

**Specifications:** All surfaces are to be machined smooth and true, as indicated in the drawing.  
**Material:** 1 lb. of round cold-rolled steel bar stock.  
**Turning Spindle:** 1200 r.p.m.  
**Feeds:** As noted.  
**Tools:** Round tool, two flats turning tool,  $\frac{1}{16}$  in. drill and holder.  
 $\frac{1}{16}$  in. reamer and holder, smoothing tool, draw and round tool.  
**Note:** Make tool layout similar to Fig. 260 before proceeding with machine setup.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Put bar in jaws of lathe.		See Fig. 259
2. Set up lathe and start rotation.		See details, page 487
3. Turn smooth to size.	Round tool.	
4. Turn smooth to size.	Smoothing tool.	
5. Drill.	Turning tool.	See Fig. 260
6. Ream.	$\frac{1}{16}$ in. drill and holder.	See details, page 487
7. Smooth.	Reamer, reamer and holder.	
8. Turn end and set off.	Draw and round tool.	See Fig. 260

DETAILS OF OPERATION

See details of Problem 15 for general machine setup.  
 The spindle needs in Problem 15 and the tool employed in this problem should be assembled as shown in Fig. 261 and the



FIG. 261—Complete gear gear.

end of the spindle should rest. The end should then be the smooth and polished on a speed lathe. The assembly becomes a part of the paper gear made in Problem 15.

Problem 16  
 MAKE GEAR BLANK

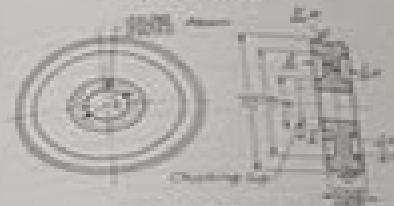


FIG. 262—Gear blank.

**Note:** The blank is to be made gear blank to dimensions shown in Fig. 262 on a turning lathe.  
**Specifications:** All surfaces are to be smooth. There must be square with axis of hole, and outside edge must be perpendicular with center hole.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Turn blank on chucking lat.	Turning tool.	
2. Turn hole.	Turning tool.	
3. Turn hole.	$\frac{1}{16}$ in. drill and holder.	See Fig. 262
4. Drill.	Reamer.	
5. Smooth.	$\frac{1}{16}$ in. reamer and holder.	
6. Turn smooth.	Turning tool.	
7. Turn smooth.	Draw tool.	
8. Turn smooth and round edges.	Draw tool.	
9. Round on outside, using with ring being shown.	Auto stop.	See details
10. Turn end and set off chucking lat.	Turning tool.	
11. Turn gear on lathe.	Turning tool.	

# Machine Tool Work Fundamental Princi 2nd Edition

**ML Yell**



**Machine Tool Work Fundamental Princi 2nd Edition:**

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