

[illegible]

Rod. When all the turning is done, cut the 1/16" end at 31/32" and thread 22-25 using a tailstock die holder. Part 1-3/16" total length and mill the flats gripping on the .086" diameter in the small V-groove in the milling vise. Mill the slot and make the 1/16"

one set of jaws horizontal, back up the rear jaw out 1/16". Force the work back with the front jaw. Run the cross slide in .050". Slowly feed the rear jaw back until the work touches the tool bit. Carefully snug up the other three jaws. Now, when the high spot just kisses the bit and the chuck is then rotated 180 degrees, a .100" diameter bar should just slide between. Turn the 1/4" diameter to a

