

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: By hand.

Tools: Round tool, two flats turning tool, $\frac{1}{16}$ in. drill and holder.

Note: $\frac{1}{16}$ in. round end holder, mounting tool drive and chuck tool.

Make: Make tool holder similar to Fig. 260 before proceeding with machine setup.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Put bar in jaws of chuck.		See Fig. 259
2. Set up machine and adjust speeds.		See details, page 48
3. Turn smooth to size.	Round tool.	
4. Turn flats.	Flats turning tool.	
5. Round smooth.	$\frac{1}{16}$ in. drill and holder.	See Fig. 260
6. Drill.	Drill.	See details, page 48
7. Round.	Round smooth tool.	
8. Turn tool and set off.	Turn tool and round 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 completed 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 the smooth and polished on a speed lathe. The assembly becomes a part of the paper punch made in Problem 14.

Problem 21 ROUND IRON BLANK

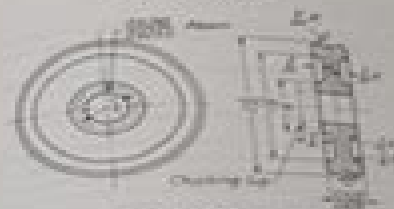


FIG. 260—Round iron blank.

Note: The blank is round iron blank to dimensions shown in Fig. 260 on a round lathe.

Specifications: All surfaces are to be smooth. There must be square with axis of hole, and outside edge must be continuous with round hole.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Turn blank on chucking lat.	Turning tool.	
2. Turn size.	Turning tool.	
3. Turn.	$\frac{1}{16}$ in. drill and holder.	See Fig. 260
4. Drill.	Drill.	
5. Round.	$\frac{1}{16}$ in. round and holder.	
6. Turn smooth.	Turning tool.	
7. Turn smooth to size.	Turn tool.	
8. Turn smooth and round edges.	Turn tool.	
9. Round on smooth, using with ring being shown.	Auto stop.	See details
10. Turn end and set off chucking lat.	Turning tool.	
11. Turn groove to form.	Turning tool.	

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