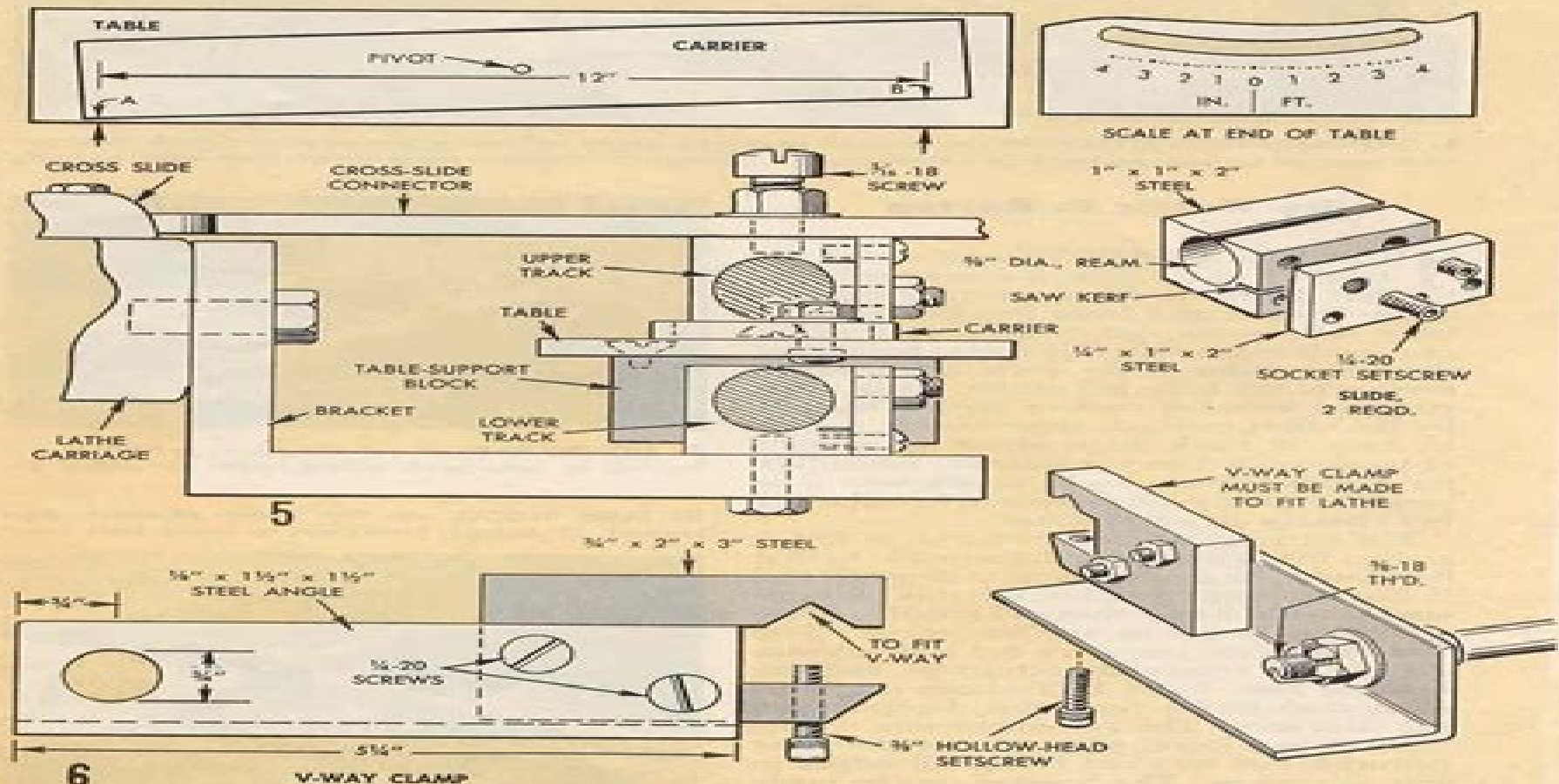




4. SLIDE BLOCKS should be lapped after reaming to assure smooth operation. Drill-rod track is coated with lapping compound. Block is stroked by hand

from a short length of heavy steel angle or can be made by welding two pieces of $\frac{1}{2}$ -in. flat steel at a 90-degree angle. The bracket is screwed to the flat on the back face of the lathe carriage, Fig. 5. The dimensions on the angle bracket carrying the V-way clamp, Fig. 6, also should be checked with your lathe before cutting stock. The lower track, Figs. 5 and 8, should be parallel with the lathe ways.

The slides, Fig. 5, are bored off-center and reamed as in Fig. 3. After reaming, saw cuts (or milling cuts) are run through into the bore and into one side as indicated. Then when the capping piece is screwed in place, the setscrews, with locknuts, provide for clamping the slides at any point along the tracks. Then each slide is lapped to its track, using a lapping compound and a full-length stroke as in Fig. 4. After roughing



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