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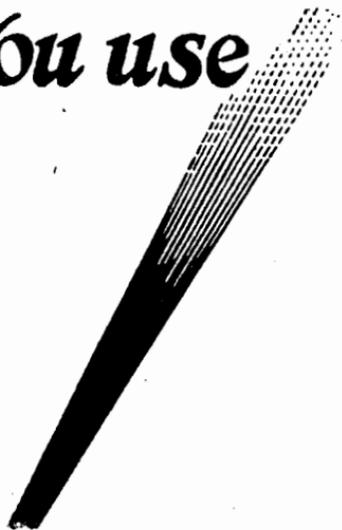
This organization also manufactures
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Specialties, etc.

Catalogues illustrating the various
lines will also be sent to those interested.



Reprint From Manual c1922

Read This *before you use*



STANLEY CORE BOX PLANE No. 57

These Planes are designed for making circular core boxes. The principle is that only a right angle may be inscribed in a semi-circle.

The sides of the Plane are at right angles, consequently the point of the plane will cut on the circumference of the circle when the sides rest on the edges of the cut.

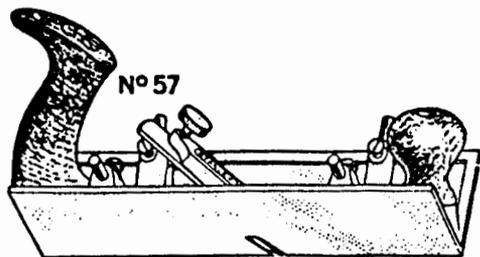


Fig. 1



Fig. 3

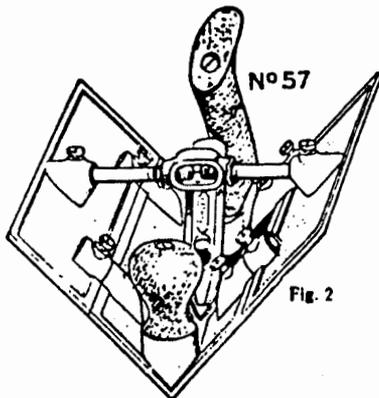


Fig. 2

No. 57 Plane is different from other Core Box Planes inasmuch as it can be used either on the right or left sides. This is useful when making long core boxes which cannot easily be reversed and in making taper core boxes where you have to plane with the grain. It likewise suits the user's choice right or left.

In setting the plane iron, be careful that it cuts only on the side determined on, either right or left. The edge opposite from the cutting edge of the cutter must be rounded, so that it will not cut or project out of the plane bottom. Once the cutter is properly set it will go a long time without adjustment. For making taper core boxes it is a good plan to have two cutters, a right and left.

Each Plane is furnished with one pair of extra sides or, as they are called, Additional Sections (Fig. 3).

Without the Additional Section as shown (Fig. 1) it will work semi-circles from one inch to two and one-half inches in diameter.

With the Additional Sections furnished as shown (Fig. 2) it will work semi-circles up to five inches in diameter.

Additional Sections with adjusting rods, by means of which the sides can be made square and held firmly in position, can be supplied, each extra pair adding two and one-half inches to the diameter of the semi-circle that can be worked; Section No. 2 making the diameter seven and one-half inches and Section 3 added to No. 2 making the diameter ten inches, the practical limit of the Plane.

READ THIS CAREFULLY

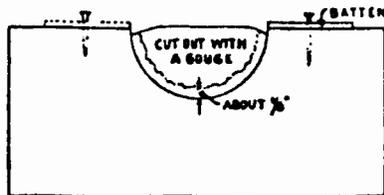


Fig. 1

To make a core box first layout with a scratch and compass the line and size of the core box desired. With a thin batten to guide the plane, make a bevel groove $\frac{1}{16}$ -inch deep on each side, to define the edges of the cut. Next with a gouge, chisel or round plane, remove the middle portion of the core to within about $\frac{1}{8}$ -inch of the circumference.

Then with the core box resting on both edges of the cut start to plane slowly and carefully; do not let the plane slip (Fig. 2.). After the plane is well into the circle it will work much easier. Plane half way and then reverse the block and do it the other half the same way.

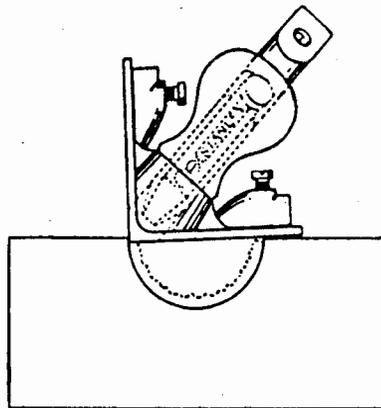


Fig. 2

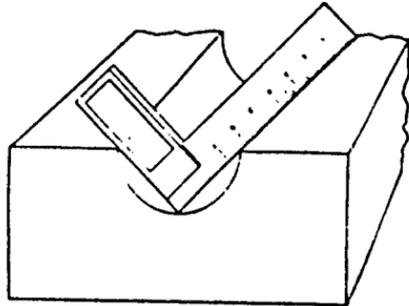


Fig. 3

Next, using a bench plane, plane off the top surface of the core box until all three points of a try square touch the circumference of the core. (Fig. 3). You then have a perfect semi-circle.

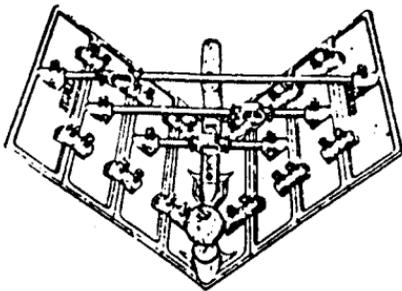


Fig. 4

In building up the plane with additional sections for large core boxes, each section must have the tie or adjusting rods in position (Fig. 4). These adjusting rods are for squaring up the sides of the plane. Be particularly careful to square up each section before the next section is put on. It is impossible to get a perfectly smooth surface where the sections join but this is unnecessary to make a perfect core box.