

Jim McLain Woodturning
Stone Wave Hollow Forms
November 4, 2017

The following is a rough guide on the steps I take to make these pieces.

1. These pieces can be made from a variety of woods but the burnt pieces I make are typically made from Ash.
2. I prefer to use logs that are fairly uniform round because once the log is cut in half and the piece is turned similar to a natural edge bowl where you are trying to balance the piece the wave flows across the piece very consistently.
3. Once the piece is rough turned and dried it should be returned and hallowed to about a one half of an inch wall thickness. It should be sanded inside and out. Be sure to do a good job sanding because any problem areas will show up even more when you burn the piece. The piece should also be reversed and the bottom turned to a final shape.
4. Once sanded the lines for the carving should be drawn on the piece following the growth rings of the wood. I try to balance the amount of stone above and below the shoulder of the piece but try and pick an area where the growth ring is fairly consistent top and bottom. The higher you go up on the piece the wider the growth rings will get near the top of the opening.



5. Once you have drawn the lines on the piece you need to establish the margins of the carving. On burnt pieces I do this by burning a line following the middle of the grown ring. On pieces that are not going to

be burnt I carve in a groove with a tri tipped v carver. Doing this step helps prevent tear out into the non carved area when the groove is carved.



6. Once the lines are burnt in or carved in, it is time to carve the actual groove. I do this with a square tipped tri tipped carbide cutter from rotarychisel.com. (Creative Technologies Inc). This is a very aggressive cutter and it can get away from you so be careful.



7. Carving with this tri tipped carbide cutter is very rough and will need some cleanup. It can be done with a number of different burrs in a Foredom type carver as shown above but I prefer an air turbine like the Vortex F5 shown above with a 702 bit. The Vortex gives you far more control than most other burrs. Part of the clean up should include a slight bevel at the top of the groove so that the edge is not too square or fine. Leaving it too fine or square will cause the wood to burn too much in this area.
8. The next step is the actual burning process. I prefer to burn with a standard propane torch. This type of torch does not burn as hot as other torches. I try to burn the whole piece lightly and then let it cool to the touch and then burn the entire piece more aggressively the second time. My rationale is that the initial burning helps relieve some of the tension in the wood and might help prevent cracking when the piece is burnt the second time.



9. These pieces will crack during the burning process so be prepared to come up with some way to fill the crack. The following picture shows

about how much burning has been done to a completed piece.



10. The next step in the process is to stain the piece inside and out including the groove. This can be done with any type of black stain. I have used solar-lux for all of the pieces I have done do date but Transtint dyes would work fine as well as possibly india ink.



11. Once dry I like to seal the wood with a coat of Waterlox prior to inlaying the stones. This step could also be done with lacquer sanding sealer or shellac. This step helps with superglue removal if you get a drop or two where you do not want it. Let the sealer dry then you can start inlaying the stones. I pick a small area and line up four to six stones then drip the super glue over the stones just enough to set the stones and spray with an accelerator. I continue doing this until the entire groove is filled with stones. Be sure not to get too much superglue in any one area because it can run and make a mess where you do not want it. I use Starbond glue and accelerator.



12. Once all the stones have been inlayed, I spray the piece with Deft Satin using a rattle can.