

Specifications: All surfaces are to be machined smooth and true.

Material: $\frac{1}{2}$ lb. round cold-rolled steel bar stock.

Turning Spindle: 1200 g.m.

Feeder: 30 in.

Tools: Round steel bar stock turning tool, $\frac{1}{2}$ in. dia. and holder.

Notes: 1. In machine and holder, mounting tool down and out of tool. 2. Make tool holder similar to Fig. 260 before proceeding with machine setup.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Put bar in jaws of machine.		See Fig. 259
2. Set up machine and adjust stops.		See details, page 48
3. Feed stock to stop.	Round steel bar stock turning tool.	
4. Round.	Turning tool.	
5. Round down.	Turning tool.	See Fig. 260
6. Drill.	Drill, drill bit, and holder.	See details, page 48
7. Bore.	Reamer, reamer and holder.	
8. Turn tool and set off.	Turn tool and small tool.	See Fig. 260

DETAILS OF OPERATION

See details of Problem 18 for general machine setup.

The spindle made in Problem 18 and the tool holder made in this problem should be assembled as shown in Fig. 259 and the



Fig. 259—Spindle and tool holder.

end of the spindle should rest. The end should then be fed smoothly and polished on a speed lathe. The assembly becomes a part of the paper punch made in Problem 14.

Problem 21 ROUND IRON BLANK

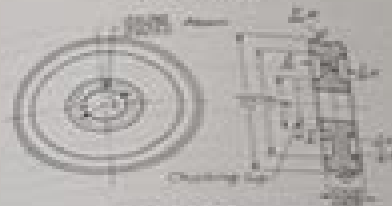


Fig. 260—Round iron blank.

Notes: 1. The blank is to be turned down to the diameter shown in Fig. 260 on a speed lathe.

Specifications: All surfaces are to be smooth. There must be square ends on all tools, and outside edge must be continuous with center hole.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Turn blank on chucking lat.	Turning tool.	
2. Turn down.	Turning tool.	
3. Turn.	Turning tool.	See Fig. 260
4. Drill.	Drill, drill bit, and holder.	
5. Bore.	Reamer, reamer and holder.	
6. Turn down.	Turning tool.	
7. Turn down.	Turning tool.	
8. Turn down.	Turning tool.	
9. Turn down.	Turning tool.	
10. Turn down.	Turning tool.	
11. Turn down.	Turning tool.	
12. Turn down.	Turning tool.	

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