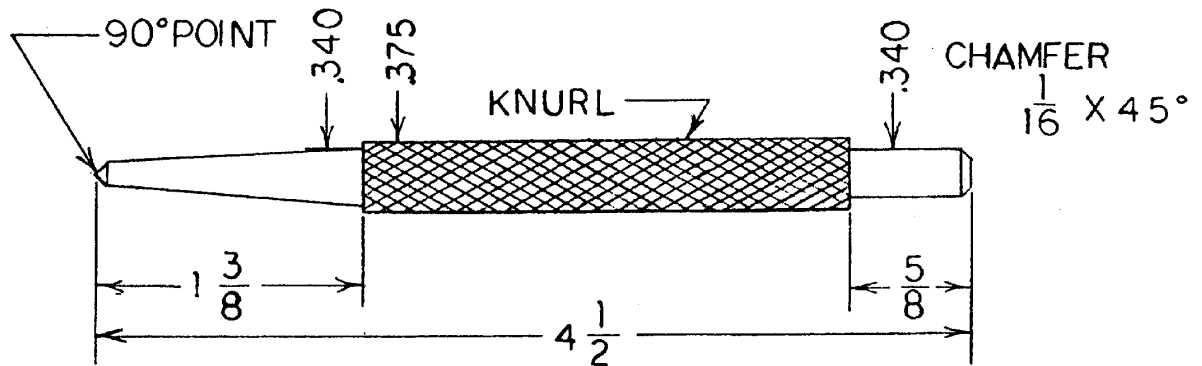


CENTER PUNCH-TURNING



Procedure:

1. Select stock: $\frac{3}{8}$ " diameter drill rod. _____
2. Cut off a piece 5" long. _____
3. Face just enough off each end to square it off. _____
4. Centerdrill each end with a small size centerdrill. _____
5. Mount work between centers and layout all length dimensions. _____
6. Knurl the center section with a fine size knurling tool. _____
7. Turn the right hand end to .340" diameter. _____
8. Turn the other end to .340" diameter. _____
9. Hold the workpiece in a 3-jaw or collet chuck. Be careful not to damage the knurl. Face both ends to finished length. _____
10. Cut the $\frac{1}{16}$ " by 45° chamfer on the right hand side. _____
11. Cut the 5° taper on taper attachment or $2\frac{1}{2}$ ° on compound rest. _____
12. Cut the 90° point. _____
13. Harden and temper the point. _____
14. Polish the ends to a bright finish. _____