

CW TIP 9 — Additional Modifications to the Sherline Steady Rest/Kelsey Downum

Customizing the Steady Rest for Detailed Work

This suggestion comes from Kelsey Downum and is a refinement of Tip #1 on the "Tips for Clock & Watchmaker" web page entitled, *Sherline Steady-Rest Modification*, by Gary Combs.

Kelsey has supplied three photos showing the modifications that he currently uses on his Sherline Steady Rest for all clock work (i.e., pivot polishing, re-pivoting, etc.).

Kelsey says, "These modifications (to me) increase the flexibility of the tool for working with very small parts and round stock. In addition to adding a knurled adjustment knob to facilitate adjustment of the tool without an Allen wrench (thank you for the idea Gary!), I minimized the profile of the adjustment screws on the front of the Steady Rest (see Figure 1) by replacing the blade holding cap screws with lower profile screws. This enables work close to the front of the tool without interference or banged up knuckles (see Figure 2)."



FIGURE 1



FIGURE 2

"I have replaced the 1/4" square brass blades with three fine brass blades made of 0.156" diameter brass rod – each is 2-1/2" in length and tapered with a 2-3 degree taper (cut by rotating the headstock). The blades are held in place by 1/4" brass square stock holders that are center drilled to 0.157" and chamfered at both ends. There are three blade holders – two are 3/4" long and one is 1" in length (I put the longest one at the mouth of the tool where most of the close handwork needs to occur). Holes were then drilled and tapped for 6-32 cap screws approx. 1/8" from one end of each blade holder. The 6-32 cap screws hold the blades to their proper depth and are easy to adjust by finger tightening/ loosening (see Figure 3 on the next page). I arrange the holding screw on the longest blade holder with the screw facing toward the headstock to minimize conflicts with tools or fingers."

Advantages of these Modifications

i) Steady Rest and blades can be quickly and easily adjusted;

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- ii) Interference between blades and work pieces (i.e., wheels, etc.) is minimized;
- iii) Blade holders do not need to be re-adjusted once in place; and
- iv) Reducing profile in front of Steady Rest increases work area for small and difficult to reach wheels, parts, etc.

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FIGURE 3