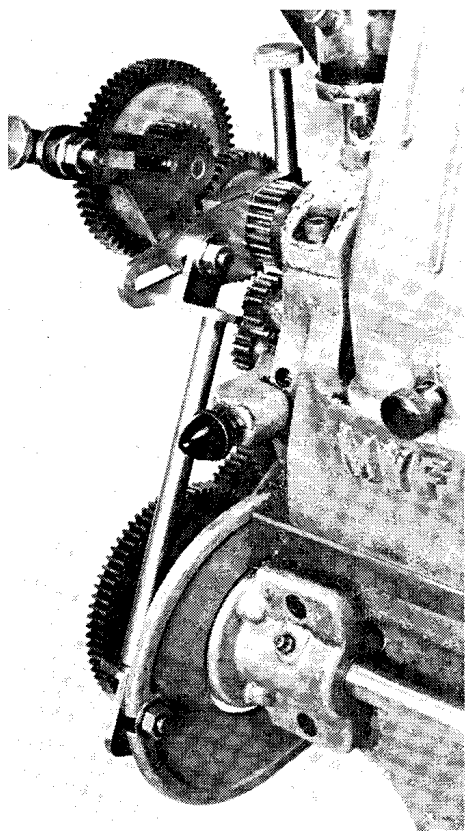


The photograph above shows the additional compound dividing bracket assembled to the original dividing attachment.



On the left, the compound dividing attachment in use on the lathe. The big index wheel is 60 t., keyed to the 25, gearing with 45 wheel on the mandrel. Indexing round by "threes" gives 36 divisions.

the key being silver soldered in a slot milled down the length of the sleeve. In setting up, the compound bracket is positioned for the correct mesh of the extra wheel with the mandrel gear, and the nuts holding the anchor stay fully tightened. Then the detent block is positioned relative to the indexing wheel.

The proportions shown allow of any standard ML7 wheels to be used. Should some odd numbers of divisions be required that necessitate the use of

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TABLE I

Selection of numbers possible only by compound dividing.

No. of Divisions	Mandrel Wheel	Second Wheel	Index Wheel	Index Every
16	50	25	40	5
18	40	20	45	5
21	60	20	35	5
22	40	20	55	5
24	40	20	60	5
26	40	20	65	5
27	60	20	45	5
28	40	20	70	5
32	40	25	60	3
33	60	20	55	5
36	45	25	60	3
39	60	20	65	5
42	60	20	70	5
44	40	50	55	1
48	40	50	60	1
49	35	50	70	1
52	40	50	65	1
54	30	25	45	1
56	40	25	35	1
57	60	20	38	2
63	35	25	45	1
*64	40	25	40	1
66	30	25	55	1
72	30	25	60	1
76	40	20	38	1
77	35	25	55	1
78	30	25	65	1
80	50	25	40	1
84	35	25	60	1
88	40	25	55	1
90	40	20	45	1
96	40	25	60	1
98	35	25	70	1
99	45	25	55	1
100	40	20	50	1
180	75	25	60	1

*A number used by clockmakers, requiring a second 40 wheel.

