

TIP 91 — Depth Stop for the Lathe/Russ Cupan

If you have any of the Sherline milling collets, here is a way to make some custom depth stops for the lathe. With the stop mounted in a chuck, turn a diameter that fits into your collet about a half inch long, as shown in Figure 1.



FIGURE 1

Use a sharp-cornered tool to get a minimal radius where the turned diameter meets the shoulder of the stop. Install the collet and stop in the spindle with the shoulder of the stop pushed against the collet and then tighten.

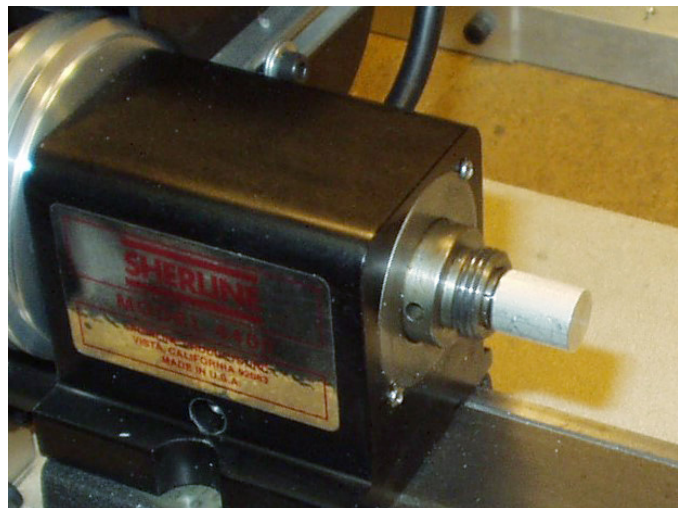


FIGURE 2

The main body of the stop can be up to around 5/8" diameter and still pass through the threaded portion of a chuck. Now turn the diameter of the stop to slightly less than the diameter of the stock you will be

working with so you will be sure to grip the work, not the stop. Install the chuck and measure from the face of the chuck jaws to the face of the stop to determine how much needs to be faced off the stop to establish the depth that the stop needs to be within the chuck.

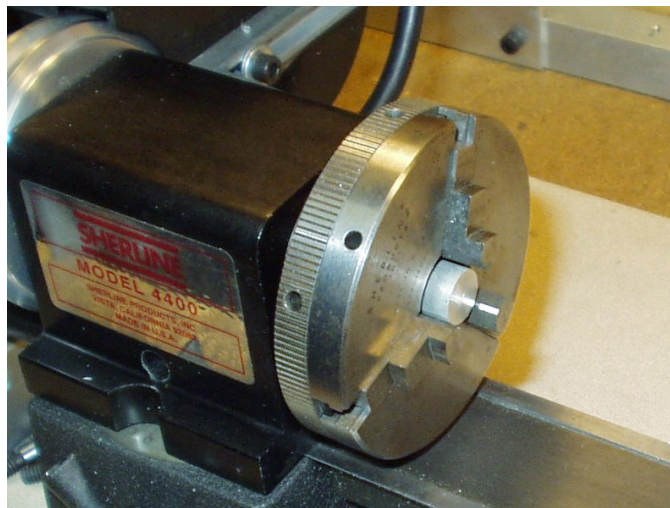


FIGURE 3

As you can see in Figure 4, a flanged bushing is ready to be faced to a custom length. It is held square in the jaws of the chuck, as it sits against the face of the stop.

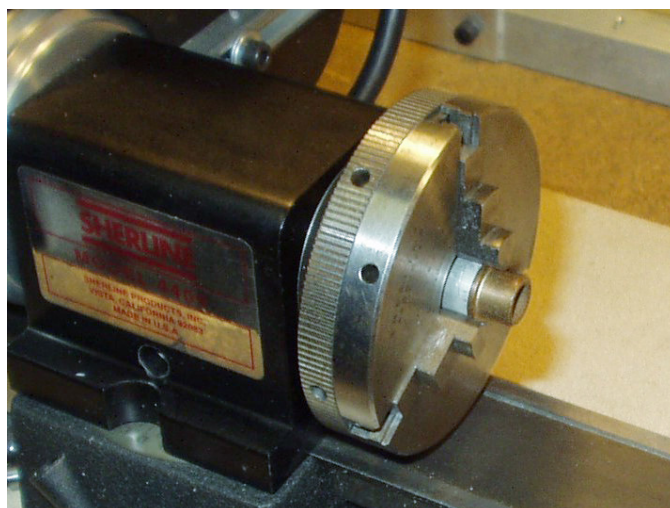


FIGURE 4