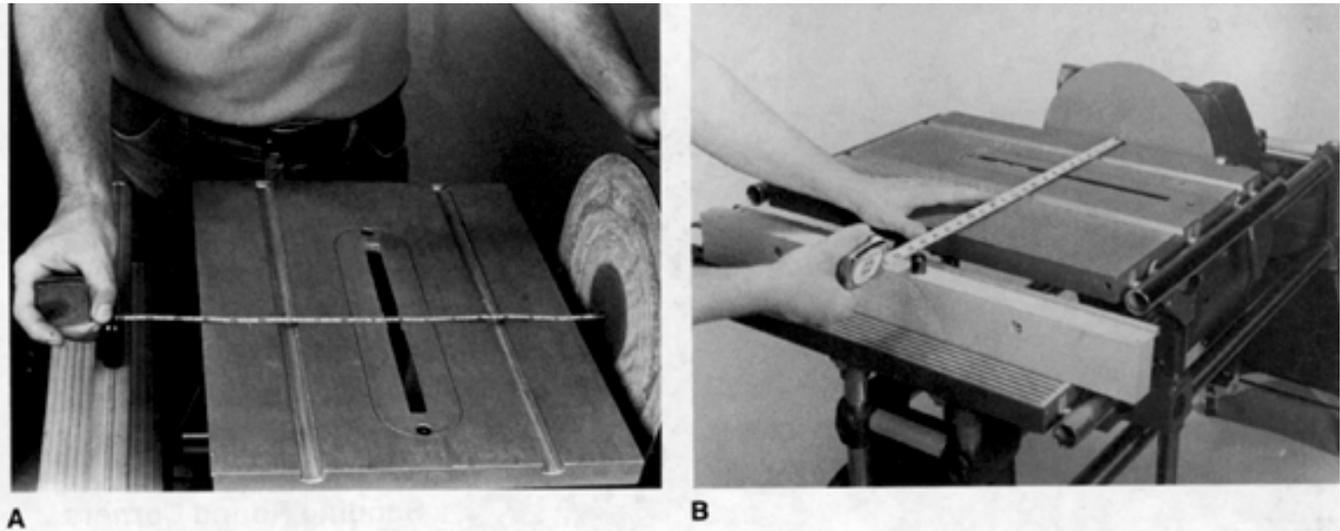


**Figure 17-25.** Construction details of the pivot fixture. Notice the two types of pivot posts; one has a point to be used when the workpiece does not have a center hole.



**Figure 17-26.** To pivot sand extra-large circular workpieces, mount the lathe cup center to : (A) the rip fence of the Model 500 or (B) a rip fence extension on the Model 510.



**Figure 17-27.** Corners can be rounded off by sanding to a line. The bulk of the waste should be removed with saw cuts before you begin.

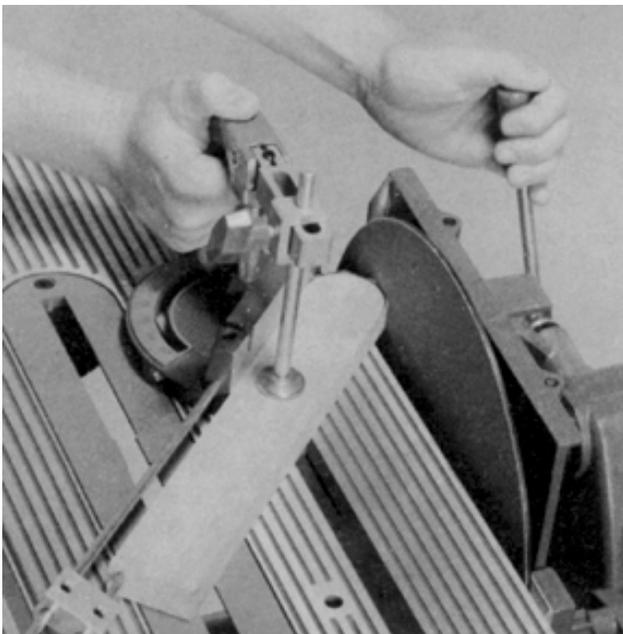
### Sanding Round Corners

One method of sanding round corners is shown in Figure 17-27.

Prepare the stock by sawing off the bulk of the waste material and then finish the shaping by using the disc sander.

When the radius of the corner isn't very large, the entire job can be done by sanding, a procedure that is especially applicable when you need many similar pieces. Set the miter gauge at 45° and use the miter gauge stop rod as a backup for the workpiece. Secure the workpiece by holding the safety grip and, with the depth control set to limit the disc's extension, feed the disc forward to sand to a line that is tangent to the curve (Figure 17-28).

