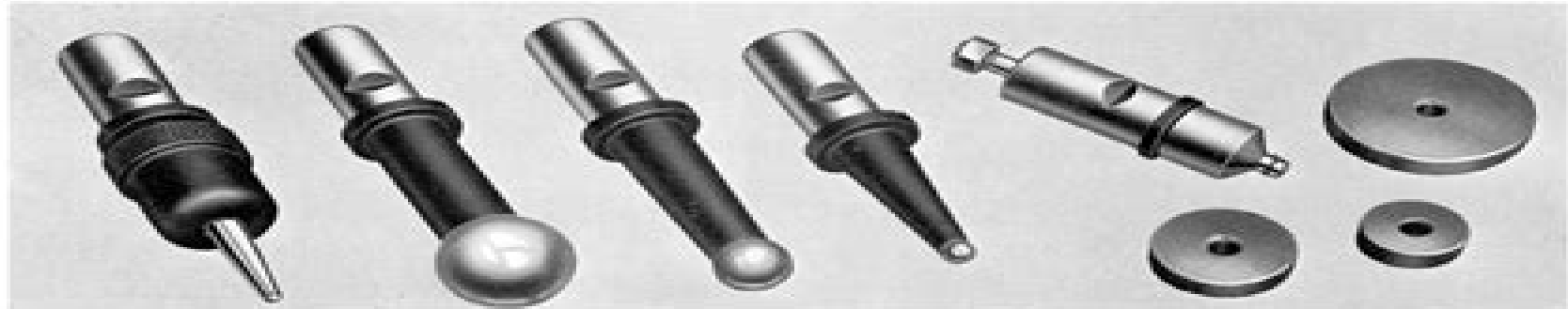


CUTTERS & STYLES

Fig. 3 shows a typical range of styles as used in this machine. Generally for three-dimensional work spherical ended cutters and corresponding spherical styles are employed. It is essential that the diameters of the cutter and the corresponding style should be in the exact ratio of the reduction at which the machine is used, otherwise accurate copying is impossible (see table on page 11). Square ended cutters, end mills, etc., are also employed, these being used in conjunction with cylindrical styles, the same remark regarding diameters holding good.

Fig. 3



Cutters below about $\frac{1}{4}$ -in. (6.35 mm.) diameter, especially ball ended and conical cutters can be ground up from steel rod. To hold these in the machine a $\frac{1}{4}$ -in. (6.35 mm.) diameter collet is included as part of the standard equipment. This serves also to hold standard end mills with $\frac{1}{4}$ -in. (6.35 mm.) diameter parallel shanks. (Right hand spiral mills should be used.) $\frac{3}{8}$ -in. (9.53 mm.) and $\frac{1}{2}$ -in. (12.70 mm.) collets are also included with equipment.

For both spherical and cylindrical cutters made out of $\frac{1}{4}$ -in. (6.35 mm.) diameter ground rod it is recommended that the business end be ground up somewhat after the manner of the old spade drill on the two cutting edges. A minimum of 12° cutting clearance should be given, and particular attention should be paid to secure the best cutting conditions at the centre.

As stated previously, the style and the cutter must always be in the same ratio to each other as the reduction at which the machine is being used. In order to avoid unnecessary multiplicity of sizes, it is very helpful, where the nature of the work permits this, to work always at the same reduction.

Where, however, it is required to produce a series of reproductions of different sizes from a single master copy, the use of different reductions is necessary, and accordingly, in order that the user can cheaply make

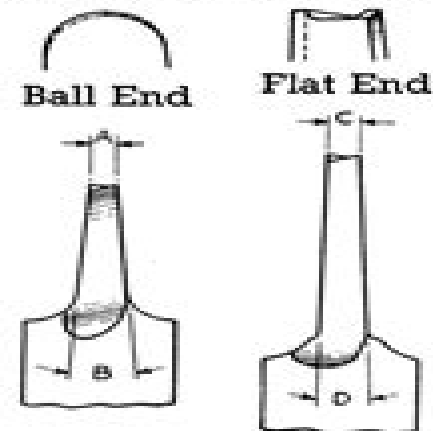
up styles himself as required in different sizes, the style fitting of the machine has been kept as simple as possible. It is simply necessary to provide a parallel shank to the style of $\frac{1}{4}$ -in. (15.88 mm.) diameter.

A range of spherical styles from $\frac{1}{4}$ -in. (6.35 mm.) to 1-in. (25.40 mm.) diameter is provided. These are made from steel balls which are softened, drilled and tapped and re-hardened. They attach to one of the three ball style holders with a draw bolt. There are about 40 standard sizes of steel balls between $\frac{1}{4}$ -in.

(6.35 mm.) and 1-in. (25.40 mm.) diameter which can be utilised in this way.

Under certain conditions, as when working from a delicate model, a fibre style can be used with advantage, but great care must be exercised as, if the style wears, accuracy will be lost.

Method of making shapes of Cutters, ground from $\frac{1}{4}$ " high-speed steel rod



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