CYLINDER MEASUREMENT FOR LEATHER FLESHING AND SHAVING BLADES

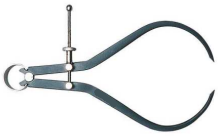
LABOURCRAFT
redefining edges since 1954

Read the Entire Instructions Carefully Before Starting to Take Measurements

Recommendations

- Though the first three measurements can be taken on the cylinder with the blades fixed on it, *we recommend*, for accuracy, measurements of the cylinder be taken on an empty cylinder without the blades.
- Though imperial system (feet, inch) can be used, *we recommend,* you use metric (m, mm) system for measurement.

Martials required

Tape measure		Chalk sticks	
Outer Caliper		Vernier Caliper	
Ruler		Depth Gauge	
Calculator		Two Stands for the Cylinder	

Scope of work

- Remove the cylinder from the machine.
- Place the cylinder on the stands in such a way that it can be rotated freely with ease.
- Remove the old blades from the cylinder and clean the cylinder and its grooves.

Machine

Make _____ Model _____

☐ Shaving Machine ☐ Fleshing Machine *(Tick one)*

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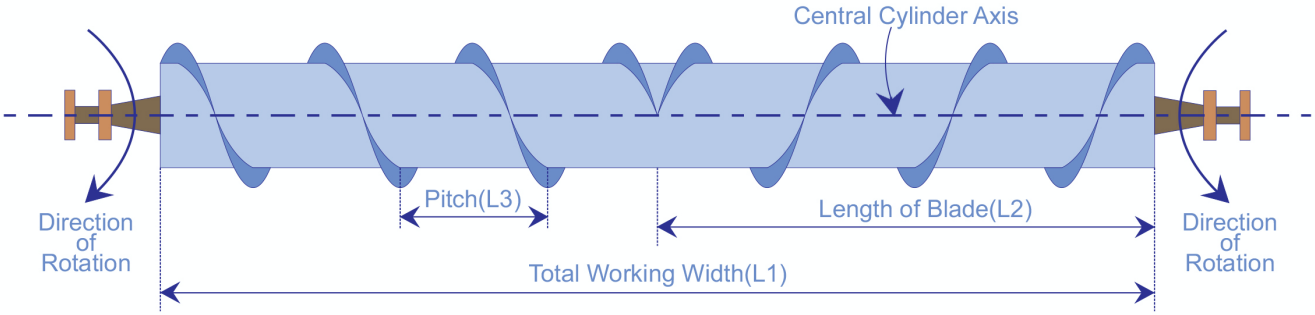
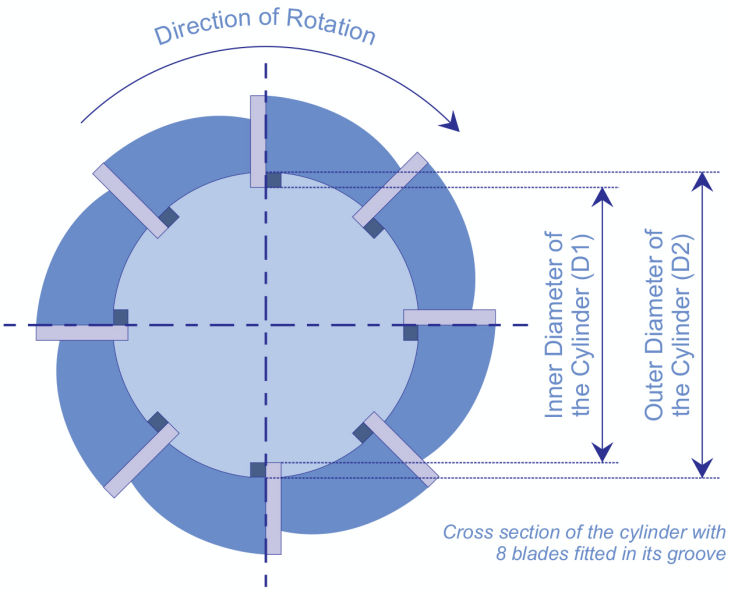
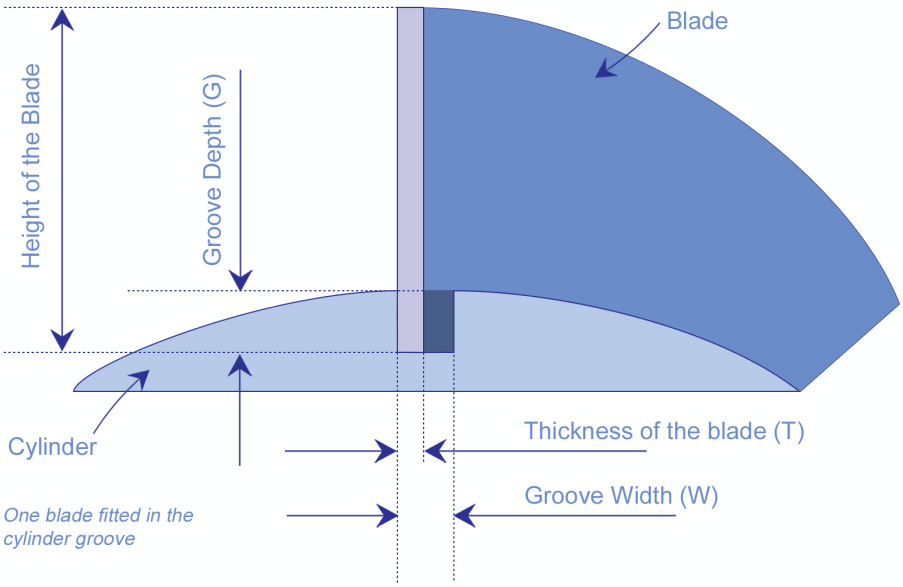


