

POSITIONING JIG FOR OPEN SEGMENTED CONSTRUCTION

A= $\frac{3}{4}$ " plywood 4" wide by the height of lathe axis less $\frac{1}{16}$ " (ie. $5 \frac{15}{16}$ " for a 12 inch lathe)

B= $\frac{3}{4}$ " plywood 8" x 8"

C= $\frac{1}{4}$ " to $\frac{1}{2}$ " thick x 8" long and just wide enough to fit between ways of the lathe. Can be plexiglas, nylon or plywood screwed to underside of "B" along the lathe axis. Part "C" should allow the jig to slide smoothly along the ways of the lathe without much side play.

D= $\frac{3}{4}$ " plywood clamp held in place with $\frac{1}{4}$ -20 bolts that can be tightened and loosened with wingnuts.

E= 1"X1"X $\frac{1}{16}$ " thick Aluminum angle 6 inches long screwed to headstock side of "A" so the leading edge lines up with the center line axis of the lathe. The top edge of "E" should be about $\frac{1}{16}$ " above the top of "A".

Notes: These dimensions are about right for a 12" lathe. All dimensions may be scaled up or down for larger or smaller lathes. Only critical aspect is the alignment of the front/top of "E" with the axis of the lathe and that the jig can slide smoothly along the lathe ways without much side play. On larger lathes a couple of 3"x3" corner gussets can be added at the intersection of "A" and "B" to stiffen the jig.

