

and its hole are kept clean, a tapered center rarely runs perfectly true on the point. When a job requires accuracy, this center must be turned up true each time it is set in the handstock spindle; consequently the life of such centers is very short.

If a lathe-center spindle is available, the center can be made hard and ground true instead of turning it. It is necessary to keep a hard center for the handstock and use it on jobs that do not require great accuracy.

Turning a Large Cone

A method of turning a large cone on a lathe is shown in the illustration. A short portion of the proper shape, is first turned at the apex of the cone with the compound rest set to the required angle. The rest is then taken from the cross-bed



arrow, allowing the slide rest to move freely. The lathe tool, carrying the angle, is then moved along with the cutting tool. The action of the rest on the turned surface causes the tool to move in a straight line, but making an angle with the axis of the rest.—Contributed by James H. Rodgers, Hamilton, Ont.

A Lathe Kink

It is usually found convenient to keep the compound rest of a lathe set at an angle of 30° to the cross slide. In reducing the length of a piece being turned, advantage may be taken of this position, as it affords a simple means of accurately gauging the rest. At the 30° setting, holding in the compound rest a certain distance gives the tool a longitudinal movement of exactly half that amount. For instance, if the work is found to be .010 in. too long, lock the carriage, bring the rest up against the end of the work with the compound rest, withdraw the cross slide, set the compound rest to .010 in., and the tool is in position to face the work to exact length.—J. Roman, San Francisco, Calif.

Protecting Slaves for a Tailstock Center

Great accuracy is usually required in grinding machine work. The centers of the machine and the center holes of the work must therefore be carefully guarded in order not to rack or bruise them in any way. By means of the protecting sleeve illustrated this difficulty is overcome.

The sleeve is made to fit the machine center snugly, and turned out to fit the work to be ground approximately allowing a slight clearance all around the cir-

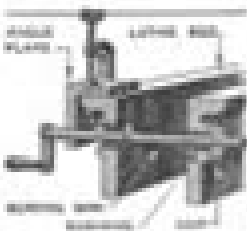


Protecting Sleeve for the Tailstock Center in Power Grinding Wheel True Running.

cumference. In order to insure true centering, the inner edges of the sleeve are made slightly rounded. This guides the work to its running position safely and rapidly, avoiding the painstaking centering operation otherwise necessary. One side of the sleeve must be cut away sufficiently to allow the grinding wheel to pass when running off of the work.

Reboring a Turret-Lathe Bed

The drawing shows a simple method of reboring a turret-lathe bed, when it is not convenient to move the part to a machine shop for reboring.



A single plate, with a hole drilled through one side, is used as one bearing for the boring bar, and supported to the lathe bed as indicated.

A bearing in the hole in the opposite side of the lathe bed serves as the other bearing. The bar itself has a fine thread on one end, and a nut is used to hold it.

When the revolving work is slathered, as is to destroy the flatness of the cut, the machine sometimes can be prevented by placing a wall of waste between the arm of the lathe dog and the side of the lathe plate cut.

Ball-Turning Tool for Small Lathes

Upon obtaining an order to make some ball-head lathes for automobile driving handles, I devised the toolholder shown in the drawing, for use on a small lathe.

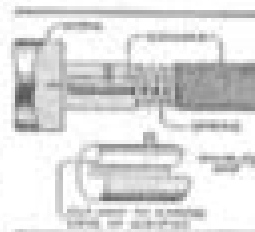


Ball-Turning Tool That Produces True Ball Points. It Can Be Adapted to Any Small Lathe.

A piece of cast iron was bolted to the cross slide and bored, at the exact height of the lathe centers, for a stud. This forms the toolpost. The toolholder is shaped, as shown, at machine shop, fitted with a pin for a cap screw, and a square hole, broached at an angle, for the tool bit. The toolholder slides in the slot in the stud, which is rotated by the lever pinned to the rest rest. Adjustment is effected by moving either toolholder or tool.—H. Hugo-Dreyer, Oudart, Belgium.

Scraper for Truing Center Holes

It sometimes happens that a piece of shafting, or other cylindrical work being turned in the lathe, will not run true, because the center hole is not exactly parallel with the longitudinal axis of the work. When this occurs, it is a common practice to true the center, with a hand scraper, until the work runs true. It is, however, almost impossible to keep the end of the center hole at the correct angle while scraping, and it not infrequently happens that, while the work runs true for a time, it is slowly running on one of two high spots in the center hole, and, when these wear down, the work will "run out" again.

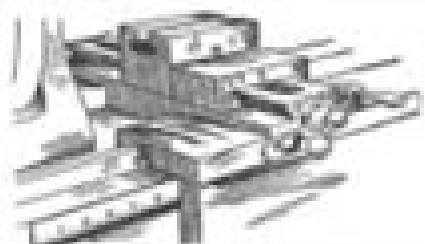


The scraper shown in the drawing compels the operator to scrape always at the same angle. It is made in two parts; the scraper proper is provided with a knurled grip, the opposite end being tapered down for a few inches, and machined at a 60° angle; these flutes are cut in it, and two of the lands thus produced rounded off, so as to leave only one cutting edge. Over the cutting end of the scraper slides a sleeve, tapered for a screw that bears on a flat nut on the scraper; between sleeve and scraper grip a light coil spring is placed, and a corner of the sleeve is set away so as to expose the cutting edge, thus enabling the operator to observe how much metal the scraper is removing.

In use, the work is placed between centers, the high spot marked, and, on that side of the center hole is the one to be scraped, the cutting edge of the scraper is placed on that side, and the scraper pushed in and rotated until the desired result is obtained.

Guide for Longitudinal Lathe Feed

An ordinary 12-in. flexible-wood scale fastened to the bed of a lathe makes a good guide for the longitudinal feed.



Steel Guide Fastened to a Lathe Bed, to Facilitate a Guide for the Longitudinal Feed.

This is a very handy device for roughing out work and is easily applied. In one case, I have placed the scale on the front of the bed, and the carriage passes over it, but it can be placed on top of the bed if desired.—A. E. Holiday, Union City, Connecticut.

Beveling and Chamfering Tool for a Lathe

A simple little tool which is very efficient within its range is shown in the illustration. The tool is designed to be carried in the machinist's tool chest as a part of his equipment. This tool is to take the place of the compound rest on

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