

## FEEDSCREW ASSEMBLY

WE can now pass on to the feedscrew assembly, and if you have progressed this far in your essay at machine tool construction you will not require much advice on how to carry out this work.

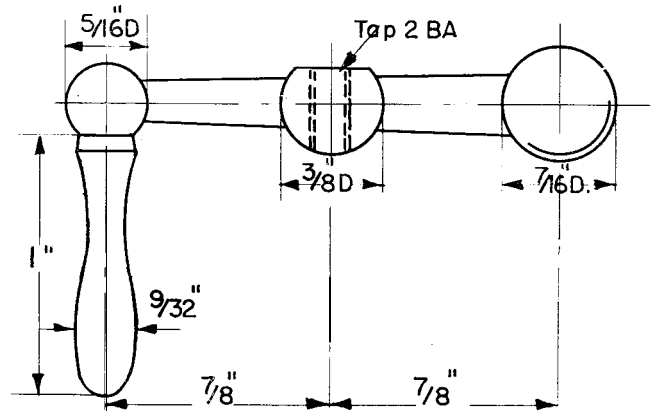
I apologise for the Whitworth thread on item No. 16. It should be a square thread, and if you prefer that you will have to make a tap as well for the nut (19) and you will, of course, cut it left hand. Item 16 will be difficult to turn between centres and so, if you do it this way, a steady is essential. I turned it in stages with the work in the chuck and supported it on the tailstock centre.

The micrometer collar (18) and the handle (20) are both threaded 2 BA and form a locknut system for adjusting the end play of the feedscrew. This is not necessarily the best arrangement but, if the threads are close-fitting, it works well enough. My lathe has had so much use that the feedscrew has worn slack in its nut and so the micrometer collar is not now very reliable. If you have no facilities for dividing, leave the collar blank. It can be done at some later date on the lathe itself.

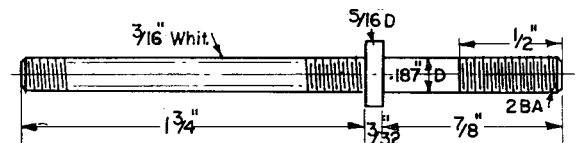
The arrangement of the topslide can be seen in the photograph, p. 553 (August 1), the dovetail slides are machined in exactly the same way as before. Starting at the bottom we have a base (21) carrying a bearing (24) for the feedscrew (25) at one end. The sliding member (22) has a T-slot for the toolpost (27) and a recess is milled out for the nut (23).

I carried out all these milling operations on the Myford, using a Dormer end mill of 9/32 in. dia. and a small slotting cutter for the bottom portion of the T-slot. The cutter was made from an odd piece of silver steel 1/2 in. dia.

