

Fig. 1-12. Shaper tools for cutting steel. A. Roughing tool. B. Round-nose general-purpose tool. C. Steel finishing tool.

A shoulder-finishing tool is shown at B in Fig. 1-15. If a sharp corner is required, a flat is ground on the end and on the side-cutting edge as shown. The width of this flat should be from .030 to .060 inch. If a radius is required in the corner, the flat on the side-cutting edge can be eliminated and the required radius ground on the nose of the tool. It can be used as shown

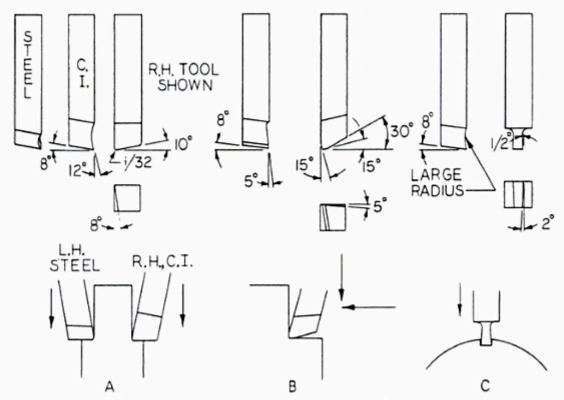


Fig. 1-15. Shaper cutting tools. A. Side cutting tool. B. Shoulder-finishing tool. C. Keyseating tool.