Contents

PREFACE TO THE FOURTH EDITION	PAGE
PREFACE TO THE FIRST EDITION .	vi
CHAPTER I	
Introduction Difference between jig and fixture—Jig borers—Principles of jigs and fixtures—Economic principles—Principles of design—Locating work—Use of V blocks—Efficient clamping—Jig legs, bushings and latches—General considerations—Prize-winning jig design.	3
CHAPTER II	
Points to be considered—Standard drawing practice in jig and fixture work—Lines and line work—Standard section lining for different materials—Revolved and other sections—Dimensioning dimension lines, and figures—Holes, tolerances, and fits—Finish marks and tapers—Screw threads, bolts, and threaded parts—Thread symbols—Pipe threads—Standardized drawings—Symbols for castings and bar stock.	r , 1
CHAPTER III	
Advantages of Tool-design Standards	42
Standard parts for jigs—Standard wrenches, knobs, ball crank, and machine handles—Pilot-wheel spokes and star knobs—Jig-lid stops—Guide pins and bushings—Jig feet—How jigs are standardized in one shop—Locking knuckles and latches—Die sets.	S
CHAPTER IV Drill-jig Bushings	. 75
Tables of standard bushings—Wear bushings, press fit, and renewable. Linear bushings—Bushing specifications—Jig plate thickness—Special bushings—Bushings for two holes—Bracket bushings—Removable slip bushings—Screen bushings.	ł e
CHAPTER V	
Types of Drill Jigs and Fixtures	85
Rotary fixtures—Tables and latch jigs—Wedge, eccentric, and sliding plate jigs—Double, cross-hole, and large revolving fixtures—Cradle and knee-type rotary fixtures—Pilar fixture.	

viii	CONTENTS	
• •	CHAPTER VI	PAGE
MACHINE VISES AND		. 91
Wedge and V-jav equalizing jaws— lating nuts—Jaw jaws—Vise-jaw	ws—Angular and contour jaws—Compensating of Hold-down and special jaws—Holder for caste is for holding pins—Straddle jaws—Aligning vise milling fixtures—Indexing in machine vise— Time-saving vise for drilling—Simple milling	or l- se
Vise.	CHAPTER VII	
		. 109
for detent contribution for detent contribution. Business Ball equalizer collids—Stop pins for stop motion—In—Stud and blobushings—Adjushandles—Laying	ting plungers—Detents for holding bars—Spring col—Hinge designs for fixture lids—Center-type ded hinge pins—Shouldered rivets and screws-menections—Universal joints—Ball-bearing fixture indexing—Pawls used in indexing—Geneva-type dexing pins and methods—Mistake-proof fixture ck fastenings—Profile for setting work—Group table screw and slip bushings—Thumbscrews and court a drill jig—Standard T-slots, cutters, and tongues and splines.	e e e e p p d
	CHAPTER VIII	
LOCATING SCHEMES	FOR DRILL JIGS AND FIXTURES	. 147
adjustable stops Self-aligning fix locking devices used in locking p Lock nuts and o	entering work—Use in large jigs—Stationary of s—Locating and locking work simultaneously-tures—Jack screws and jack pins—Springs an —Self-locking jack—Multiple clamping—Screw parts together—Clamps for holding tools or work-expanding collars—Other types of locking device essure on several parts.	- id vs -
	CHAPTER IX	
CLAMPS AND CLAMP	ING METHODS	. 166
clamps and stra Side and toe	mps—Clamping three pieces with one bolt—Lev ps—Latches and hook bolts—Eccentric clamps- clamps—Nipping blocks—Cam-shaped clamps- locks—Spring pins—Jig clamps and lids—Di	_
grooves—Drill Clamps that sa latch jig—Stocl	jig lids—Equalizing clamps—Clamp details- tive time—Advantages of latch jig—Examples k parts of latch jigs—Clamp bushings—Sizes —Ball nut handles—Drill jig for ball rods.	of
	CHAPTER X	
DRILLING JIGS AND	FIXTURES	. 204

Rigidity—Chip clearance—Bushing dimensions—Coolant space—Angle blocks and wedges—Cross holes in round stock—Two-

CONTENTS	

ix

	Page
position drill fixture—Jig for cotter-pin holes—Self-adjusting jig—Combination clamping—Jig for center drilling—Drilling two parts at once—Drilling and reaming fixtures—Large indexing fixtures—Key-locked jig—Aluminum jig—Guide jig for matching oil holes—Roll-over jig—Right-angle drill jig—Drilling mica—Adaptable drill jig—Parallels for drilling—Cooling drills—Universal jigs—Radical drill fixtures—Unusual boring fixture.	
CHAPTER XI	
MILLING MACHINE FIXTURES	233
Right way to clamp work—Slot milling fixture—Two-operation fixture—Universal screw-slotting fixture—Indexing fixture—Substantial dividing head—Turtleback fixture—Automatic indexing fixture—Multiple indexing fixture—Another type of cam lock—Profiling fixture—Semi-automatic plate indexing head—Milling steering knuckles—Fixtures for milling contours—Slide milling fixtures—Holding two pieces at once—Group milling fixtures—Milling in two planes—Double-head milling—Four-spindle fixture—Splitting bearing blocks—Gang milling—Using straddle mills—Circular milling fixture—Rotary-type fixture—Continuous milling—Radius and form milling—Screw-slotting fixture—Equalizing jaws for rough work—Fixtures for profiling—Milling machine fixtures.	
CHAPTER XII	•
Grinding-machine Fixtures	
CHAPTER XIII	
WELDED, CAST-IRON, AND LIGHT METAL FIXTURES	296
Cast-iron tools—Welded tools—Welding equipment—Money saved by welded fixtures—Efficient jigs of welded steel—Locating by tongues and screws—Lightweight jigs and fixtures.	
CHAPTER XIV	
PNEUMATIC FIXTURES FOR HOLDING WORK	310
Holding weak pieces of work—Other pneumatic milling fixtures—	
Positive pneumatic clamping device—Changing hand fixture to use air—Air applied to large fixtures—Air fixture for connecting rods.	
· CHAPTER XV	
FIXTURES FOR INSPECTION WORK	323
Inspecting hole location—Inspecting jig-bushed holes—Inspection fixture for sprockets—One- and two-handed fixtures—Application of gages—A cutter setting gage—Gages used in drilling.	

X	CONTENTS	
	CHAPTER XVI	Pagi
System	IN THE TOOLROOM	333
To	cords and drawings—Tool-designing department accessories—ol record and operation sheets—Card files—What do jigs and tures cost—Detailed cost sheets.	
INDEX.		349
WARTIN	ME DATA SUPPLEMENT	355
Ass wir the	sembly-fixture construction—Mating or locating jig for bomber ngs—Large fixtures used in air-frame work—Jigs and fixtures for a Thunderbolt—Tube-welding fixture—Huge assembly fixtures bombers—Fixture for adjusting control surfaces.	
INDEX	TO THE WARTIME DATA SUPPLEMENT	373