

Q. - - -How can I do the Basket pattern?

A. - - -I need to clarify what you mean by 'basket pattern'. There are four types of basket pattern, three are performed with the VCF or UCF and the fourth with the Drilling Spindle:

1. Plain: a series of rows of cuts with a square-ended cutter. The cuts are made deep enough to overlap so that they join in a sharp crest. Each successive row is phased by one half of a cut or less to give an effect more like brickwork than basketwork. For example, 16 cuts around a cylinder at intervals of 6 divisions from 96 i.e. holes 96, 6, 12, 18, etc; followed by 16 cuts at 3, 9, 15, 21 etc.

2. Bamboo: as for Plain except that a hollow-nosed cutter is used. This gives the effect of bamboo because the ends of the cuts, where they join, have an appearance similar to the joints in bamboo.

3. Chicken-wire: again as for Plain except that a round-nosed or point cutter is used so the cuts are 'boat-shaped'. Several rows of this pattern alternately phased by half a cut gives an appearance like chicken wire or honeycomb. If the point angle is too steep (acute) the cuts will be too deep to reflect the light properly so the cutter should be ground to a shallow (obtuse) angle, say, 90° - 100° for cutting on thin cylinders or 110° - 120° for cutting on large diameter cylinders or flat surfaces.

4. Pseudo-Rose-engine: This pattern more closely resembles basketwork in that it leaves short vertical stubs between cuts and these resemble the vertical canes in basketwork. An example of this pattern may be seen in Holtzapffel Volume V Fig.485. Unlike the above methods this one is performed by the Drilling Spindle with a round-nosed or point drill, the Eccentric Chuck and the segment stops. Ideally a piece of scrap wood can be used to set up the pattern; decide how many cuts to take around the circumference, say, 12; set the Eccentric Chuck horizontal with the micrometer nearest the operator, set the index in the 96 row of divisions and extend the chuck slide about one third of the diameter of the work. Advance the drill so it touches the work and set the depth stop so it will just penetrate the work; then retract the drill. Move the index 4 of 96 divisions in one direction and set a segment stop then move the index back plus 4 divisions in the other direction and set the second stop. Run the drill back and forth to form a curved flute until the depth stop is reached. Then move the nose-wheel of the chuck by 12 of 96 divisions and repeat the drill fluting. By fine adjustments to the eccentricity of the slide and the distance between the segment stops the most pleasing result may soon be established. Then cut an adjoining row phased by half a cut (4 divisions) from the cuts in the previous row. When satisfied with the results on the scrap piece a pre-prepared piece of the same size may be attempted with confidence.