

lumps which may appear on the particular edge and which you were unable to locate when holding the straight edge across the entire width of saw. When holding the straight edge $\frac{3}{4}$ the way across the blade, the light should not show as deep under it as when holding it across entire width of blade, because when holding it across entire width of blade, both ends or straight edge are resting on the two tires or thickest part of saw, and when holding only two-thirds the way across the blade only one end of straight edge is resting on the tension or thin part of saw. In like manner go over the entire inside of saw, after which put it down on the bench "on the bottom" and go over the outside of saw in the same manner as with the inside, always bearing in mind how much light showed under the straight edge when you were leveling the inside and trying to equalize same when leveling the outside of saw, being especially careful to have no light show under straight edge on either side of saw from where the tension terminates at the edges. If you are not satisfied that you have the saw sufficiently level to ensure its doing good work after going over each side, repeat the operation until you are satisfied.

The most important part of bench work is to have saws level. For this work I have a cast iron leveling slab about 3x12 inches by 6 feet. This slab has a perfectly straight and level face, both lengthwise and crosswise, and forms a part of my bench. I use a 14-inch straight edge to level by, which I am very particular to see is straight at all times.

When do I put the tension in a saw, or go over it to equalize the tension? Answer, after leveling my saw on the inside the entire length and while leveling the outside. I level a section on the outside and then try the tension gauge on that section. If any tight places appear, I roll them out, after which I again try my straight edge to that particular part, to see if in putting in the tension my roller has punched through or pulled up that particular part of saw rolled on. If pulled up, I again level and try tension; if punched through, I mark saw with chalk on the other side at that place, so I may know the cause of lump when I come to level on the other side again, which I would certainly have to do.

I have had men tell me it was not the fault of the roller that the saw was punched through or pulled up. To others of the same opinion I would advise them to try a saw on a roller which has a top roller with a more crowning face than the bottom, and see if the saw is not pushed through, or with the rollers vice versa, and also notice if the saw is not pulled up. I have my saw lying perfectly flat on the bench (the bench is in perfect line with the top face of bottom roller) when rolling in tension.

In sharpening, a single cut sharpener equipped R and L hand is preferable to use of two separate sharpeners, for by using the same machine for sharpening each edge of saw, you are certain to obtain the same shape and hook in the teeth on each edge, consequently both edges, if properly gone over on the bench,

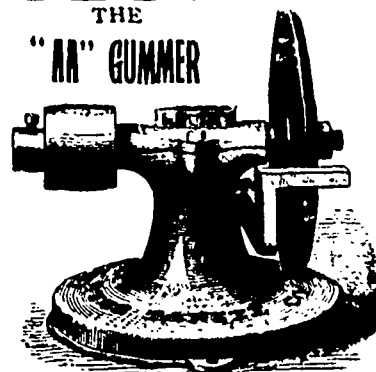
would stand the same amount of feed. Moreover, in such case your swage will swage alike the teeth on both edges of saw. Always go over a newly swaged saw with a set gauge, making sure that the teeth are all perfectly straight.—From Baldwin, Tuthill & Bolton's Catalogue.

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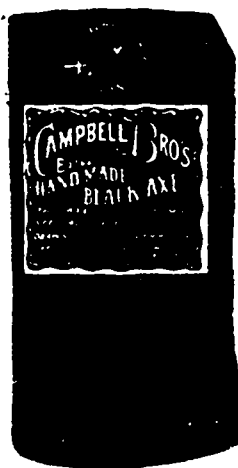
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