

Newsletter of the Horological Tool Chapter #173 of the NAWCC

Tool Enthusiasts' Round-Up

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Grinding a Watchmakers Lathe Bed

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The Horological Tool Chapter of NAWCC

The Tool Enthusiasts' Round-Up is the newsletter of the Horological Tool Chapter #173 of the National Association of Watch and Clock Collectors Inc., a non-profit educational organization. This chapter and its newsletter are intended to foster interaction among NAWCC members who share a common interest in the use and collection of horological tools of all sorts. If you have an item you have researched, a book of interest, or notes on a project you have made, please consider sharing your knowledge with others through the newsletter.

The annual chapter dues of \$10 will ensure that members receive the newsletter and are included in the Membership Directory when it is published. Members are also entitled to one classified ad in each issue.

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News from the TER Editor

The NAWCC National Convention was a good time for those who went. Several members stopped by and talked to the Editor at his Mart table. It is always good to put a face to the name on your newsletter mailing label. I would also like to thank many of you for your positive comments in relationship to the job being done by the volunteer board of Chapter 173.

I think we all need a pat on the back to know that our work has been appreciated. Another form of feedback has been the number of membership renewals we had this year. Most members are now paying dues 2 years in advance; so, I guess they are relatively satisfied with our progress. One member is prepaid for 10 years!

Still, we have a long way to go. Many NAWCC members still do not know there is a special chapter for horological tools. We need to increase our visibility by holding meetings at regionals and nationals ...something we have not been doing recently. However, this takes volunteers, something we need more of. Most of the current Chapter 173 board members hold positions in other chapters or at a national level. There is just so much multi-tasking one person can do. So if you would like to help out give us a call.

As for the NAWCC National Convention, the selection of tools was modest. Two antique Swiss wheel cutting engines showed up and both failed to sell. The prices seemed reasonable to me but, the demand for these has dropped along with their price. It appears that they are now selling for 30% to 50% less than when I bought mine.

This may be an indicator that antique horological tool prices are now trending downward as did the prices in the watch and clock market over the last few years. It might be a bad time to sell your tools but, on the other hand, a good time to buy.

Best Wishes,
Bruce

Resurfacing a Lathe Bed

By Bill Bonta

I was doing a favor for a friend whose father died and this set in motion the disposal of his estate. Unfortunately, the son knew nothing about his father's watchmaking business; so, long story short, I volunteered to get rid of his fathers' paraphernalia. Among his junk was a Marshall Peerless lathe. I am sure you know the brand. I figured that I could polish up the chrome, do a quick grind on the bed and sell it on eBay for several hundred dollars. Boy was I wrong, at least about the quick part.

