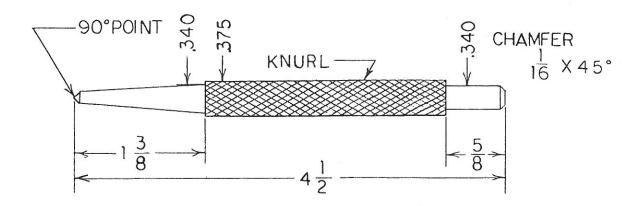
## CENTER PUNCH-TURNING



## Procedure:

1.	Select stock: 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 1/16" by 45 chamfer on the right hand side.
11.	Cut the 5 taper on taper attachment or 2½ on compound rest.
12.	Cut the 90 point.
13.	Harden and temper the point.
14.	Polish the ends to a bright finish.