

## TIP 61 — A Holder for 1/8" Square Lathe Tools/Don Brouse

Attached are photos of an adapter that allows 1/8" square tool bits to be used with standard Sherline 1/4" tool posts. Grinding 1/8" tool bits requires a lot less metal removal than 1/4" bits and is a real timesaver, especially when grinding radius tools for small inside diameters. 1/8" bits still have more than enough rigidity for any project the Sherline can handle. They also cost a little less than 1/4" bits and take up less storage room.

The adapter is made from 1/4" square mild steel and has a 1/8" deep by 1/8" wide slot centered on one face. Overall length is 2". The sides of the channel should be milled down so they are slightly less than 1/4" high so the clamp screws tighten on the tool bit, not the adapter.

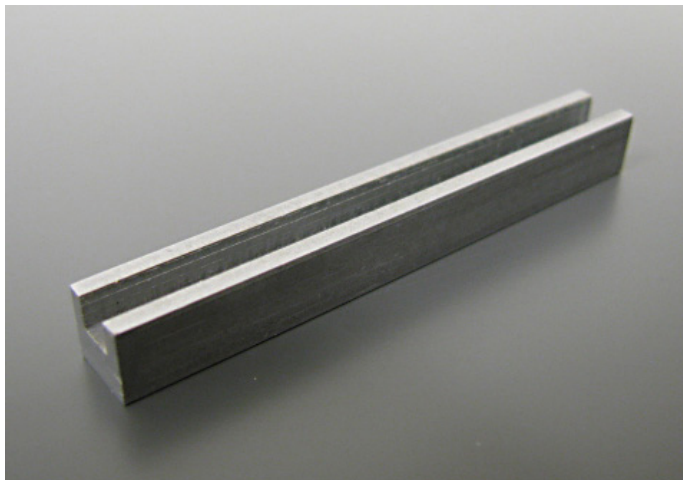


Photo 1—The 1/4" blank with a slot cut to hold the 1/8" tool.

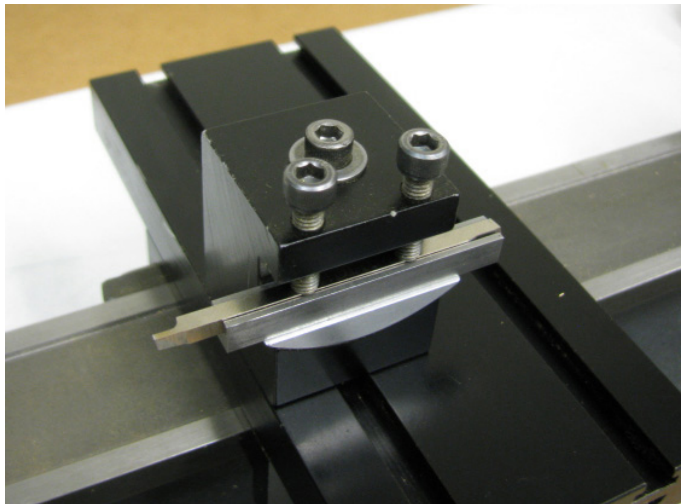


Photo 2—The holder and 1/8" tool in place on a Sherline 1/4" rocker tool post. Note that the top surface of the holder on either side of the channel is reduced in height slightly so the clamping screws contact the 1/8" tool itself.

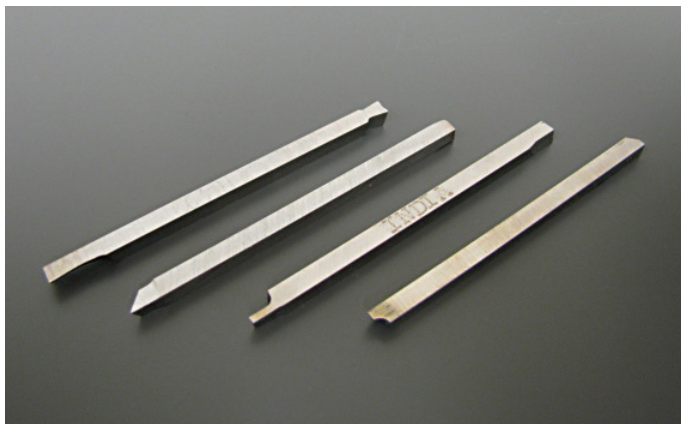


Photo 3—Above is a photo of several 1/8" tool bits that I have ground.

Best Regards,  
Don Brouse