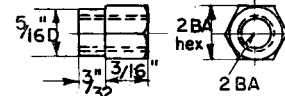
**To be concluded.**



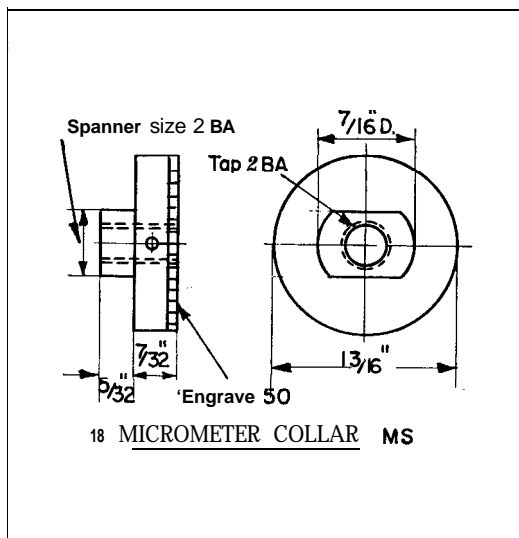
20 BALL HANDLE MS



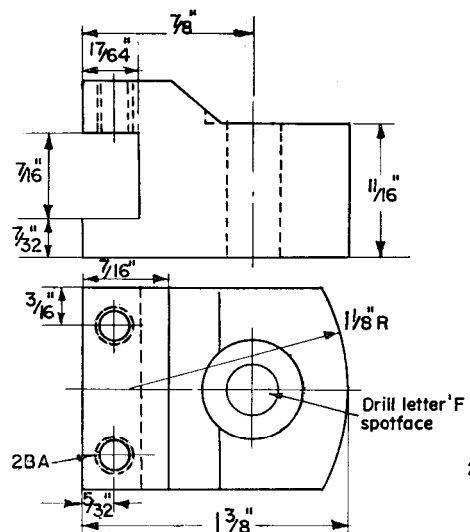
25 TOP SLIDE FEED SCREW MS



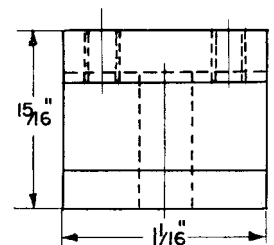
26 FEED SCREW NUT MS

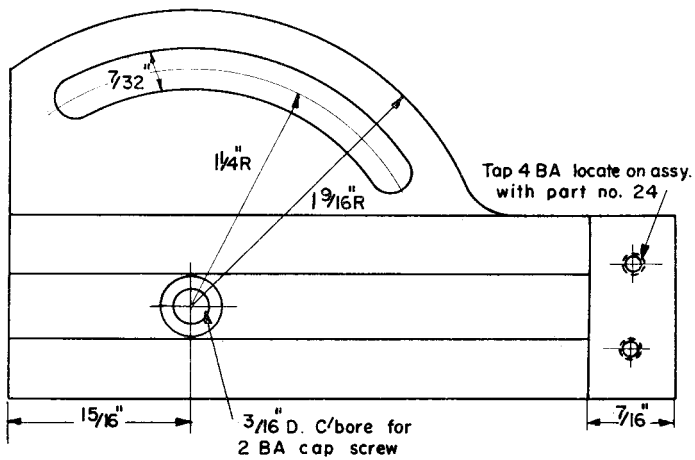
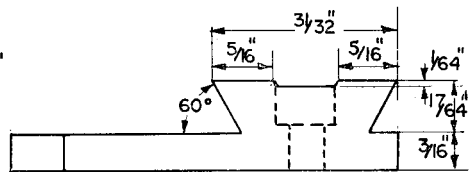
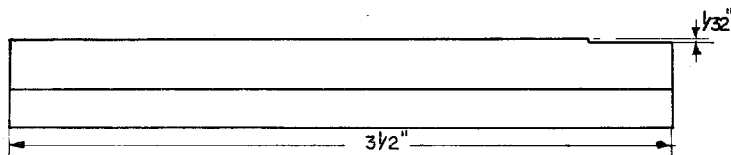


18 MICROMETER COLLAR MS

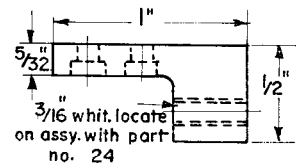
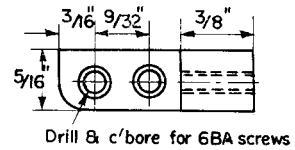


27 TOOL POST MS or CI

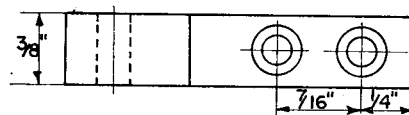
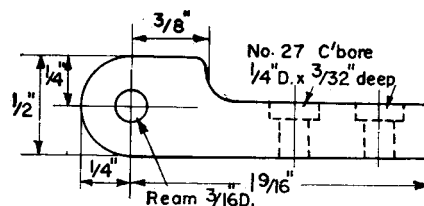
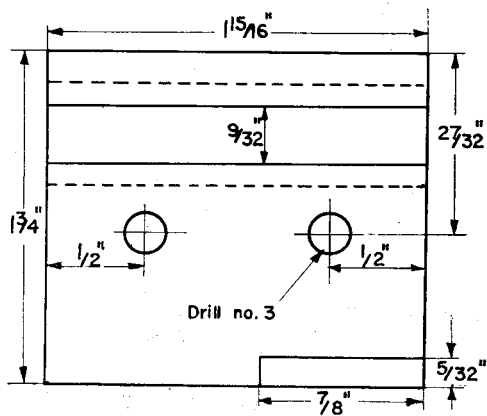
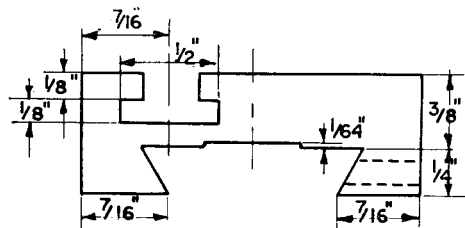
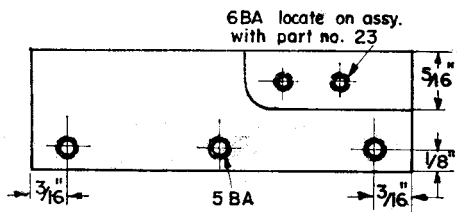




21 TOP SLIDE BASE C I



23 TOP SLIDE NUT C I or G'metal



24 FEED SCREW BEARING C I or brass

22 TOP SLIDE C I