

A rotating center that is also used to support work from the tailstock. However, because it rotates with the work, there is no need for lubrication of the actual center.



HALF CENTERS

When a Morse taper is supporting work at the tailstock and it is very difficult to machine the end face of the work as the tool hits the circumference of the center, before reaching the middle of the work, in those cases we use what are known as half centers. These can be bought but many people prefer to make their own, doing so in a useful way of using an old center that has become well worn. Half centers have the point reduced to nearly half the original diameter. Unfortunately it is not practical to reduce them to an absolute half as in doing so the support they supply would be lost. This means that the tool still cannot be taken absolutely to the center of the work, but it will be very close and the diameter of the hole in which the half center engages may be sufficient to allow the work to be completely faced off. How close one can get to the work center will depend on the tool. A normally ground right hand turning tool will tool a half center and so if facing off work that is supported in this way it will be necessary to grind a special tool to do the work.

ROTATING CENTERS

Centers set in ball races and mounted on Morse tapers are known as rotating centers for the obvious reason that they rotate. They are used instead of hand centers to support work from the tailstock. There is less wear on a rotating center than there is on a hand center, if they have an Achilles Heel it is the fact that the housing of the ball races is frequently too large to allow machining to take place at the very end of the bar. This apart they are an extremely useful accessory to have, unlike the ordinary hand center, which can bind up to the point of welding, this does not happen with the rotating center.



Another type of rotating center and known as a pipe center as it is intended for supporting work with large tapers.



The parts of a homemade pipe center, showing the ball race that allows the head to rotate.

OTHER CENTERS

There are other types of center used as supports, although they are not often seen. The most common is probably the pipe center, which is a rotating center but with a very large angled section, the angle of which is steeper than that of a normal center. They are intended to support large diameter tubes or hollow work and are available in a variety of diameters. The reason for the steeper angle is to allow them to be brought nearer to the work than would be practical if the point was set to sixty degrees. It is essential when using one to make sure that the end of the work, to be machined, is running true, if it is

skewed in any way the center will throw it out of alignment and defeat the very purpose for which it was intended.

Virtually the reverse of a normal center the hollow center is used to support work that cannot be supported by a normally shaped center. A typical example of this would be a piece of work that had a domed or pointed end. Sometimes a ball shaped center might be used to support particular work, especially if the work has a large hole or is hollow and it is not unknown for a hollow center to have a ball bearing temporarily set on the end in order to perform the same function.



The pipe center in use. Note that, in this case, the pipe has previously been plugged with wood because the pipe is of this soft copper and applying pressure with the center could possibly cause it to bel out.

Basic Lathework For Home Machinists

Xiang Xie



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