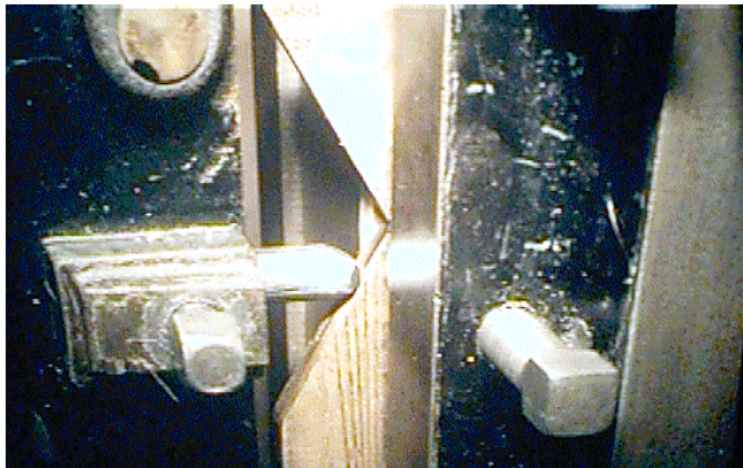


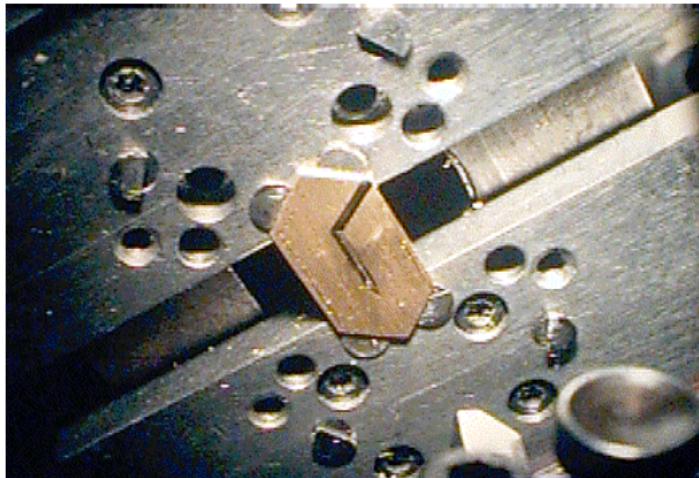
## 2. ***Cutting Lines: The basis of all engine turning***

### **A Pair of Hexagonal Cufflinks**

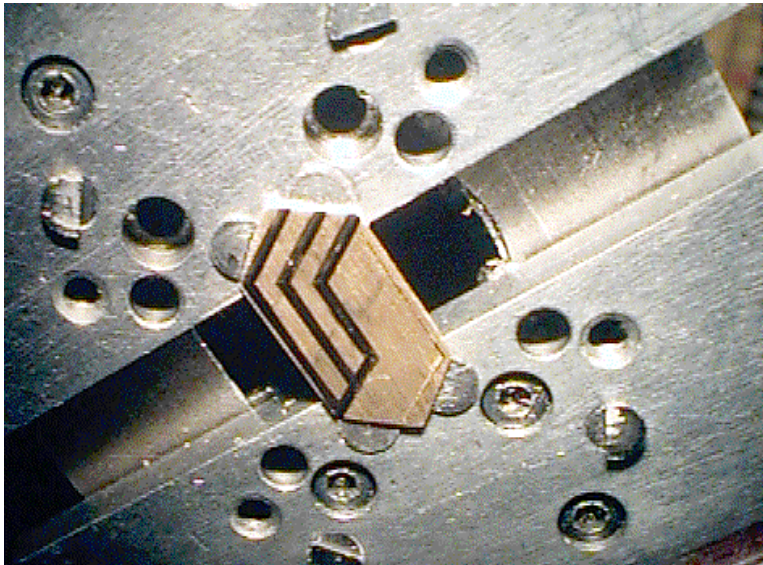
Creative use of the pattern bar can produce surprising effects. Here is shown how a bar with just one change of direction, a single "wave", is used to produce an original and striking design on a cufflink. Two tool profiles are used, vee and spoon or flute.



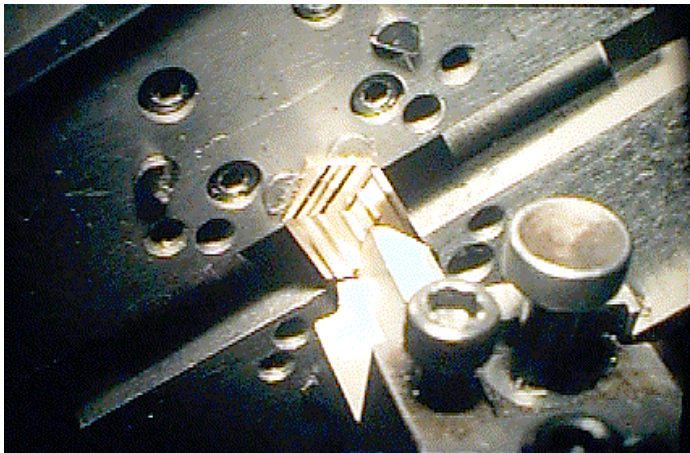
*A pattern bar with a single big notch for a change of direction. The result will be a line with a sharp bend, opposite to the bar since the workpiece is moving against the bar to create a left handed or mirror image version of what is on the bar.*



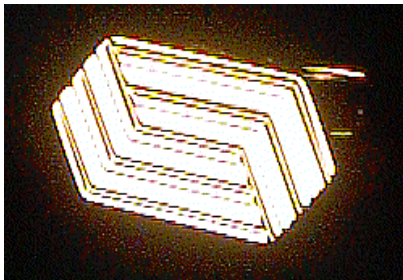
*The first line, a vee cut with a single change of direction following the pattern bar, a mirror image of course, starting from the middle of the cufflink. The piece will be rotated several times 180 degrees to finish the design. A large guide is used to bridge the cuts as the work progresses. Note the peg jaws used to hold small items.*



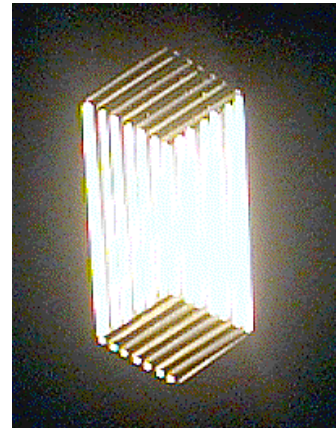
*Next, the work is rotated 180 degrees and 3 more vee cuts are made, the third rightmost in this image starting from within the first cut. Care must be taken to ensure that the tool is at exactly 90 degrees to the work for the reversed cuts to match up evenly in the centre of the job*



*Then, after reversing 180 degrees again and finishing the vee cuts, the spoon cuts are added in each direction*



*The finished cufflink*



*A money clip engine turned to match for a gents accessory set*