# Bench Drill Manual

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PREFACE SINCE the publication, in 1888 and 1895 respectively, of David Adamsons Treatise on the Art of Fretsawing and Marquetry, and D. Dennings book on the same subjects, fretworking has considerably advanced factories have sprung up for the manufacture of tools and machines saw-mills have been specially set apart for the cutting, planing and finishing of the various woods periodicals published for those interested in the art designs of surpassing excellence produced labour-saving devices brought upon the market and what is more important, rapid improvements have taken place in the manufacture of saw-blades, and the cheap German saws which once had the monopoly of the market have been largely surpassed by improved and swiftcutting blades. So a great deal has taken place in recent years, and the author thinks he is fulfilling a long-felt want in this volume, as hitherto no complete work dealing exclusively with the subject has been published. Pamphlets, handbooks and manuals, usually advertising mediums, have been put on the market, but do not deal with the work in its entirety. Marquetry and inlaying, buhl work, etc., are not included in this volume, being now separate handicrafts. The present book contains information suitable either for the beginner or for advanced workers, special chapters

having been included for the benefit of those who wish to dispose of their work. In the past those who were desirous of turning out really good and profitable work, instead of being able to obtain the required information at once, were obliged to pick up hints here and there as they progressed, sometimes at much expense and entailing years of labour before their work could be made satisfactory, and a market found whereat the articles would find a ready sale and bring them adequate return for their labours. The information contained in this volume is the result of the careful study of years- wrinkles, so to speak, not only from the authors own experience, but from the vast experience of others. By close attention to the authors advice and patient practice the fretcutter should in time attain that degree of proficiency which the author has reached after many years work. THE AUTHOR CONTENTS CHAPTER PAO 8 PREFACE . V INTRODUCTORY . . I I. THE WORKROOM 7 11. WOODS . . 12 111. WOODS confinued . . 18 IV. DESIGNS . . 28 V. TOOLS. 36 VI. METHODS OF TRANSFERRING DUPLICATING AND COPYING DRILLING AND CUTTING-OUT . a 46 VII. HINTS TO MACHINE WORKERS . 54 V.T.11. FLXING, GLUEING, AND FITTING . 61 . . 68 X. FITTINGS . 74 IX. OVERLAYS XI. FITTINGS continutd . 83 XII. MISCELLANEOUS FITTINGS . - 93 XIII. MISCELLANEOUS HINTS . . IOI XIV. HOW TO MAKE IT PAY . . 110 XV. PAYING ORDERS . . 1x9 XVI. FRETCUTTING IN METALS, ETC. . I 130 INTRODUCTORY HE choosing of an outfit for the beginner must depend entirely upon the size of his pocket. It is not the quality of the tools that produces the best workmanship, but the skill with which they are used. The cheapest sawframe can produce first-class work if wielded by an expert hand, yet good tools are certainly conducive to comfort and rapid and easy working. FIG. I.-COMBINED CUTTING BOARD AND VICE. The learner needs only a hand-frame, a drill, a few feet of fretwood, designs, and saws, and his outfit is complete. A small hammer, sandpaper, and glue, may be included if the worker does not already possess them. Choose a frame about B fourteen inches long this saws average work and is not too heavy to handle. The clamps for holding the saw-blade must be easy to manipulate, and the tension of the saw-blade should be secured by a twist or turn of the handle...

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