After all corners have been sanded in this manner, finish the job freehand. There will be very little material left to remove.



**Figure 17-28.** This is a setup that can be used if the corners are not too large. First sand to a line that is tangent to the curve. Finish rounding off by working freehand.



**Figure 17-29.** The ends of the dowels are larger rounds can be pointed or chamfered freehand by angling the miter gauge.

### Pointing or Chamfering Rounds

Pointing or chamfering dowels or rounds can be done freehand by setting the miter gauge to the angle you need and then using it as a guide as you rotate the workpiece against the disc (Figure 17-29). If you want more precise results or need to shape duplicate pieces, work as follows.

Use the miter gauge stop rod or a long extension with a stop block to back up the workpiece. Advance the disc to the point where it will form the chamfer or point you need while rotating the stock against the miter gauge.

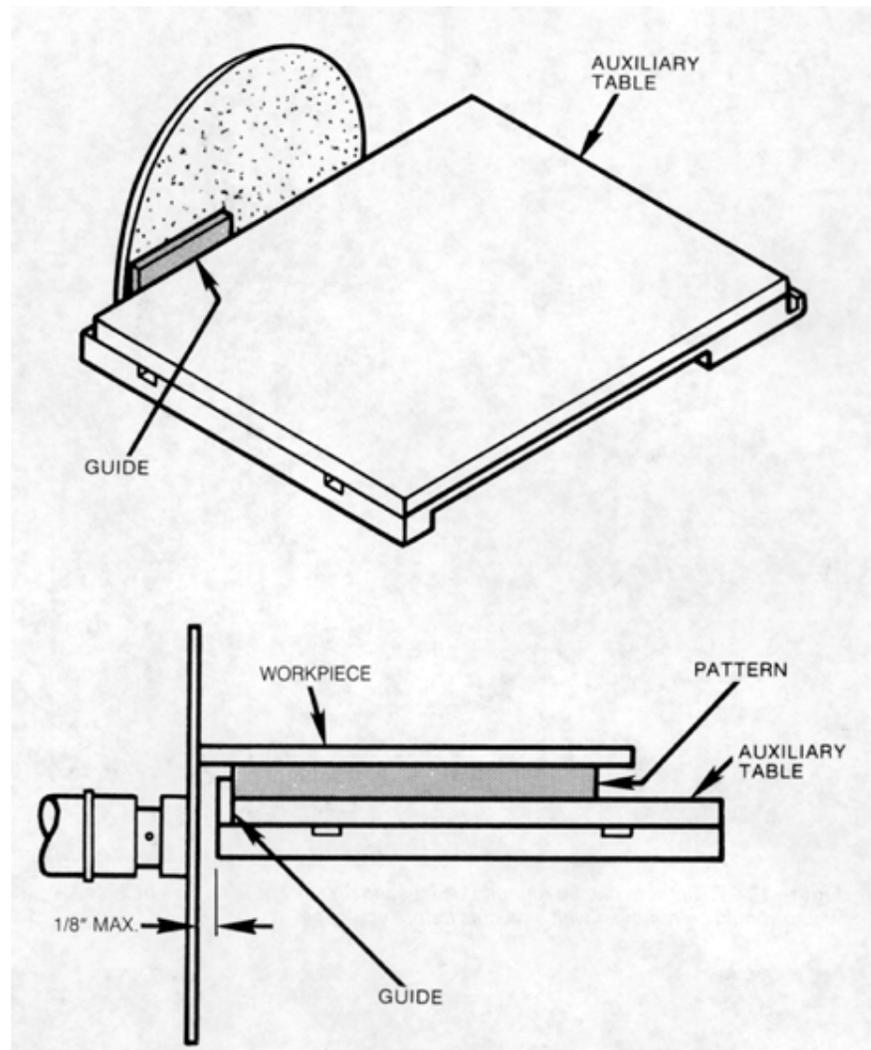
### PATTERN DISC SANDING

Pattern disc sanding is useful for sanding duplicate pieces, especially if they have an odd shape. The procedure is shown in Figure 17-30.

The guide, preferably metal, is attached to the edge of an auxiliary platform which is clamped to the worktable so the guide will be about 1/8" from the disc.

The workpiece, attached to the pattern, projects over the guide to contact the disc. Therefore, the distance from the guide to the disc and the thickness of the guide must be considered when shaping the pattern. The pattern must be smaller than the actual workpiece.

The workpiece is attached to the pattern by tack-nailing or using nail points projecting from the pattern. When you rough-cut the workpieces, try to leave the least amount of material for the disc sander to remove.



**Figure 17-30.** The pattern sanding procedure shown here is useful when many identical pieces are needed.