Cylinder with one left hand side blade and one right hand side blade fitted in its groove



Cross section of the cylinder with 8 blades fitted in its groove



One blade fitted in the cylinder groove

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Measurements

Total Working Width (L1) It is the total length of the cylinder measured parallel to the central cylinder axis. To measure, use a tape measure to measure from one end of the cylinder to the other keeping the tape parallel to the central cylinder axis.	mm
Length of Blade (L2) The cylinder has right-handed and left-handed grooves cut in it. The right-handed grooves fits the blades of right hand winding and the left-handed grooves fits the blades of left hand winding. To measure, use a tape measure to measure the cylinder from any one end to the centre of the cylinder including the overlapped portion keeping the tape parallel to the central cylinder axis.	mm
Pitch (L3) It is the distance from one point of the blade to the next corresponding point of the same blade measured parallel to the axis. The pitch of the blade matches the pitch of the cylinder. However, we recommend taking the measurement from the cylinder than from the blade. To measure the pitch, use a chalk to mark along a groove of the cylinder. Using a tape measure placed parallel to the central cylinder axis, measure the distance between the two corresponding marked points on the marked groove.	mm
Groove Depth (G) It denotes the depth of the groove. It can be measured by means of a depth gauge.	mm
Outer Diameter of the Cylinder (D2) It is the diameter of the cylinder before the grooves have been cut into it. To measure, use the outer caliper to measure the cylinder diameter and note the reading against a ruler.	mm
Inner Diameter of the Cylinder (D1) Also known as the "Diameter at the Bottom of the Groove", it is the cylinder diameter after the grooves has been cut in it. Some cylinders have specific areas marked to measure the inner diameter. In such cases outer caliper is used to measure the Inner Diameter of the Cylinder. Else, Inner Diameter of the Cylinder equals Outer Diameter of the Cylinder minus two times Groove Depth. Mathematically, D1 = D2 – (2 x G).	mm
Number of Blades Count the number of grooves cut in the cylinder for right hand winding blades and left hand winding blades separately. They should be equal.	Right Left
Thickness of the Blade (T) Measure the thickness of the blade at the bottom using a Vernier Caliper.	mm
Groove Width (W) Though measurement of Groove Width is not required to order blades, it is useful when ordering for Copper Caulking Strips. The Width of the Groove, measured perpendicular to the line of the groove, increases overtime due to wear and tear.	mm

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