

25TH SEPT

It was all going so well!! Until I went into the workshop - - - all manner of 'silly' errors today. The first was a blank positioning mistake I forgot that the 'ridge' in the table (being used as a datum) is 25mm to the right of the 200mm limit so the first cut was out by that amount. I didn't appreciate it until I came to cut the top end of the rear frame and the tool came down to cut air beyond the left hand end of the blank.

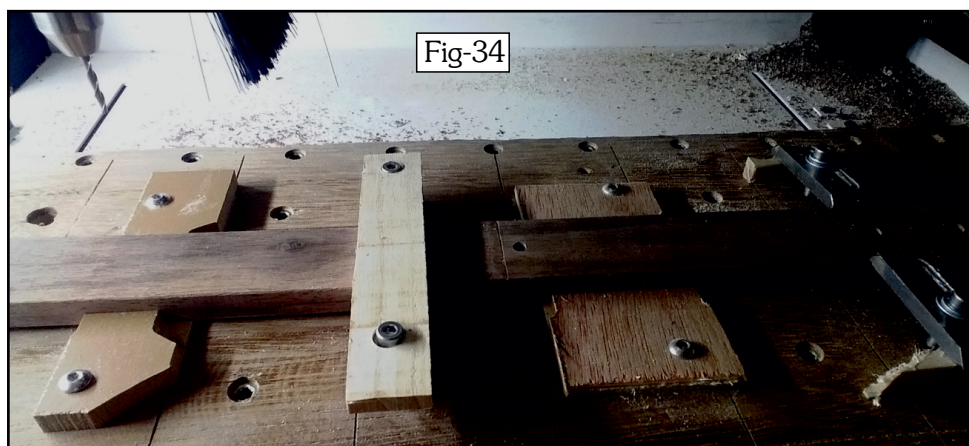
Having corrected that I quickly machined the other three blanks - even avoiding the mistake of cutting one slot on the wrong side — or so I thought — I'd actually cut a different slot (joint) on the wrong side, not that it matters a great deal it just means that the mating part will cross in front rather than behind.

While the Denford was doing its thing, rather than twiddle my thumbs I looked at recovering the mistake I made on the first blank which wasn't sensible so I started again but needed two shorter lengths joined. Taking each to the Linisher to create a 'clean' face and then to the Mill to make a scarf joint would you believe that I cut the waste away from the same side of each so when joined I had each side with a mixture of 'fair' and 'foul' faces! There was enough meat to allow a clean-up on the thicknesser but it still gauls.

I now have the first side of the Rear Frame [A] nearly complete – I'd forgotten to draw in a modification I made when I added a bracing piece so I need to cut another slot but Fig-33 shows the current state of three of them, The other is set up on the Denford table ready for the second side to be machined.



Positioning the work for a second - opposite side - machining operation can be tricky and needs some thought. In this case I need another joint to be exactly in line with the wider joint in Fig-33 so it made sense to devise a means by which that joint became the 'datum'. It also made sense to use the narrow joint as a secondary locator so using a couple of scrap blocks fixed to the table I created G-Code to machine those as the opposite of the joints. Although they are a good tight fit, clamping in a



similar fashion is still needed and Fig-34 shows the fourth Frame upright ready to be worked on tomorrow.

26TH SEPT

Whatever it was that I said about my mis-fortunes today didn't really need to be shared!! It seems that while this file was being auto-saved I had a 2 second power-out and the words of wisdom I'd already penned are

lost – I also lost 4 hours work in CamBam so I've now found out that CamBam does not have an auto-save facility - except as a 'Plug-in'.

The work I lost is on the next component I thought about making which is the Ratchet & Pawls made from African Leadwood. A number of issues arose when creating the basic blank billet which turned out to be non parallel. Not by a great amount (10.5 - 12mm) but sufficient to cause me to take account. As it happens the Ratchet is only 9mm thick and the Pawls are <5mm so I can get all the parts out with appropriate care.

When I'm working in CamBam it has been my habit to jot down the various surface levels on the back of an envelope so that I know what figures I need to enter but, due to the need to be particularly cautious regarding the positioning of these components in the Z axis, I was more fastidious and did a detailed scale drawing. Fig-35 shows this.

Clamping this blank to the Router Table presents some problems since I need to skim the surface so the one clamping screw I can get in needs to be recessed - Fig-36 is a plan view to show the position of the components and clamping.