

CHAPTER XXI.

ARTICLE 129.

DIRECTIONS FOR CONSTRUCTING UNDERSHOT WHEELS,
SUCH AS SHOWN IN FIGURE 1, PLATE XIII.

1. Dress the arms straight and square on all sides, and find the centre of each; divide each into 4 equal parts on the side; square, centre, scribe, and gauge them from the upper side across each point, on both sides, 6 inches each way from the centre.

2. Set up a truckle or centre-post, for a centre to frame the wheel on, in a level piece of ground, and set a stake to keep up each end of the arms level with the truckle, of convenient height to work on.

3. Lay the first arm with its centre on the centre of the truckle, and take a square notch out of the upper side 3-4ths of its depth, wide enough to receive the 2d arm.

4. Make a square notch in the lower edge of the 2d arm, 1-4th of its depth, and lay it in the other, and they will joint, standing square across each other.

5. Lay the 3d arm just equi-distant between the others, and scribe the lower arms by the side of the upper, and the lower edge of the upper by the sides of the lower arms. Then take the upper arm off and strike the square scribes, taking out the lower half of the 3d arm, and the upper half of the lower arms, and fit and lay them together.

6. Lay the 4th arm on the others, and scribe as directed before; then take 3-4ths of the lower edge of the 4th arm, and 1-4th out of the upper edge of the others, and lay them together, and they will be locked together in the depth of one.

7. Make a sweep-staff with a gimlet hole for the centre at one end, which must be set by a gimlet in the centre of the arms. Measure from this hole half the diameter of the wheel, making a hole there, and another the depth of the shrouds towards the centre, making each edge of this sweep at the end next the shrouds, straight