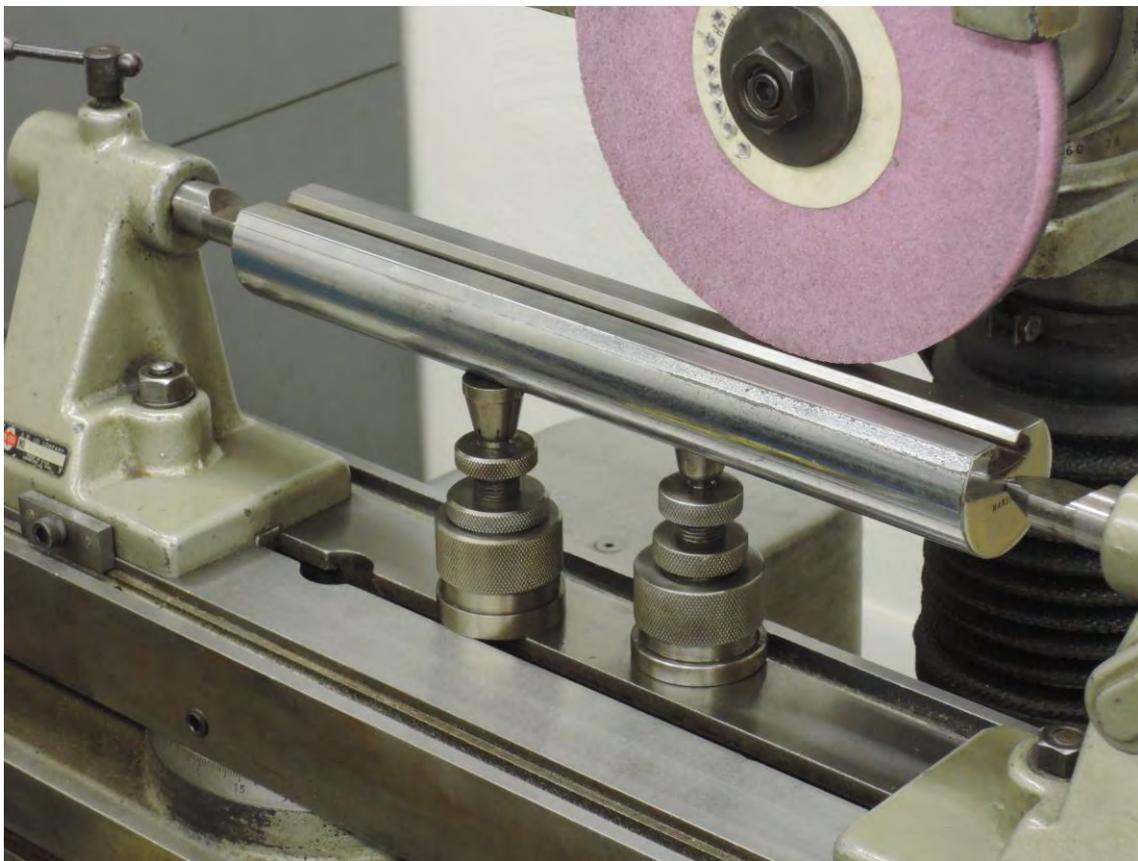


Figure 1. Setup for grinding a lathe bed.

The bed setup is easy as shown in Figures 1 and 2. I've done this work before. The lathe bed is manufactured from round stock and the reference points are centering holes in each end of the bed. So, the right and left leveling is automatic and the for-and-aft leveling is done with a small machinists spirit level and a pair of jack stands, one each under both of the bottom flats used for the tool post clamping surface.

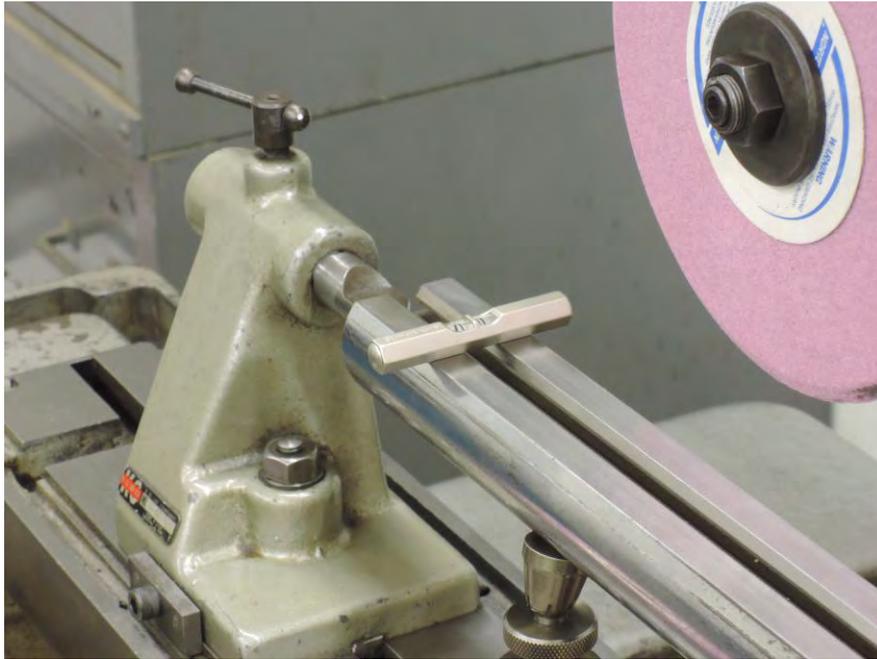


Figure 2. Leveling the bed.

So far so good. First grind the flat surface until it all looks new then swap out the flat wheel for one that I keep for this purpose, which I diamond ground to a 30 degree point (Figures 3 and 4). Of course on the Peerless lathe bed, the wheel is used in the center slot instead of the outside of the bed as for other lathes. Grind the center slot both front and back angles until there is no shake that you can feel placing the headstock back on the bed. The finished product looks as shown in Figure 5.



Figure 3 and 4. Grinding the flat (left) and grinding the angle (right).

Now comes the surprise: only six of the 40 collets that came with the lathe fit the spindle (did you hear me muttering what the hell is going on?). The answer was that somebody replaced the key in the spindle and it looked good from the standpoint that I didn't notice that fact. So, the major part of this job was to find out how to correct this error.



Figure 5. The reground lathe bed.

