

## TIP 82 — Tommy-Bar Locker/Sanghyeon Jung (a.k.a. David the Korean machinist)

One of our customers in Korea has a great idea that may be helpful to the rest of the Sherline machining community. The device is a Tommy-bar locker that enables one-hand operation for the opening and closing of a chuck. It can be used on either your mill or your lathe (see Figure 5 for headstock installation details).

The magnets that he has fixed to the headstock are so the SHCS will stick to them and hold the lever arm “up and out of the way” of the rotating chuck (see Figure 3 for magnet placement).

Additionally, using a piece of round stock instead of square stock for the lever arm is a good idea. If the lever arm were to drop down while the chuck was turning, the chances are better that the arm would be knocked away from the chuck by the pin when the pin hits the round surface of the arm. The pin would surely

crash if it hit the flat side of a square piece of stock.

David says, “I continue to expand my business, and from five years of experience with Sherline products and its services I am quite impressed. I will definitely get my next machining equipment from Sherline.

I am planning to become a fountain pen manufacturer in South Korea. For the ebonite parts that I will be machining I will use Sherline gang lathe and gang mill.

Take care, and as always, thank you for your dedication and service.”

Sanghyeon Jung  
English name David  
a.k.a. the Korean machinist

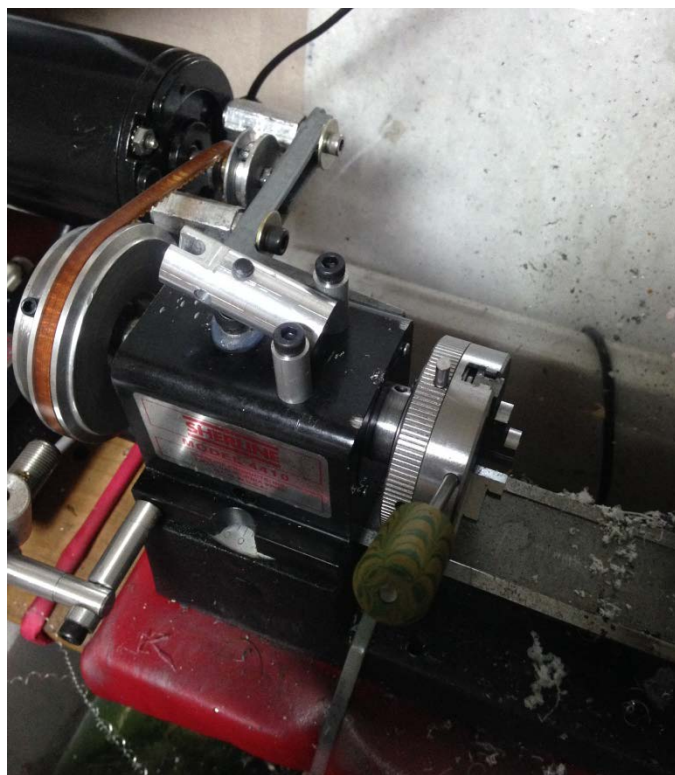


Figure 1—Lathe setup, open position



Figure 2—Lathe setup, locked position

Continued on page 2.



Figure 3—mill setup, open position (magnets circled in red)



Figure 4—mill setup

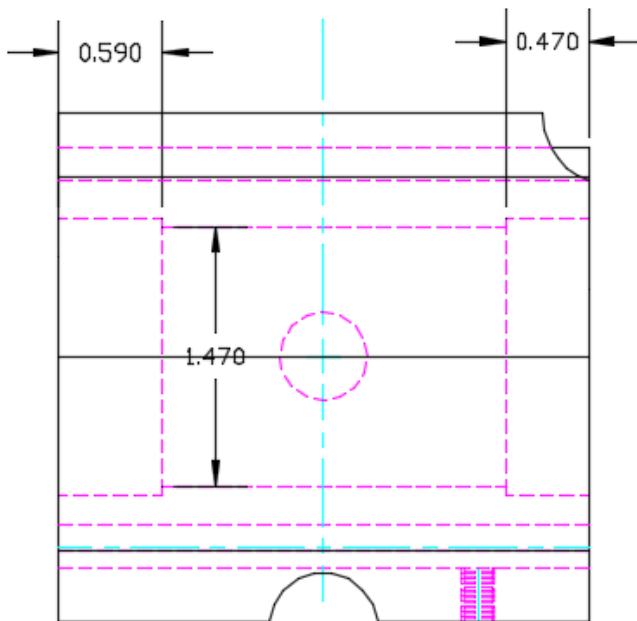


Figure 5—Shows the headstock bearing location

**NOTE:** Any holes that are drilled and tapped into the top of the headstock should be 3/4" away from the front or backside to avoid damaging the bearings.