

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

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

Turning Spindle: 1200 r.p.m.

Feeds: .015 in.

Tools: Single flute tool from turning tool, $\frac{1}{16}$ in. dia. and holder.

Set: $\frac{1}{16}$ in. square and holder, turning tool from and holder, lathe.

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

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Put bar in jaws of lathe.		See Fig. 260
2. Set up lathe and start lathe.		See Fig. 260
3. Turn end to size.	Turning tool.	See Fig. 260
4. Turn end to size.	Turning tool.	See Fig. 260
5. Turn end to size.	Turning tool.	See Fig. 260
6. Turn end to size.	Turning tool.	See Fig. 260
7. Turn end to size.	Turning tool.	See Fig. 260
8. Turn end and set off.	Turning tool.	See Fig. 260

DETAILS OF OPERATION

See details of Problem 18 for general machine setup.

The spindle must be machined in Problem 18 and the tool holder must be machined in Problem 18 and the



Fig. 260—Turning paper punch.

end of the spindle must be machined. 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 18.

Problem 19 TURNING TOOL

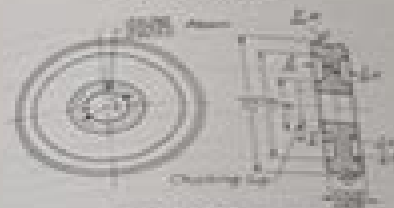


Fig. 261—Turning paper punch.

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

Material: $\frac{1}{2}$ lb. round cold-rolled steel bar stock. **Feeds:** .015 in.

SEQUENCE OF OPERATIONS

Operation	Tools	Reference
1. Turn end to size.	Turning tool.	See Fig. 261
2. Turn end to size.	Turning tool.	See Fig. 261
3. Turn end to size.	Turning tool.	See Fig. 261
4. Turn end to size.	Turning tool.	See Fig. 261
5. Turn end to size.	Turning tool.	See Fig. 261
6. Turn end to size.	Turning tool.	See Fig. 261
7. Turn end to size.	Turning tool.	See Fig. 261
8. Turn end to size.	Turning tool.	See Fig. 261
9. Turn end to size.	Turning tool.	See Fig. 261
10. Turn end to size.	Turning tool.	See Fig. 261
11. Turn end to size.	Turning tool.	See Fig. 261
12. Turn end to size.	Turning tool.	See Fig. 261

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 - The Rise of Digital Reading Machine Tool Work Fundamental Princi 2nd Edition
 - Advantages of eBooks Over Traditional Books
2. Identifying Machine Tool Work Fundamental Princi 2nd Edition
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Machine Tool Work Fundamental Princi 2nd Edition
 - User-Friendly Interface
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 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Machine Tool Work Fundamental Princi 2nd Edition
9. Balancing eBooks and Physical Books Machine Tool Work Fundamental Princi 2nd Edition
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Machine Tool Work Fundamental Princi 2nd Edition
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Machine Tool Work Fundamental Princi 2nd Edition
 - Setting Reading Goals Machine Tool Work Fundamental Princi 2nd Edition
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Machine Tool Work Fundamental Princi 2nd Edition
 - Fact-Checking eBook Content of Machine Tool Work Fundamental Princi 2nd Edition
 - Distinguishing Credible Sources
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- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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