





tool post and holder, Fig. 3, permit the top surface of the slide to be cleared for clamping down work to be milled. For this use, the spindle rotation is reversed, the work is fed with the cutter teeth pushing toward the travel and pressure, and the speed is reduced greatly. About 60 r.p.m. works well with small cutters. It is important that the work be fed to the cutter uniformly throughout the length of the cut. Any irregularity in the feed is likely to cause breakage.

## Bluing and Blackening Brass Ware

Brass articles may be given a blue or black color by first cleaning and then immersing them in a solution made by dissolving hypo, 1/2 lb., and lead acetate, 2 oz., in 1 gal. of water. More lead acetate may be added to deepen the color and to speed up the action. To use the solution, heat it almost to the boiling point and immerse the work, watching carefully to remove it when the color is of a suitable shade. Brass wire should be used to suspend the work in the solution, and the finished work should be protected with clear lacquer to preserve the finish.

due to the fact that a half thousandth cut on the radius reduces the diameter of the work twice that amount. The swivel turret may also be marked or scribed in degrees for accurate work. The removable