

The NEMES

NEW ENGLAND MODEL ENGINEERING SOCIETY INC.

Gazette

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Pattern making and castings Part II by Rolly Evans.



Next Meeting

Thursday, Aug 1th, 2013

Charles River Museum of Industry
154 Moody Street
Waltham, Massachusetts

Membership Info

New members welcome! Annual dues are \$25 (mail applications and/or dues checks, made payable to "NEMES", to our Treasurer David Baker) Annual dues are for the calendar year and are due by December 31st of the prior year (or with application).

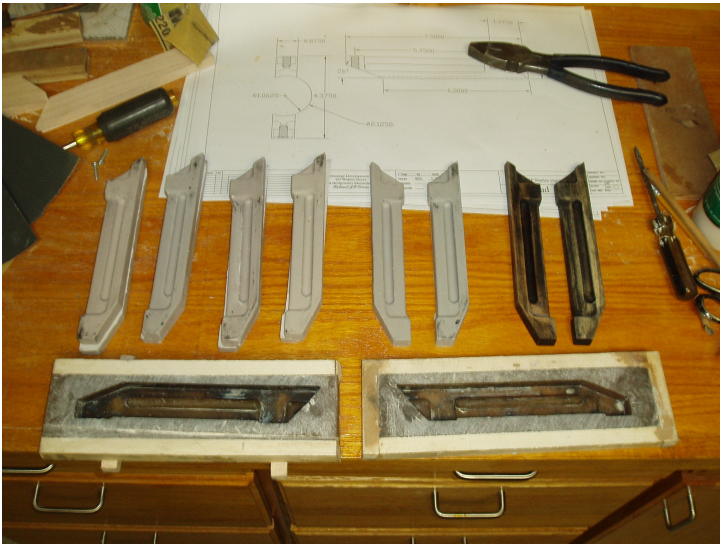
Missing a Gazette? Send a US mail or email to our publisher. Contact addresses are in the left column.

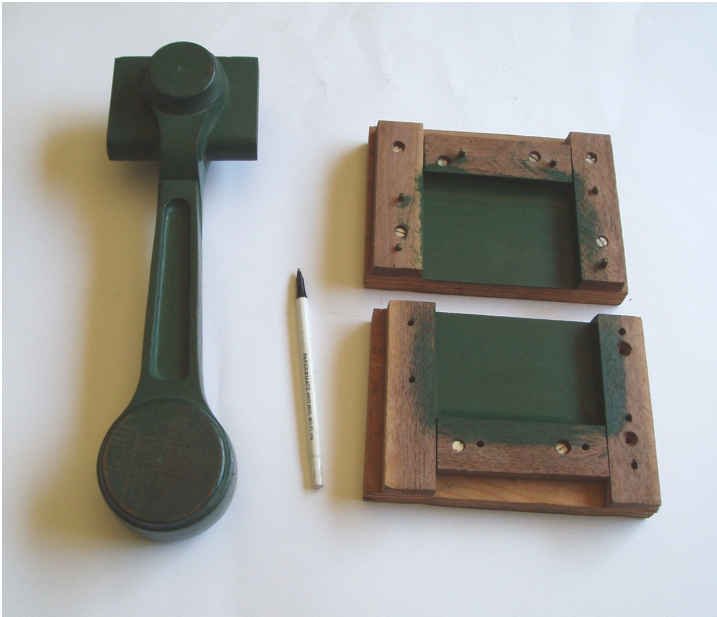
Issue Contributions Due

AUG	JUL 18, 2013
SEP	AUG 22, 2013
OCT	SEP 17, 2013

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Tapping Clapper Box Photo by R. G. Sparber

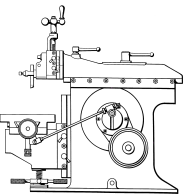
The pivot hole must be tapped in the clapper box. With a spiral point tap in my drill chuck, I ran the mill up to full speed and then cut power. After it coasted down to a comfortable speed I drove the tap into the hole. It went in about half way, which is safe.



Hand Tapping Photo by R. G. Sparber

The thread was finished by hand. I am too far along to risk breaking off a tap, stripping out the threads, or yanking the casting out the the vise.

If I had striped out the threads, a Helicoil® would have been used to restore the thread.

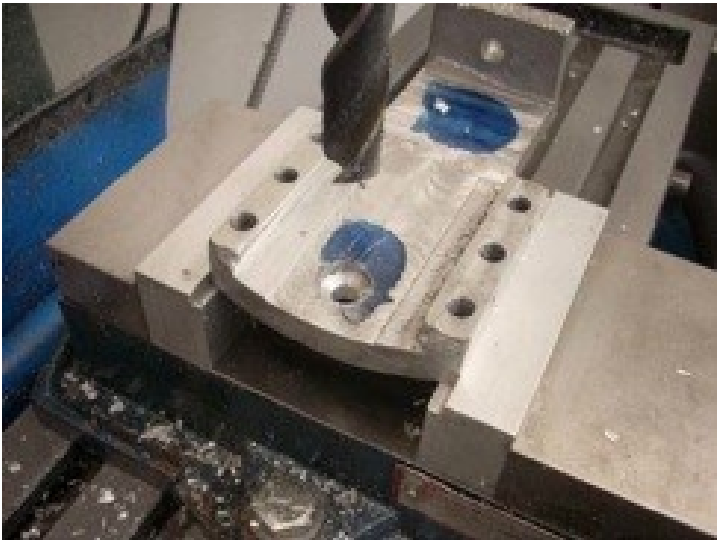


Metal Shapers

Kay Fisher

R. G. Sparber's Gingery Shaper - Part 39 Machining and Fitting the Clapper Box (part 5 of 5)

Back on the down feed casting, it is time to machine the pivot hole. I have drilled a clearance hole and sort of a counterbore using a $\frac{5}{8}$ " drill.



