

LATHE TOOL BIT DESIGN  
 OFFICIAL A.S.M.E. DESIGNATIONS OF TOOL BIT ANGLES

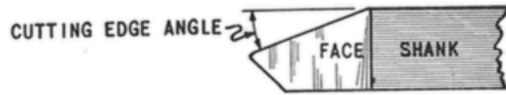


FIG. 38A

Tool bit angles with the tool bit horizontal and at a right angle with the centerline of the work.

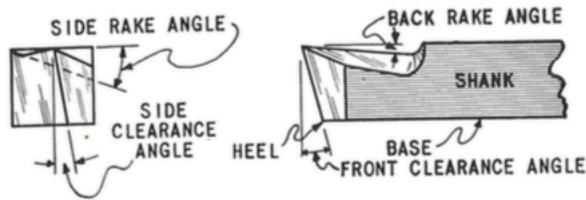


FIG. 38B

Tool bit angles as designated for use in the tool holder.

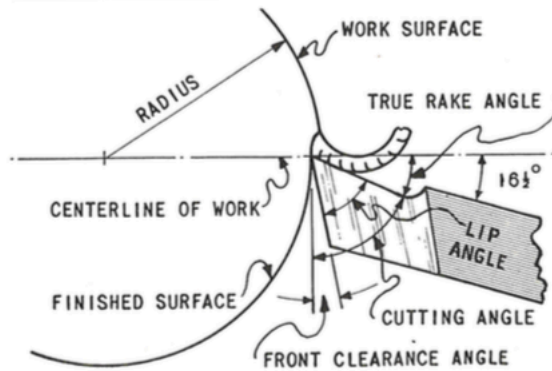
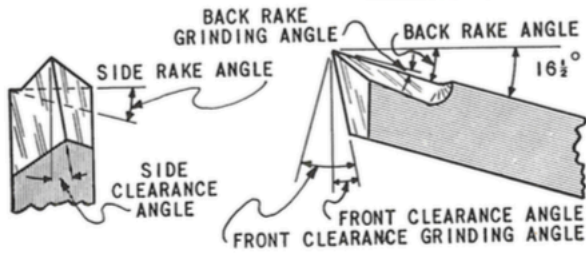


FIG. 38C

Angles of the tool bit in relation to the work.

## TOOL BIT SHAPES FOR USE IN THE TOOL HOLDER

The five standard tool forms on these two pages will be found suitable for most lathe turning. When grinding tools for special work, simply keep in mind the shapes and angles recommended for general turning and apply these principles to the special tool being ground. See the examples on page 41.

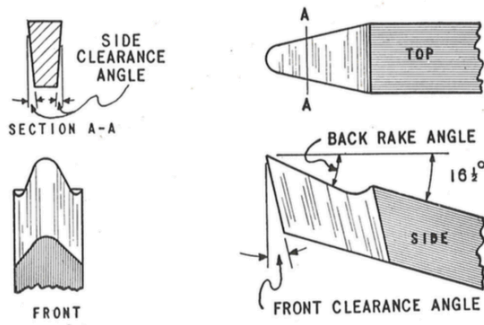


FIG. 40. Round Nose Cutting Tool suitable for roughing and general purpose turning.

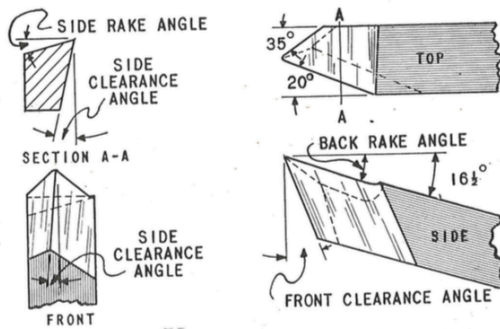


FIG. 41. Excellent R. H. Tool for general turning and shouldering toward headstock; also facing. Point should be rounded for finishing work.

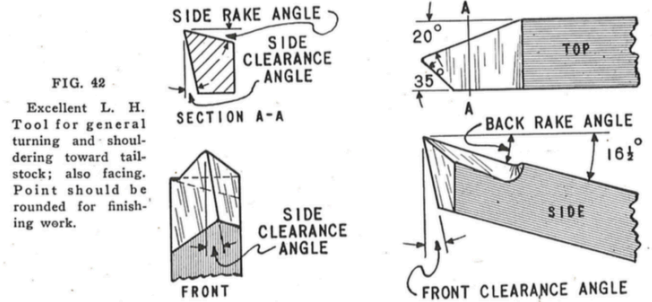


FIG. 42. Excellent L. H. Tool for general turning and shouldering toward tailstock; also facing. Point should be rounded for finishing work.

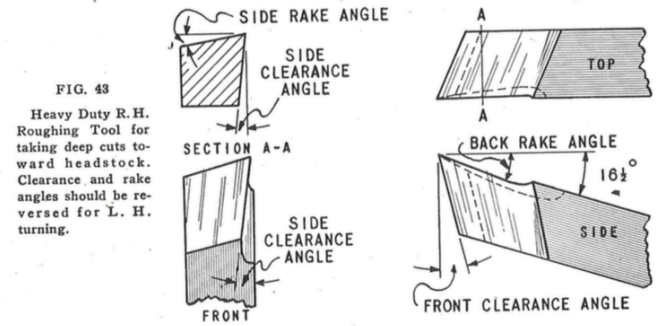


FIG. 43. Heavy Duty R. H. Roughing Tool for taking deep cuts toward headstock. Clearance and rake angles should be reversed for L. H. turning.

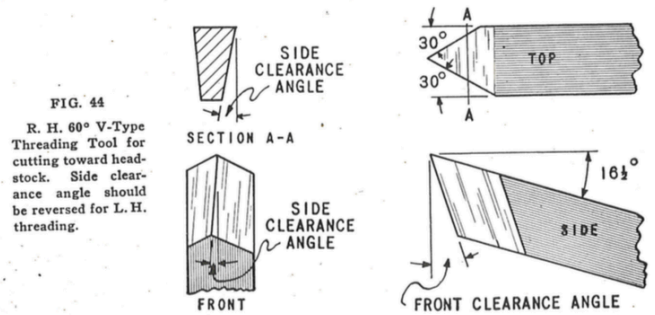


FIG. 44. R. H. 60° V-Type Threading Tool for cutting toward headstock. Side clearance angle should be reversed for L. H. threading.