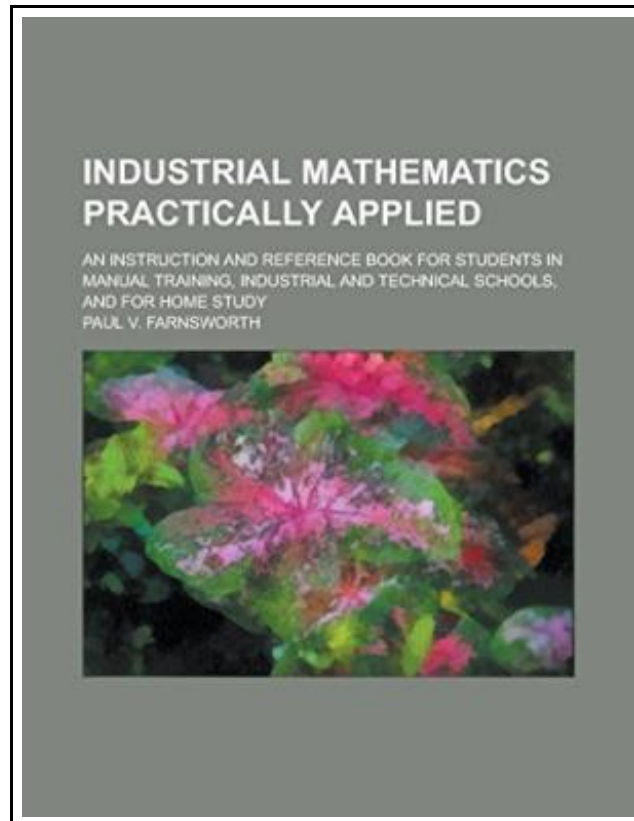


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Rarebookclub.com, United States, 2013. Paperback. Book Condition: New. 246 x 189 mm. Language: English . Brand New Book ***** Print on Demand *****.This historic book may have numerous typos and missing text. Purchasers can usually download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1921 edition. Excerpt: .motion of the index plate takes place when the crank is turned, which turns the plate either forward or backward as may be required. The result is that the actual movement of the crank, in indexing, is either more or less than the movement in relation to the index plate. The differential method cannot be used in connection with spiral milling, because the spiral head spindle is geared to the lead screw of the milling machine. The amount of rotation of the index plate may be regulated by the difference in velocity ratios of the change gears. Example: Find the indexing required for 81 divisions. Solution: By simple indexing the index crank would be rotated through $\frac{40}{81}$ of a turn for each division, but as there is no plate with 81 divisions, the spacing is impossible: therefore another fraction is selected whose value is near $\frac{40}{81}$, say $\frac{40}{84}$ or $\frac{10}{21}$, then a 21 hole circle can be used, indexing in this way for 81 divisions, giving $81 \times \frac{10}{21} = 810/21$ or $38 \frac{12}{21}$ complete turns of the index crank or $1 \frac{9}{21}$ turns less than the 40 required for one complete turn of the work. By using gears in the ratio of $1 \frac{9}{21}$ to 1, the index plate will make $1 \frac{9}{21}$ revolutions, which with $38 \frac{12}{21}$ turns of the crank will make the 41 turns required. Thus the gears will be in the ratio of $7 \times 356 \times 24$ drivers If...



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