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54 **Workpiece guides.**

57 The disclosure relates to a workpiece guide for supporting a rotary workpiece comprising a housing (10) in which an assembly of three jaw members (13, 14, 15) is mounted to embrace and support a workpiece for rotation about an axis (11) defined by the positions of the jaw members. Common drive means (55 to 60) close the jaw members to hold the workpiece for rotation in the jaw members. The jaw assembly has an adjustable mounting (39, 40) to alter the position of the axis (11) defined by the jaw members whereby the axis can be set to coincide with an axis of a machine tool on which the guide is to be used and a workpiece then supported on that axis in the guide. Having closed the jaw members (13, 14, 15) on a workpiece the drive means (55) releases the members slightly to allow a running clearance for the workpiece in the jaws.

FIG. 6.

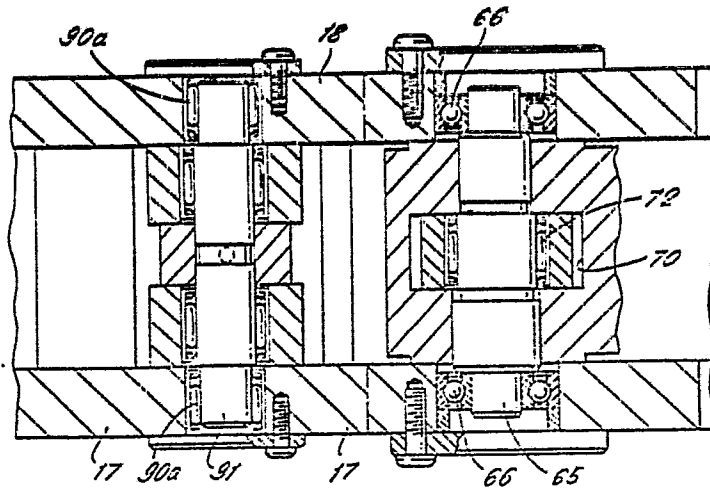
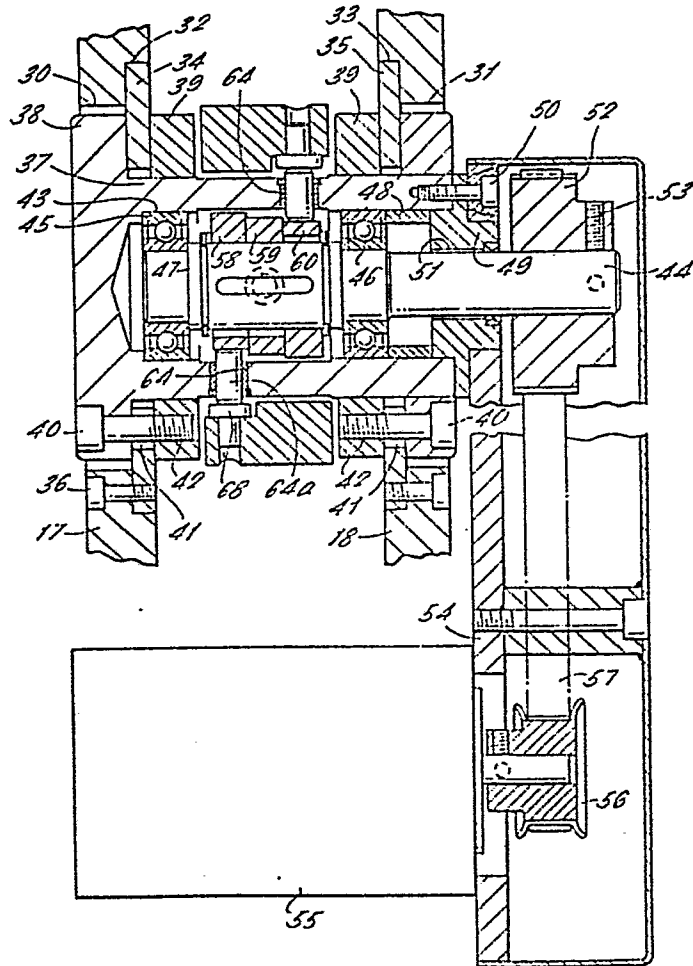


FIG. 7.





DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
4	X GB-A- 764 493 (DROMMOND) * Pages 1-3; figure * ---	1,4	B 24 B 41/06
1	A SOVIET ENGINEERING RESEARCH, vol. 2, no. 11, November 1982, Melton Mowbray, Leicestershire, GB; S.M. SOBOLER et al.: "Faster and more accurate grinding of flexible parts in cylindrical grinders" * Pages 73-75; figure 1 * ---	2,3	
1	A GB-A-1 155 644 (WEYBURN) ---	5,6	
3	A DE-A-2 141 702 (DIETL) ---	7	
1	A DE-B-1 090 540 (VÖGELE) ---	10	TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
1	A US-A-4 184 293 (BENNETT) ---		B 24 B 41/00 B 23 Q 1/00
1	D,A US-A-4 276 723 (FOURNIER) -----		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 12-06-1986	Examiner SEMBRITZKI
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			