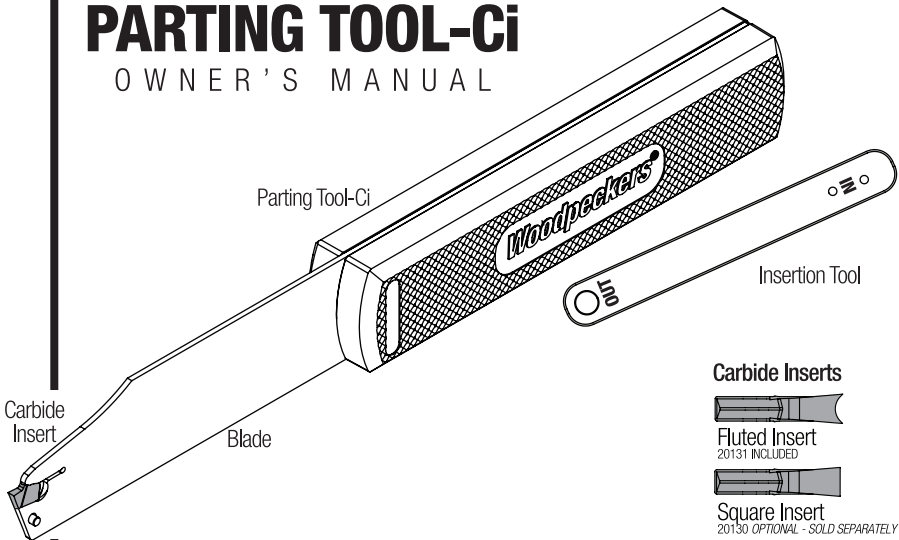
# ULTRA·SHEAR™

WOODTURNING TOOLS

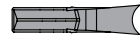
by **Woodpeckers®**

## PARTING TOOL-Ci

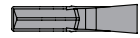
OWNER'S MANUAL



### Carbide Inserts



Fluted Insert  
20131 INCLUDED



Square Insert  
20130 OPTIONAL - SOLD SEPARATELY

If you think you're missing anything, email us at [mailroom@woodpeck.com](mailto:mailroom@woodpeck.com).  
You can also call us at 800-752-0725 from 9:00 a.m. to 5:00 p.m. EST Monday - Friday.

## ALSO AVAILABLE FROM **ULTRA·SHEAR™**

WOODTURNING TOOLS  
by **Woodpeckers®**

### WOODTURNING TOOL PRODUCT LISTING

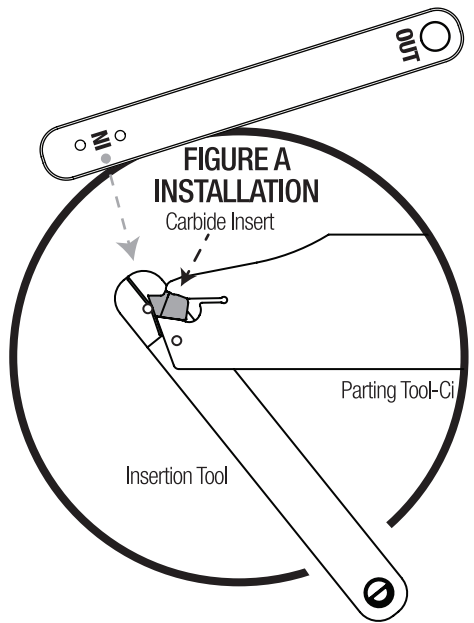
- FSS** *ULTRA·SHEAR Full Size Square*  
Uses Tips 20121, 20122 & 20123
- FSR** *ULTRA·SHEAR Full Size Round*  
Uses Tips 20124
- FSD** *ULTRA·SHEAR Full Size Detail*  
Uses Tips 20128 & 20129
- MSS** *ULTRA·SHEAR Mid Size Square*  
Uses Tips 20125, 20122 & 20123
- MSR** *ULTRA·SHEAR Mid Size Round*  
Uses Tips 20124
- MSD** *ULTRA·SHEAR Mid Size Detail*  
Uses Tips 20128 & 20129
- PSS** *ULTRA·SHEAR Pen Size Square*  
Uses Tips 20125 & 20126
- PSR** *ULTRA·SHEAR Pen Size Round*  
Uses Tips 20127
- PSD** *ULTRA·SHEAR Pen Size Detail*  
Uses Tips 20128 & 20129
- PT** *ULTRA·SHEAR Parting Tool-Ci*  
Uses Tips 20131 & 20130