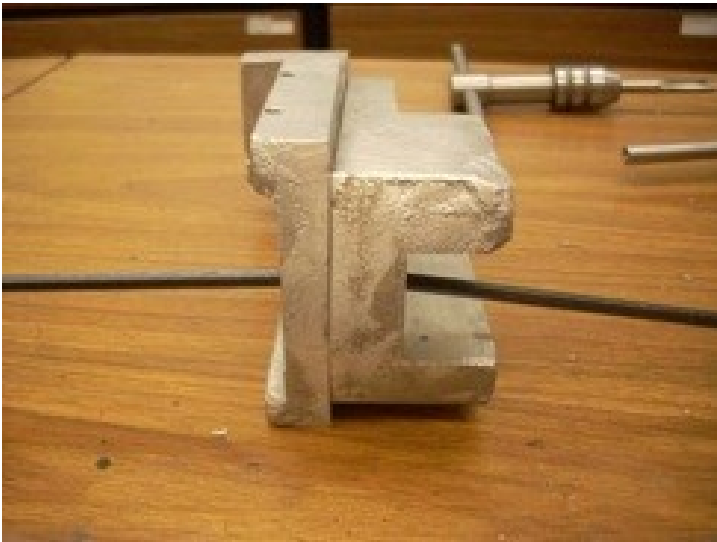
Down Feed Pivot Hole Photo by R. G. Sparber

I wanted to use my $\frac{5}{8}$ " end mill but it would not reach without lowering the head.



Drill Clamp Bolt Hole Photo by R. G. Sparber

The clapper box has been temporarily bolted to the down-feed casting and set approximately on center. I can now match drill the clamp-bolt hole such that it is aligned by the curved slot. A spud was used to position the center of the spindle on the center line of the down-feed casting. Next, a close-fitting dowel was used to locate where along the X-axis to drill the second hole such that it is centered in the arc. The hole was then drilled and tapped.



Fitted - End View Photo by R. G. Sparber

A screw is fed through the down feed casting and into the threaded hole in the clapper box. A set screw is fed in from the clapper box. By tightening the screw from the left and the set screw from the right, their ends press together and lock the screw. The idea is to have an adjustable clamping action between these two parts yet permit them to pivot.



Clapper Left Photo by R. G. Sparber

With the screw installed, you can see that I am able to swing the clapper box all the way to the left.



Clapper Right Photo by R. G. Sparber

I can then smoothly swing the clapper box all the way to the right.

The bolt head chosen is the same size as all adjust bolts on the shaper. I don't want to have to constantly swap sockets while setting up the machine.



Cleaning The Last Surface Photo by R. G. Sparber

One last bit of clean up is required so the dial feed pointer and crank fit squarely on the above surface. I could have cut a bit deeper and not left the small recess but did not want to push my luck with the casting after so many hours of time invested.



Clapper Box on Shaper Photo by R. G. Sparber

We are now one step closer to having an operational shaper!

The clapper will be cut from CRS. I plan to use a tapered D reamer to cut the pivot pin hole. The tapered pin will be cut at the same time the reamer blank is cut. But that is for another day.

Stay Tuned for part 40 from R. G. Sparber next month.

Keep sending me email with questions and interesting shaper stories.



Upcoming Events

Bill Brackett

To add an event, please send a brief description, time, place and a contact person to call for further information to Bill Brackett at:

thebracketts@verizon.net or 508-393-6290.

Aug 1st Thursday 7PM
NEMES Monthly club meeting
Charles River Museum of Industry 781-893-5410
Waltham, MA

Aug 4th Belltown Antique Car Club
47th annual summer show
off of Rt. 151 East Hampton Ct
<http://www.belltownantiquecarclub.org/shows/engine%20show%20main.htm>

Aug 3-4th Scribner's Mill Show
Sebago Lake Region near Harrison ME
207-583-6455

Aug 10th -11th Straw Hollow Engine Show
Boylston, MA
J. A. Resseguie 508-869-2089

Aug 18th 9:00am The Flea at MIT
Albany Street Garage at the corner of Albany and Main Streets in Cambridge

Aug 23-25th 42nd Annual Meet
Waushakum Live Steamers
Holliston MA
<http://www.waushakumlivesteamers.org/>

Aug 30th -31st Vermont Gas & Steam Engine Assoc show
Intersection Rte 100 and Rte 107 Stockbridge VT
Gail Norman 802-485-8224

Sept 5th Thursday 7PM
NEMES Monthly club meeting
Charles River Museum of Industry 781-893-54104
Waltham, MA

Sept 7-8th Dublin Show
RT 101, Dublin, NH

Sept 6th - 15th Annual Lee's Mills Steamboat meet
Moultonborough, NH
<http://www.steamboating.org/>

Sept 15th 9:00am The Flea at MIT
Albany Street Garage at the corner of Albany and Main Streets in Cambridge

Sept 21st 8:00-4:00 The Original Yankee Steam-Up
The New England Wireless and Steam Museum, Inc.
1300 Frenchtown Road East Greenwich, RI
<http://www.newsm.org/index.html>

Sept 22nd 12:00-5:00
Roland's Shop visit
90 S. Spencer Rd. Spencer Ma.
508-887-2277

Sept 27th-30--29th Connecticut Antique Machinery Museum
Fall Festival
<http://www.ctamachinery.com>