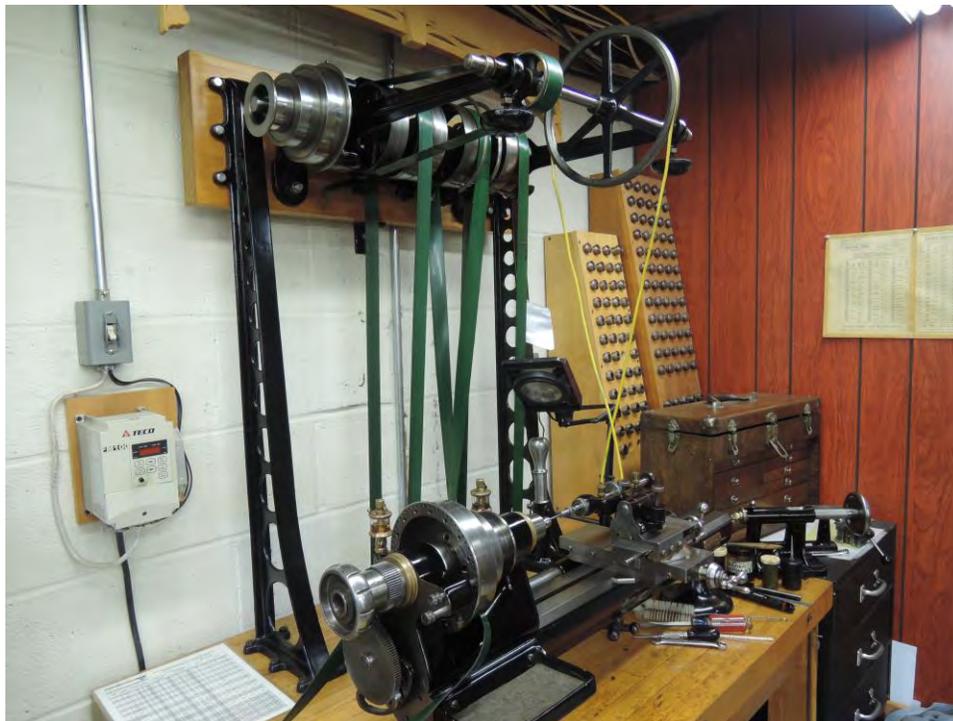


Figure 6. The Hardinge Cataract lathe with internal grinding attachment.

