



# **A treatise on lathes and turning; simple, mechanical, and ornamental**

*William Henry Northcott*

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This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1868 Excerpt: ...circular, spiral elliptic, and other shaped articles, are turned by giving the shaper-plate a slightly faster or slower speed than the work. In the case of the former, the line passing through the concentric and eccentric centres, and in the other case the long diameter continually alters its position at every revolution of the work. Thus, when turning a spiral elliptic shaft, if the difference between the speeds of the work and copy-plate be the one-hundredth of a rotation, then at every rotation of the work, the long diameter of the ellipse will be  $T$  of a revolution behind or in advance of the same diameter of the ellipse which was cut at the last rotation. At the end of twenty-five rotations of the work, the long diameter will have shifted just quarter round, at fifty rotations just half round, and at one hundred rotations the spiral will have made one complete turn. This work is very singular in appearance; when cutting, it looks like and really is a double-threaded screw or spiral, and is cut with a slow traverse of the tool. If the copy-plate rotate faster than the work, the spiral will be left-hand; if slower, it will be right-hand. The pitch of the spiral depends upon the relative speeds of work, copy-plate, and screw. The figure makes one complete turn in every one hundred or other number of rotations: the pitch of the spiral will consequently be the distance traversed by the tool whilst the work has rotated one hundred times. The article may be made of a tapering spiral-elliptic, or other shape by shifting the headstock, or speeding the surfacslide. When the leading screw is driven in the usual manner by the change-wheels, the spiral is formed of one continuous line, but it may be formed of a series of separate circles, by disconnecting the lea...

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