

The NEMES

NEW ENGLAND MODEL ENGINEERING SOCIETY INC.

Gazette

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Club Business

George Gallant

We are in need of a Gazette editor. Errol tried to wear this hat along with the Web and the Events coordinator. More roles than one person needs to do. It is somewhat daunting getting started but it quickly becomes routine. Help is available.

We are also in need of interesting articles.

Failure for members to step forward means the end of the NEMES news letter!!

Thursday, August 6, 2015 7PM

Waltham Library
735 Main Street
Waltham, Massachusetts

Membership Info

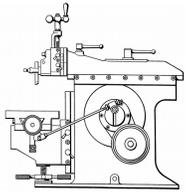
New members welcome! Annual dues are \$25 (mail applications and/or dues checks, made payable to "NEMES", to our Treasurer Richard Baker) Annual dues are for the calendar year and are due by December 31st of the prior year (or with application).

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

Deadline for submitting articles is two weeks prior to the next meeting.

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Metal Shapers

Kay Fisher

R. G. Sparber's Gingery Shaper - Part 64

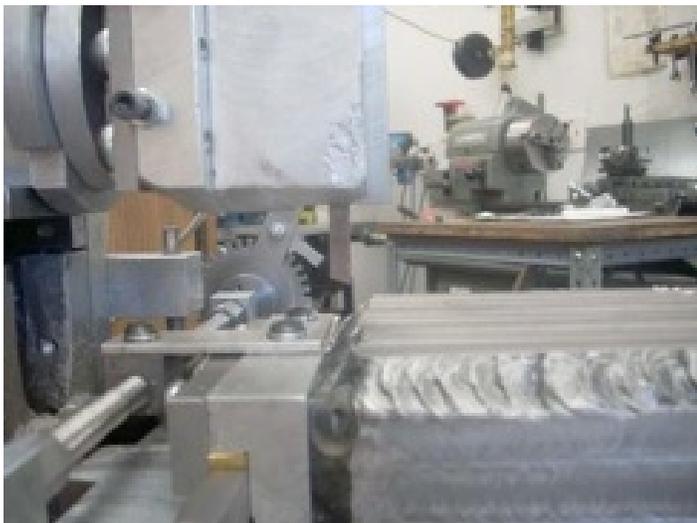
Ram Stroke Adjustment

One of the challenges of modifying Gingery's shaper design is that there are unexpected consequences. One of these surprises was that the cutter did not reach far enough forward. It also started too far back.



Cutter Forward Travel Photo by R. G. Sparber

After making a few modifications, I was able to get the cutter to almost reach the front edge of the table. At the start of the stroke it now just comes off the table.



Cutter Rear Travel Photo by R. G. Sparber

The main reason for the original misalignment is how I modified the clapper. The cutter is set back such that the center of the cutter lines up with the center of the pivot pin. This is supposed to reduce chatter.

The trick in making any adjustment is to minimize rework of parts.



Link Block Modification 1 Photo by R. G. Sparber

One point of interference is the link to the ramp clamp. Here I am cutting a step so the ram clamp can have a bit more room.



Result Photo by R. G. Sparber

That should have helped but now the clamp guide is hitting.



Ram Clamp Photo by R. G. Sparber

The large hole passes the ram clamp while the smaller hole is for a screw that fastens it to the bottom of the ram (see page 67 of Gingery's book). By just removing the screw and rotating the block, I was able to gain more than 1/2".



Ram Way Modification Photo by R. G. Sparber

Here I am using a bench block to tap a new hole in the ram ways for the clamp guide screw.



Link Block Modification 2 Photo by R. G. Sparber

I had to recut the link block so that the raised part of the clamp would slide over the link.

I also had to recut the clamp guide so the larger hole was open on the end facing the link. That got me another 0.2".



Milling Corner Photo by R. G. Sparber

As a final step, I decided to round the corner of the link block to make it easier to move around the scotch yoke's closest corner. I started by running a close fitting rod through the hole and having it rest on the jaws of my vise. The cutter is then lowered until it rests on the top face. The DRO is then set to zero. I now know how much to feed in to get the proper radius which will blend into the top face.

The block was then rotated so the top right corner points straight up. I milled it down until the DRO read zero.



Link Block Done Photo by R. G. Sparber

This removed enough metal so I moved to the belt sander for a final rounding.

Stay Tuned for part 64 from R. G. Sparber next month.

Keep sending me email with questions and interesting shaper stories.



Upcoming Events

Errol Groff

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

events@neme-s.org

Aug. 1-2 Back to the Past at Scribner's Mill
Harrison ME
Follow yellow and black signs from Rts. 35 and 117 to Scribner's Mill Road.

Contact:

Marilyn Hatch
244 Scribner's Mill Rd.
Harrison, ME 04040
207-583-6455
hatchrhinebeck1@frontier.com
www.scribnersmill.org

Aug. 8-9 36th Annual Straw Hollow Engine Works Show
Boylston MA
Pine Ridge Farm, Cross St., off Rt. 70.

Contact:

Daniel Moore
125 Linden St.
Boylston, MA 01505
508-869-2722.

Aug. 15 13th Annual Durham Tractor Cruise-In
Durham CT

Durham Fairgrounds, Rt. 17 (68 Main St)

Contact:

Len Baginski
860-349-3305

Aug. 15-16 24th Annual Antique Marine Engine
Exposition

Mystic CT 195 exit 90

Contact:

Scott Noseworthy
75 Greenmanville Ave.
P0 Box 600
Mystic, CT 06355
860-572-5343
scott.noseworthy@mysticseaport.org
www.mysticseaport.org

Aug 25 29th Annual Old Truck Meet

Antique Truck Club of America

Star Speedway

Route 27 Epping NH

Contact:

Don Smith
603-664-9761