



SCHSM

Southern California Home Shop Machinists

October 3, 2015

OFFICERS

President Michael Vulpillat
Vice President Paul Chretien
Secretary Ken Rector
Treasurer Jim Endsley

COMING EVENTS

Little Machine Shop Open House
October 24, 2015
Noon - 5:P.M.
396 W Washington Blvd #500
Pasadena

November Meeting
November 7, 2015
2:00 P.M.
El Camino College

Holdridge Shop Tour
November 14, 2015
10:00 A.M.
15224 Figueroa St.
Gardena

December Meeting
December 5, 2015
2:00 P.M.
El Camino College

Preface

The October monthly meeting of the Southern California Home Shop Machinists convened at 2:00 P.M. on October 3rd, 2015 in classroom AJ115 on the first floor of the Industry and Technology Building at El Camino College in Torrance California. There were 33 people in attendance. There were no new visitors this day. Vice President Paul Chretien conducted the meeting this month in the absence of President Vulpillat.

Holdridge Manufacturing Tour

Doug Walker reminded us of the tour of the Holdridge Manufacturing Company shops on Saturday, November 14th. Holdridge manufactures a well regarded radius turning attachment widely used by industry. Their facility is located at 15224 Figueroa Street in Gardena. We will meet at the facility at 10:00 A.M.

LMS Open House

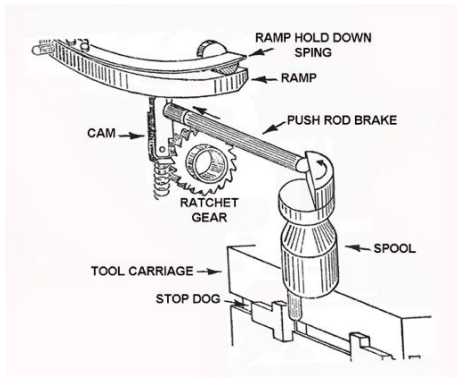
Our club has been invited to participate in the LMS Open House again this year. The event will be held on Saturday, October 24th. The event starts at noon but we should plan on being there early in the day to set up our display. Vice President Paul Chretien spoke about the benefit to our group of participating and encouraged all members to attend. He stressed that every member has something of value to display. Paul appointed Willie Jordan and Lewis Sullivan to coordinate the support props we will need for our display.

The LMS folks will provide plenty of shaded tables for our displays as well as sandwiches, drinks and door prize raffles. You can find LMS goods on sale as well as Tormach, DRO Pros, Metal Arts Press and other vendor's stuff. Visit the LMS Open House web site for more information.

Automatic Boring Head Presentation

The afternoon presentation was a talk by Jim Long about the Enco Automatic Boring Head. Jim described the design and features of the tool and how he tuned it up for use in his shop. His presentation included slides and drawings showing the internal parts of the tool and he passed the tool around for a closer look by the audience. Most interesting were the internal ramp dogs that control the automatic advance that Jim modified on the surface grinder to give better operator control. He explained how the ramp system operates to control the cutter advancement. The tool has other uses than just boring. It can be used for facing, cutting external surfaces, radius cutting and internal





grooving. The automatic adjustment is controlled by gripping the knurled ring, or using a reaction bar for production jobs. Jim finished up by showing how he cut a six inch radius across a flat plate. This was a very interesting and well documented talk about a tool that is not normally found in a home shop.

Show and Tell

Jim Endsley showed a Coehorn mortar he is building. The Coehorn was a portable mortar developed in the Netherlands by Menno van Coehoorn in 1674 and in use from the seventeenth to the mid nineteenth centuries. The coehorn was designed to be movable by as few as four men. By the time of the American Civil War, it was in service with both armies in twelve (4.62") and twenty-four pound varieties. It fired an explosive shell. Jim told how he bored the barrel using a small Harbor Freight boring head to finish the 1.68" diameter

golf ball size hole. Four!

Ron Gerlach brought in the intake and exhaust valves with their cages from a large engine he is restoring. He told how he fabricated the valve stems for the 3" valves and attached them to the original heads by peening. He reground the valves on his Sun Valve Grinder. He rebored the guides to fit the new stems and ground the valve seats on his lathe. This is a 16 HP single cylinder engine with 7" x 12" bore and stroke. Cabang, Cabang, Cabang!



Dan Snyder showed a spiral fluted tap he has been using. These taps are used to produce a thread close to the bottom of a blind hole and therefore have a very short lead. The right hand spiral cut of the flutes acts to force the swarf away from the cutting teeth to the rear of the flutes and out of the hole. They are better on materials which form long continuous stringy swarf, rather than chips. They are also better to tap a thread in a hole where there is a break in the material, e.g. another hole, as the spiral fluting helps the tap to pick up on the other side. Spiral flute taps can have slow or fast helix angles. Slow spirals are used for non ferrous materials, and fast spirals for most other materials.

Jerry Lake spoke about piston ring and compression problems he encountered trying to get his Webster engine running. Several other members joined in a discussion about ring fabrication, cylinder boring and honing and related operations.

Westec Report

The semiannual Westec Exhibition was held on September 15-17 at the Los Angeles Convention Center this year. Members Phil Ruben, Pat Dobbins and Willie Jordan told their impressions of the show. They all agreed it was interesting with plenty to see, but it was much smaller than in the past.

The meeting ended with a discussion about how our group's displays at various shows can benefit our club.



The SCHSM welcomes presentations by members or guest speakers on any subject related to metal working activities. If you have some knowledge or experience you feel may be of interest to our members, or if you know someone that may have something interesting to relate, please consider making a presentation at a meeting. Presentations may be a little longer and more detailed than a show and tell and may be accompanied by slides or video, or physical displays. Probably every member has some experience they can share and this is the purpose of the SCHSM. Please contact President Michael Vulpillat to make arrangements to give a presentation.

The SCHSM meets in class room AJ115 on the first floor of the Industry and Technology building of El Camino College, 16007 Crenshaw Blvd. Torrance California, at 2:00P.M., on the first Saturday of every month. The building is near Parking Lot B. Enter the campus on Manhattan Beach Blvd.

If you would like to contribute an article, to this newsletter, please contact the editor, Ken Rector, via the SCHSM Yahoo Group, or at kdrhoo@yahoo.com.

Find us on the web at www.schsm.org.