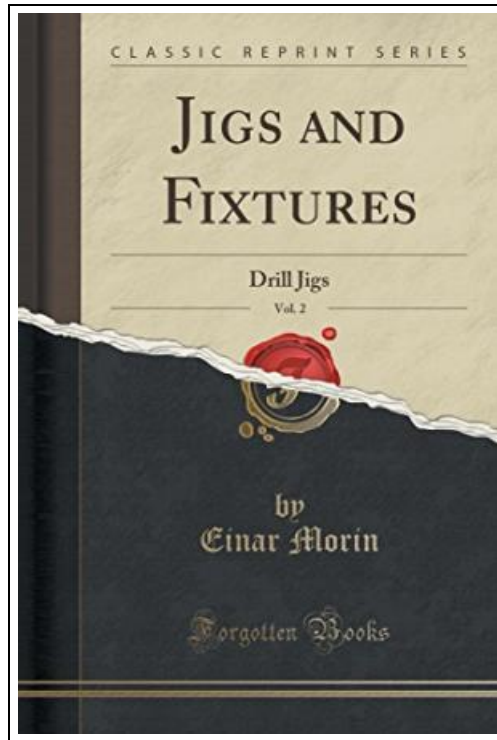


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Forgotten Books, 2017. Paperback. Condition: New. Language: English . Brand New Book ***** Print on Demand *****. Excerpt from Jigs and Fixtures, Vol. 2: Drill Jigs These legs are round, and provided with a shoulder A, preventing them from screwing into the jig plate. A headless screw or pin through the edge of the circumference of the threads at the top pre vents the studs from becoming loose. These loose legs are usually made of machine steel or tool steel, the bottom end being hardened and then ground and lapped, so that all the four legs are of the same length. It is the practice of many tool-makers not to thread the legs into the jig body, but simply to provide a plain surface on the end of the leg, which enters into the jig plate, and is driven into place. This is much easier, and there is no reason why for almost all kinds of work, jigs provided with legs attached in this manner Should not be equally durable. Of course, when jigs are made of machine or tool steel, and legs are required, the only way to provide them is to insert loose legs. In the case of cast-iron jigs, however, solid legs cast in place are preferable. The solid legs cast in place generally have the appearance shown in Fig. 69. The two webs of the leg form a right angle; which, for all practical purposes, makes the leg fully as strong as if it were made solid, as indicated by the dotted line in the upper View. The side of the leg is tapered 15 degrees, as a rule, as shown in the engraving, but this may be varied according to conditions. The thickness of the leg varies according to the size of the jig, the...



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