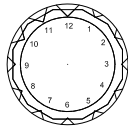
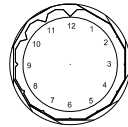


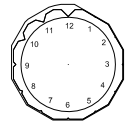
Ø16 rod
turn to Ø15 for 2mm
groove 1.75mm deep x ~1mm wide
mill flats 0.25mm deep on flange
Index for 12 faces



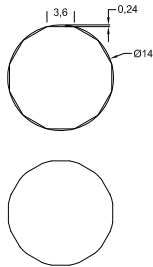
90° cutter to groove depth
(65% of pivot Ø)



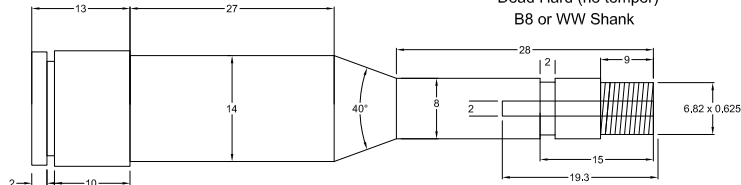
mill flat for burnisher
(50% of pivot Ø above groove flange)



No.	Pivot Ø	Groove depth
1)	0.10	0.065
2)	0.14	0.091
3)	0.16	0.104
4)	0.18	0.117
5)	0.20	0.130
6)	0.24	0.156
7)	0.30	0.195
8)	0.40	0.260
9)	0.50	0.325
10)	1.00	0.650
11)	1.20	0.780
12)	1.40	0.910

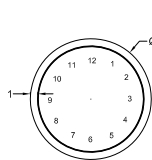


Ø 14 milled for figure stamps

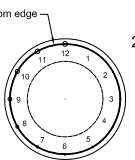


Burnishing Bed Runner
O-1 Tool Steel
Dead Hard (no temper)
B8 or WW Shank

Groove to rotate in tailstock quill
(locked by drawbar only)



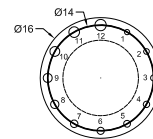
Ø16 rod
- turn flange (0.3mm thick)
- groove 1mm from edge
- turn 2mm radial clearance for burnisher



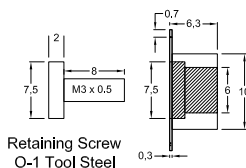
Chamfer, and drill for pivot Ø
Index for 12 positions
Chamfer hole (60°)



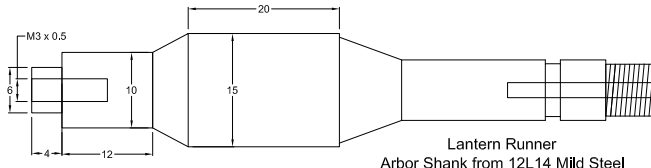
No.	Pivot Ø
1)	0.10
2)	0.14
3)	0.16
4)	0.18
5)	0.20
6)	0.24
7)	0.30
8)	0.40
9)	0.50
10)	0.55
11)	0.60
12)	0.65



No.	Pivot Ø
1)	0.70
2)	0.75
3)	0.80
4)	0.85
5)	0.90
6)	0.95
7)	1.00
8)	1.10
9)	1.20
10)	1.30
11)	1.40
12)	1.50



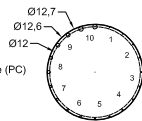
Retaining Screw
O-1 Tool Steel



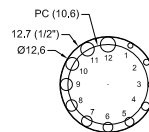
Lantern Runner
Arbor Shank from 12L14 Mild Steel

Lantern Insert
O-1 Tool Steel
harden & temper to pale blue

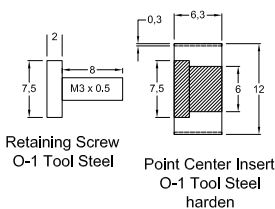
Start with $\frac{1}{2}$ " rod
- 60° chamfer to depth =
pivot Ø x $(\sqrt{3}/2)$
0.6mm pivot on 12mm pitch circle (PC)
other Ø = (0.6 - pivot Ø)/2 + PC
turn to 12.6mm



No.	Pivot Ø	$\sqrt{3}/2$	PC+	12ths
1)	0.10	0.087	0.25	0.00,6
2)	0.14	0.121	0.23	1.21,8
3)	0.16	0.139	0.22	2.43,0
4)	0.18	0.156	0.21	3.64,2
5)	0.20	0.173	0.20	4.85,4
6)	0.24	0.208	0.18	6.06,6
7)	0.30	0.260	0.15	7.27,8
8)	0.40	0.346	0.10	8.49,0
9)	0.50	0.433	0.05	9.68,10.2
10)	0.60	0.520	0.00	10.8,11.4



No.	Pivot Ø	$\sqrt{3}/2$	PC+
1)	0.70	0.605	0.65
2)	0.80	0.693	0.60
3)	1.00	0.866	0.50
4)	1.10	0.953	0.45
5)	1.20	1.039	0.40
6)	1.30	1.126	0.35
7)	1.40	1.212	0.30
8)	1.50	1.299	0.25
9)	1.60	1.386	0.20
10)	1.70	1.472	0.15
11)	1.80	1.559	0.10
12)	2.00	1.732	0.00



Retaining Screw
O-1 Tool Steel

Point Center Insert
O-1 Tool Steel
harden

