

Objective: To prepare the job as per the specifications provided

Machine Tools used: Lathe Machine (Specification H.P. =0.75 H.P. over all length 1600-2000 mm, Swing Dia =455-575 mm.

List of tools: Engg. Steel Rule 6", Outside caliper, Vernier calipers, Flat smooth file, Single point cutting tool, Knurling tool, Center drill, Drill chuck ½", Spanner set, Parting off or necking tool, Thread gauge, Threading tool, Parting tool, Lathe Dog carrier etc.

Materials Used: Mild steel Bar (40 mm dia.)

List of Operations: Cutting, Facing, center drilling, Plain turning, Taper turning, Necking, Knurling, Threading, chamfering, Filing Oiling.

Drawing: See diagram

Procedure:

1. Understand the job drawing thoroughly and plan the job.
2. Cut off a 130mm long piece from 40 mm dia. Bar.
3. Hold the work piece in the Lathe chuck and perform facing and center drill operations. Repeat the same on the other side also.
4. Hold the job in between live and dead centers.
5. Perform plain turning (L=35mm, dia, chamfering and knurling operations on one side and interchange the faces axially.
6. perform plane turning by swiveling the compound rest at an angle 4
7. Now start threading by setting levers as per requirement.
8. After filing if required, take off the job from m/c and do oiling in the whole job for the protection from the rust.

Precautions:

1. Don't wear loose clothes while working on the machine.
2. Work piece should be held tightly between the live and dead centers.
3. Always clean machine before use.
4. Cutting tools should be held tightly in the tool holder.
5. Never let your clothes and hand come in contact with the revolving chuck, pulleys etc.
6. Do not touch the chips when machine is removing them
7. Do not give large feed to the cutting tool.

First Year Btech Mechanical Workshop Manual

L Manion



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