



**Turning and mechanical manipulation Volume 1 ;  
intended as a work of general reference and  
practical instruction, on the lathe, and the various  
... their differences, choice and preparation**

*Charles Holtzapffel*

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This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1843 Excerpt: ...sledge hammers, a heavy mass being in some cases held against the opposite extremity to sustain the blows; the heat is kept up, and the work is ultimately withdrawn from the fire, and finished upon the anvil. The butt joint is materially strengthened, when, as it is usually the case in the paddle shafts of steam-vessels and similar works, the joint whilst still large is notched in on three or four sides, and pieces called stick-in pieces, dowels, or charlins, one of which is represented by the dotted lines, are prepared at another fire, and laid in the notches; the whole, when raised to the welding heat, is well worked together and reduced to the intended size; this mingles all the parts in a very substantial manner. For the majority of works however, the scarf joint, fig. 116, is used, 222 T FORM AND CORNER JOINTS. but the stick-in pieces are also occasionally employed, especially where any accidental deficiency of iron is to be feared. When two bars are required to form a T joint, the transverse piece is thinned down as at a, in fig. 120; for an angle or corner the form of b may be adopted; but c, in which each part is cut off obliquely, is to be preferred. The pieces a, b, c, are represented upside down, in order that the ridges set down on their lower surfaces may be seen. In most cases when two separate bars are to be joined, whatever the nature of the joint, the metal should be first upset, and then set down in ridges on the edge of the anvil, or with a set hammer, as the plain chamfered or sloping surfaces are apt to slide asunder when struck with the hammer, and prevent the union. When a T joint is made of square or thick iron, the one piece is upset, and moulded with the fuller much in the form of the letter, it is then welded against the flat sid...

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**Larry Turner:**

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