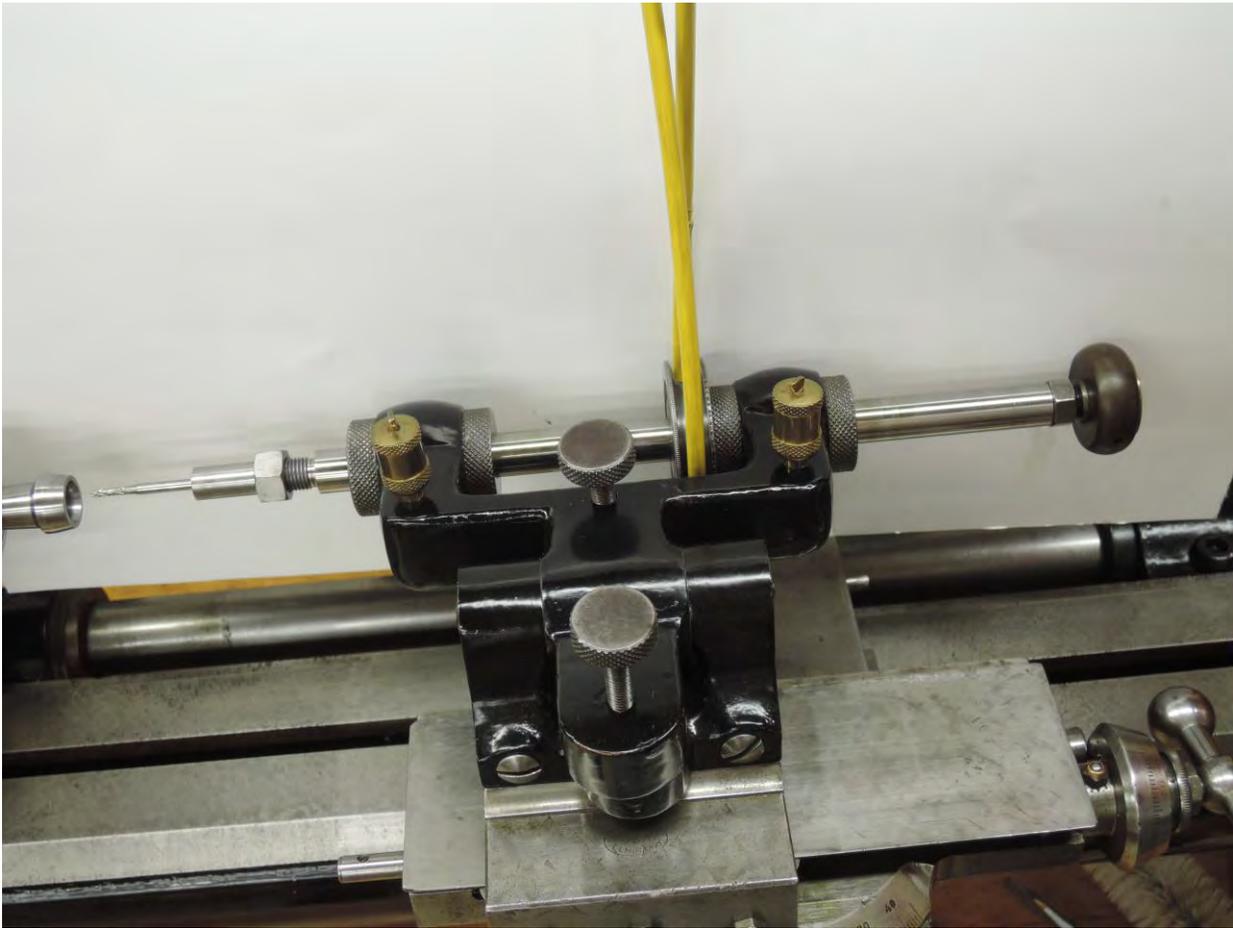


Figure 7. Close-up of the grinding attachment.

My solution was to set up the spindle grinder on my Hardinge Cataract lathe and take off the inside top of the key, bit by bit, until all the remaining collets slipped in nicely. As shown in Figures 6 and 7 the setup is fairly simple.

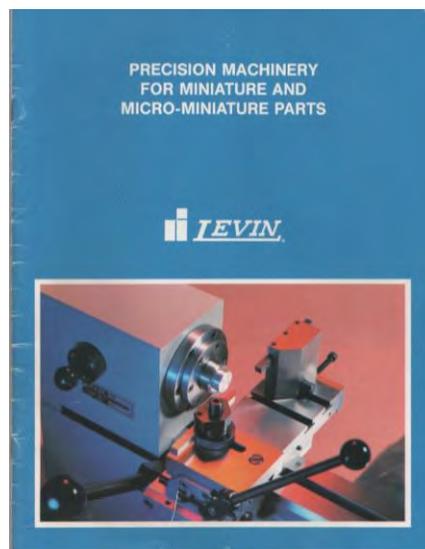
One problem I found was that the usual internal stone I have for this purpose is about 1/4" o.d. and even at that when one moves the spindle for-and-aft to get a flat top on the key, the 1/4" diameter is too large for the 8 mm bore, so I had to use a long, smaller diameter carbide burr such as you see at the Chinese tool dealers' stands at the flea markets. Another lesson: these cheap Chinese burs have all sorts of shank diameters. You can't tolerate any slop when the burr is turning at forty thousand rpm. A veritable whistle from the old guy.

Adding insult to injury, I could figure no way to measure the width of the bugged key, inside the spindle, thus some of the other collets would slip in but many more would not. Width being too great, I had to use a knife-edged, 6-cut watchmakers file to narrow the side of the key bit by bit until all forty of the collets slipped in.

So after the job was done I get no satisfaction other than I helped out a friend but, I thought there may be some lesson for other members of the tools Chapter #173. Perhaps one should not work for 50 cents per hour.....But who could have known before hand?

The End

The Library of Lathe & Tool Catalogs



Thanks to John Koepke and others, we can now offer a “Library of Lathe & Tool Catalogs” to our members on one CD. These catalogues hold a wealth of information and over 50 have now been digitized by John Koepke for your reading enjoyment. There are 35 catalogues from Levin which include the instructions for their screw cutting attachment and Micro Turn II. All these are available on one CD at a cost of \$13. Please send a check for \$13 to Chapter #173 Treasurer: Dave Kern, 5 Hilltop Drive, Manhasset, NY 11030

For Sale

A friend of mine is closing his clock shop and would like to sell his equipment. It is all basic stuff: L&R cleaning machine, drying oven, bushing tool, 8 mm lathe, work bench etc.. Does anyone know of a younger member starting out that might need some of the basics? Contact the editor.

For Sale



Schaublin model 102 second operation lathe. Enclosed headstock that takes 25 mm collets, collet closer, double tool post production cross slide, 6 position turret tail stock, Needs motor and drive belts. \$695. Mark Fulmer (330) 877-2021, Markusfu@hotmail.com



50 pieces - 25 mm Schaublin collets with collet rack. \$350 Mark Fulmer (330) 877-2021, Markusfu@hotmail.com

More tool adds coming in the Winter issue!