

MOLDING CUTTERS.

THE care and skill required in fitting up a pair of molding cutters so that each may be the exact counterpart of the other and perform the same work in every part, and still be in perfect running balance, has led many operators into the pernicious practice of using but one perfect cutter and upon the opposite side of the head a piece of iron of the same weight, to act as a counterbalance. If this were a practical thing, and the feed reduced accordingly, there would be no particular objection to this practice, but it is simply impossible to properly balance a cutterhead in this manner. A standing balance may be obtained in this manner, but a running balance never. To obtain a running balance the counterbalance must not only be of same weight but every part of it must revolve in the same circle, for the centrifugal force of a body moving with different velocities in the same circle are proportioned as the square

of the velocities, and a body revolving 1,000 revolutions per minute has four times the centrifugal strain as one revolving 500, while the centrifugal force of two unequal bodies moving with unequal velocities and at different distances from the center, are in compound proportion or ratio to the quantity of matter and the square of their velocities. So it is evident that, though the weight of the counterbalance may be the same as the cutter, still as the shape is not the same and every part of it can not revolve in the same circle, a good running balance is out of the question.

SPLIT PULLEYS.

HAS it ever occurred to you, says a writer in the Iron Trade Review, that there are some methods coming into vogue that are cheaper in the long run to use than to be without? Among these is the split pulley. It costs money, and big money, too, at times, to cut a key-

way in a shaft when a new pulley is to be located. Have you ever used a good split pulley? If not, do so. A short time since I fitted out a whole shop with pulleys and shafting, and used nothing but split wooden pulleys. Hold? Well, not at first. Each pulley was tightened as well as we could do the work at the start and then watched. At the first indication of a slip the wrench was put on again and that settled the matter for all time. I had those pulleys driving every conceivable kind of ironworking tool, from a light drill to a heavy hammer, and never had the slightest indication of trouble. Then, when new tools were bought and old ones had to be shifted, ten minutes sufficed to take down the pulley. But when I did that job, I did not know as much as I do now. I allowed builders to sell me tight and loose pulleys on the counter-shafting, so that for every machine having a four-inch belt I had to buy a nine-inch split pulley. In future I will specify clutches.

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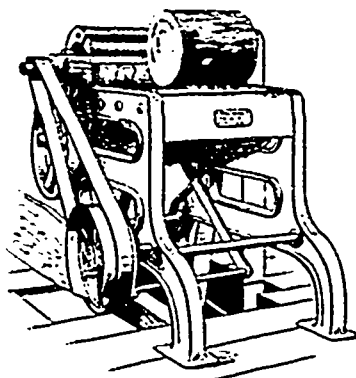
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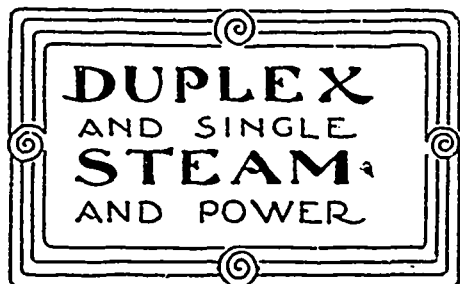
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