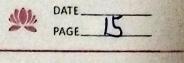
	Exposement-6
	<u>Mim</u>
	To perform job snvolving turning (Step & Tapon), Knurling & Grisoving Practices on Lathe machine.
	Materials Required
	Mild Steel Round Bour (200 mm)
	Tools / Equipment Required
9) 4) 127) 90)	Contre Lothe machine N Tool post spanner Right Hand side cutting tool vi) Steel trule Vinape outting tool vii) Outside calliper Knurling & Grooving tool viii) Surface gouge
	Procedure
1,	Hold the mild steel job properly in the chuck
۵,	on lathe machine, check position of job should be in the centere of check position of job should be in the centere of check withing on the machine, see visually the approve control of the job.
3,	After owitching on the machine, see visually the
	switch off the machine & mound tool but in tool port in proper position. Should be well thantened and the of the tool coincide with centre of the Job.

5,	Lit come about 30-40° with the gob,
	Sit come about 30-40° with the gob,
6.	Then feed the tool post towards the gob with the
	Then feed the tool post towards the gob with the help of cross suide till the tip but reach at
	coron of son, in blocks of motal trompular is ladia
TI	in sid carriage anto position, wow that the
	comb. Steet sty downed andle, And land the down
	store stude with the hold of chair ille stamper
	Angle of Japon tan az n-d , dz small dist.
	Angli of Japon, Jan a= 0-d , d= small dist.  22 D= Jarge diameter
	2 2 Longth of Japen
gr.	After growing engage back gear 8 reduce the speed of stindle and replace the growing tool but with knowling tool bit and prox it over the
	speed of spendle and replace the growing tool but
	with knusling tool bit and pross it given the
	sid are to knulled
d.	for threading, engage the feed rod lover & subable gears in proper way, etc. Now threading tool will be moved with the help of haf nut dover
	giars on propor way, etc. Now threading tool
	will be moved with the help of haf nut dover
	0
	Result
	The various machinen operations had performed on
	Lathe machine.
	$\Omega$ 10 -
	Procautions
	Use proper feed to tool bit along with app. speed.
<u>ک</u> کر	Adopt always right tool & right mechanism. Threading & knurling should be done on min, Speed along with sufficient cutting fluid 1 epolant, etc.
	along & knulling should be done on min, Speed
	and sufferent century fine / exolant, etc.

	Ex periment-7
	Asm V-Arsone proposation on the shaper.
	Materials Required Mild steel round bor (60mm × 40mm)
9) 16) 169)	Tools Required Shaker Machine is Surface plate and scriber Vishake cutting tool V Hammer & centre punch Spanner Set
3) H)	Perocedury  Clamp the woork piece In the rice & dight it properly.  Then, adjust the stroke of nam, adjustment of stroke is mode such that the tool crose the gob completely & after that 10-16 mm of charance should be provided.  Then, give the speed to the tool & feed should be given nominal.
	Result The rugid. V-groove has been prepared on the shaper.
9) 18)	Procaution The job should be clamped Alghtly in the vice port stand in front of the ran whele running

all be nothing et the ant took took 12. 1 104-08 trade and buy our the gob with a to Will rebuils evador with you the test well and parties the test of the last same agriculture. at art beef book along business of these wife b, about were go good out offer dep out on eite Mome = 17, 18-0, sprot, regist. 18 mp molls repol / of 12 4 10 ter greening engage door en Love de landed. been book with apopyon pubbonent. t probable with the help of the broom, still you beneated but watered openion to paramed one and the second s



189	Tool should be stightly fixed, Dotth of cut should be minimum, Caohnt should be supplied continuously during Stroke should be adjusted properly.	
90)	Dobth of cut should be minimum,	114
i)	Cooper' should be supplied confinuously during	eutting
(1/	Stroke should be activised properly.	V
	1/108	
	16 12	