



# **A treatise on lathes and turning; simple, mechanical and ornamental**

*W. Henry Northcott*

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This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1876 Excerpt: ...show the reader that it is simply a straight bar of metal--generally steel. It is centred at the ends like a mandril, and has two or three slot holes cut through it to receive various shaped cutters; these cutters are fastened in place by a small wedge driven in the slot at the back of the cutter precisely the same as at Fig. 117. Several cutters are shown in the bar, to give the reader an idea of the manner in which each sort is fastened in proper place for use. The cutters used in this bar have only two cutting points--frequently only one--but for large holes a stouter bar is used, and the cutters are more numerous, being 4, 6, 8, or any higher number according to the size of the hole. They are arranged round a boss which can be keyed to the bar in any convenient part of its length; the cutters are fastened to this boss by being wedged in a dovetailed groove. This instrument is driven in the lathe in the same manner as the last. Frequently, every alternate groove of the cutter boss is fitted with a piece of hard wood, which, bearing against the side of the hole, steadies the bar, and, by preventing vibration, causes a better hole to be made than when all the grooves are fitted with cutters. When either of these instruments is used, the work through which the hole is to be bored is fastened to the receiving plate of the slide-rest by bolts, or by any other convenient means, and so that the axis of the required hole shall coincide with the line of lathecentres. The work must of course have a rough hole through it to allow the boring bar to be put in place. The cutter is then set to take the proper depth of cut, and the lathe being set in motion and the handle depressed, the leading screw will carry the work forward against the rotating cutters, and the ho...

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