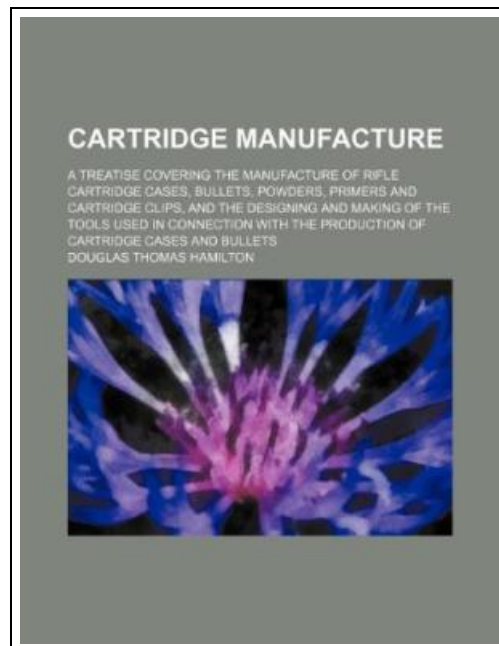


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RareBooksClub. Paperback. Book Condition: New. This item is printed on demand. Paperback. 40 pages. Dimensions: 9.5in. x 7.3in. x 0.3in. This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1916 Excerpt: . . . Blanking, Cupping, and Drawing Die Blank when Machining the Hole or roughing tool B, Fig. 1, is of the flat type, having one cutting edge, while the finishing tool A is of somewhat similar shape but has considerably more circumference so that a rounder hole will be produced. The first tool is used merely for roughing out purposes and for bringing the hole to its approximate shape. Making Redrawing Die Blanks. --The blanks for redrawing dies are made in Cleveland automatic screw machines and are ready for the final reaming operation when they drop from the machine. This method is commendable in that it reduces the cost of the die blanks to a minimum. Die G, illustrated in Fig. 3, is a second redrawing operation die for a 0.30-caliber cartridge case, and is 1.2332 inch in diameter by y inch thick. In order to have the hole true with the external diameter, great care is taken in spotting the work and then removing the hole entirely from the next blank, using a fairly wide cut-off tool. The order of operations accomplished in the proper sequence is as follows: First, feed stock to stop A, Fig. 3; second, turn external diameter with box-tool B held in turret, and spot with a drill C retained in the same holder; third, drill with drill D; fourth, ream straight portion of hole with reamer E; fifth, Fig. 3. Making Redrawing Die Blanks In a Cleveland Automatic Screw Machine...

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