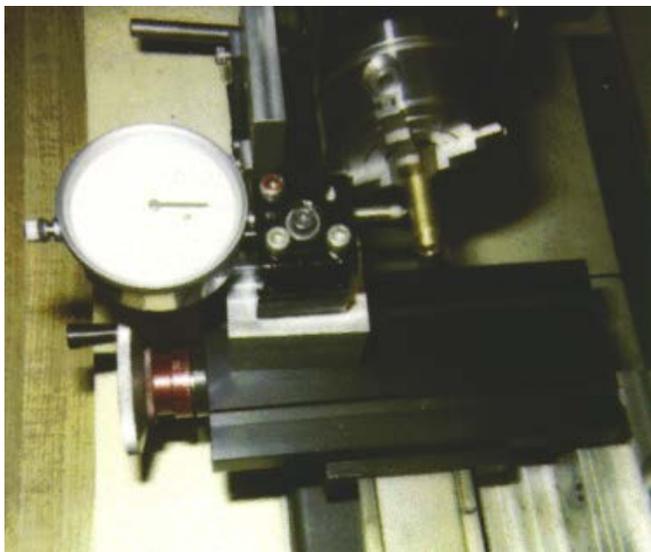


TIP 6 — Centering Work in a 4-jaw Chuck/Edward Ewell

“Here is a nice tip. If you have the 3/8" insert tool holder (P/N 7600), the 3/8" hole in this holder will hold the one-inch travel dial indicator nicely. I use this to center my work in the 4-jaw chuck. After centering, I remove the dial indicator and install the cutting tool, and position the holder for the cutting process. I make camera repair parts and the accuracy I need is only obtained with the 4-jaw chuck. I also modified the normal 1/4" tool holder by drilling a 3/8" hole in it as well.” —Edward C. Ewell, Klamath Falls, OR (Received via e-mail)



Mr. Ewell sent this photo to show the dial indicator being held in the 3/8" hole of the P/N 7600 toolpost. The part is adjusted in the 4-jaw chuck until the gage doesn't move as the spindle is rotated. The part is then perfectly centered. (A custom spacer block is under the toolpost because a riser block is being used under the headstock.)

Another good tip from Edward Ewell on using magnetic indicator stands

Many components on Sherline lathes and mills are aluminum which is non-magnetic. In order to be able to use indicators with magnetic bases, Mr. Ewell offers the following advice: “Mount your Sherline lathe or milling machine on a 1/8" steel plate to allow the use of magnetic dial indicator stands. This goes on top of the normal mounting board. You can indicate your work from either side of the machine.”

Sherline's owner, Joe Martin, notes that this is an excellent tip. He adds that if you don't have a single plate large enough to cover your entire base, you can just screw down a couple of smaller plates in the appropriate areas on your base where you will be using your magnetic indicators.