

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

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

Turning Spindle: 1.000 g.m.

Feeder: 30 in.

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

Note: $\frac{1}{16}$ in. round and holder, turning tool, flats and round tool. Make tool holder similar to Fig. 280 before proceeding with machine setup.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Put bar in jaws of chuck.		See 280
2. Set up machine and adjust stops.		See 280
3. Turn smooth to size.	Round tool.	See 280
4. Turn flats.	Turning tool.	See 280
5. Turn smooth.	Round tool.	See 280
6. Drill.	$\frac{1}{16}$ in. drill and holder.	See 280
7. Bore.	Flats, round and flats.	See 280
8. Turn tool and set off.	Flats and round tool.	See 280

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. 282 and the



FIG. 282—Spindle and tool holder.

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

Problem 21 ROUND IRON BLANK

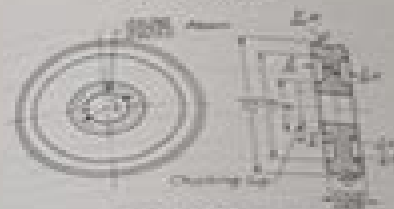


FIG. 281—Round iron blank.

Note: The blank is round iron blank to dimensions shown in Fig. 281 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 hole.	Turning tool.	
3. Turn hole.	$\frac{1}{16}$ in. drill and holder.	See 280
4. Drill.	Holder.	
5. Bore.	Flats, round and flats.	
6. Turn smooth.	Turning tool.	
7. Turn smooth to size.	Round tool.	
8. Turn smooth and bore.	Round tool.	
9. Turn smooth to size, using stop.	Round tool.	
10. Turn end and set off chucking lat.	Turning tool.	
11. Turn smooth to size.	Turning tool.	

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reason and science might offer in major events of human lives he argues that ideas about the soul and the afterlife of sin and
god s purpose have shaped human thinking for thousands of years 1

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