### CARBIDE INSERTS PRODUCT LISTING

- 20121 ■ .59" Square Insert Tip
- 20122 ■ .59" Square Insert - 2" Radius Tip
- 20123 ■ .59" Square Insert - 4" Radius Tip
- 20124 ● .63" Round Insert Tip
- 20125 ■ .44" Square Insert Tip
- 20126 ■ .44" Square Insert - 2" Radius Tip
- 20127 ● .46" Round Insert Tip
- 20128 ◆ Universal Detail Insert - Radius Tip
- 20129 ◆ Universal Detail Insert - Sharp Tip
- 20131 ■ Parting Tool-Ci Fluted Insert
- 20130 ■ Parting Tool-Ci Square Insert

## INSTALLING A CARBIDE INSERT BLADE

1. Holding the Parting Tool-Ci handle in your left hand, place the carbide insert loosely in the end of the Parting Tool blade, centered in the width of the blade.
2. Using your right hand, insert the pivot pin on the Insertion Tool thru the hole in the tip of the tool. **FIGURE A.**
3. Rotate the handle down to push on the heel of the carbide insert with the installation tool. The insert should slightly “snap” into place.
4. Do not over-insert the tool as damage may occur to either the parting tool blade or the installation tool.
5. Properly installed, the bottom heel of the carbide insert should be just slightly proud of the blade pocket.



## REMOVING A CARBIDE INSERT BLADE

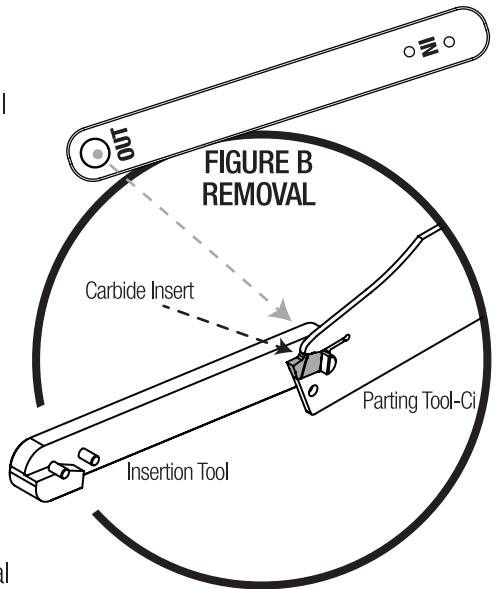
1. Insert the “D” shaped pin on the “OUT” end of the Insertion Tool behind the carbide insert. **FIGURE B.**

**NOTE:** If the space behind the insert is too small to allow this pin to fit, the carbide insert is slightly over-installed. Adjust your installation force accordingly.

2. Cover the carbide insert with your thumb during removal to prevent loss. Rotate the Insertion Tool up or down to remove the insert.

## USING THE PARTING-TOOL-Ci

1. Adjust the tool rest to bring the tip of the carbide insert level with the center of your workpiece.
2. The Parting Tool-Ci can either be held parallel and level to the centerline during the entire cut or, it may be used in a more traditional “ride the bevel” path at the start of the cut.



# Woodpeckers®

PRECISION WOODWORKING TOOLS

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**WARNING!** This product can expose you to chemicals, including chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)