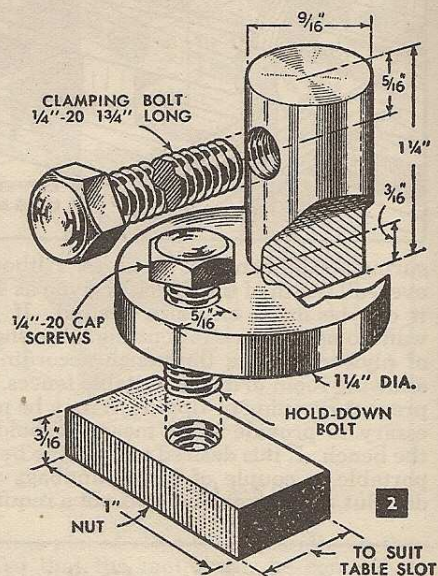
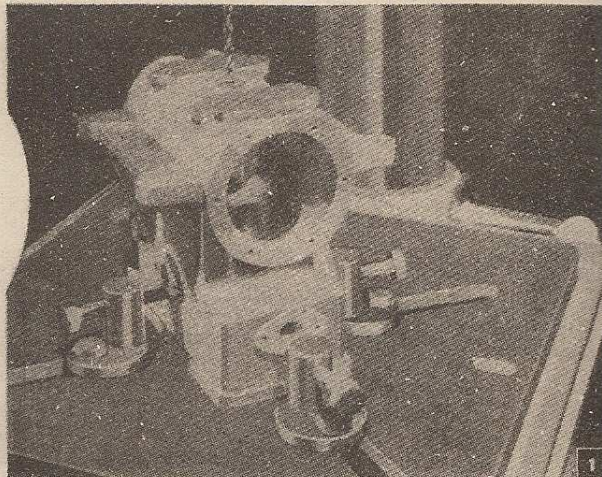


Quick-on

DRILL-PRESS CLAMPS

By Will Thomas

These clamps are so designed that they drop into the slots in the drill-press table and can be tightened in a jiffy. They are especially handy when doing close work because it's never necessary to remove nuts and washers from bolts that project under the table. As you see in Fig. 1, the individual clamps can be set in various positions to hold work which is irregular in shape. Fig. 2 details one unit, and you can make as many as you need by simply duplicating parts and operations. To make duplicate clamps, chuck 1½-in. round cold-rolled stock off-center as in Fig. 4, carrying the outer end of the piece on the tail center. Turn to the dimensions given in Fig. 2 and you have four cam shapes as in Fig. 4. Saw these apart, then drill and tap for the clamping bolts, Fig. 3. The rectangular-shaped nuts, Fig. 2, are cut from ¾-in. flat steel and finished by filing. Be sure that the nuts slip through the table slots. Drill and tap nuts exactly in the center so that strain is equalized when the bolts are tightened.



Clamps also can be used on a milling machine or lathe faceplate to hold irregular-shaped work

