

GENERAL NOTES:

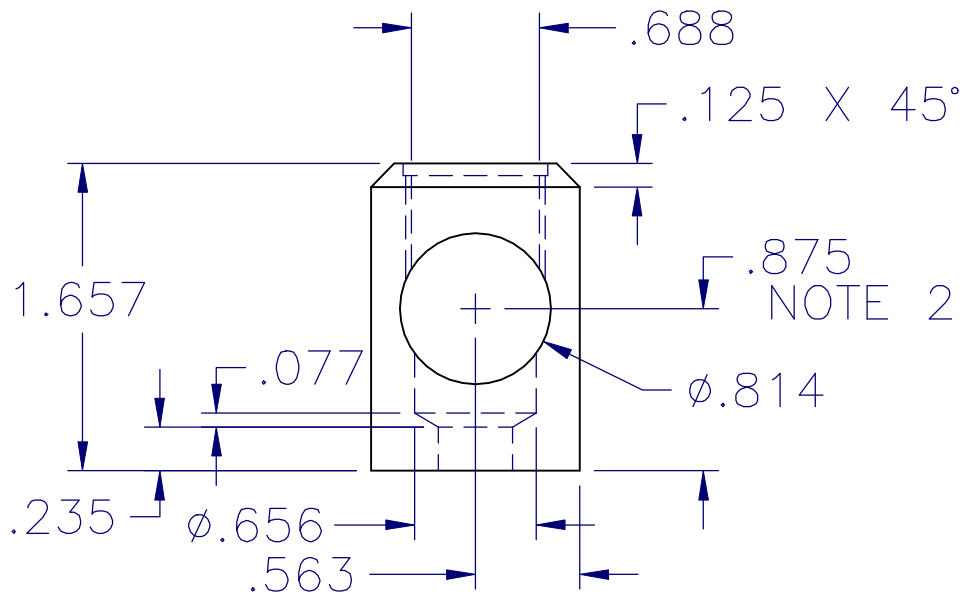
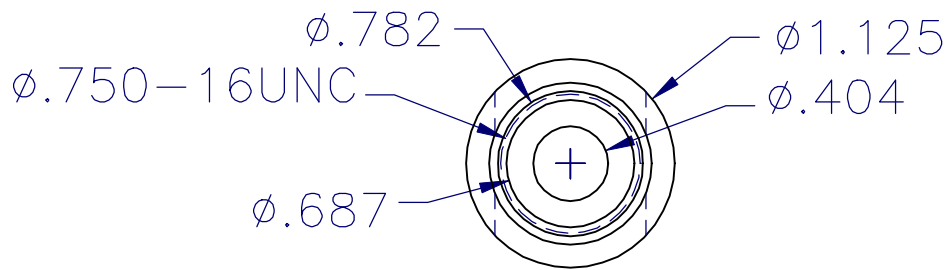
1. DIMENSIONS ARE IN INCHES, UNLESS CALLED OUT OTHERWISE.
2. STANDARD TOLERANCES: .XX ±.01, .XXX ±.005, ANGLES ±.5°.
3. BREAK EDGES .01, FILLET INSIDE CORNERS .01 MAX.
4. SURFACE FINISH: √ 32

CONSTRUCTION NOTES:

1. THIS ACCESSORY FOR THE 7X\*\* MINILATHE CAN ONLY WORK IF THE COMPOUND SLIDE HAS BEEN LOWERED BY .250 INCHES.
2. CAREFULLY VERIFY THE ACTUAL HEIGHT OF THE LATHE SPINDLE CENTERLINE ON YOUR MACHINE BEFORE MAKING THE POST AND SHELL COMPONENTS.
3. MOUNT BOLT IN LATHE CHUCK BY THREADED SHANK. PROTECT THREADS WITH A SLEEVE ROLLED FROM WIDE BANDING STRAP.
4. VERIFY THAT LENGTH OF THREADED SHANK (PC3) DOES NOT CONTACT BORING BAR WHEN TIGHTENED.
5. VERIFY THAT SCREW (PC4) DOES NOT BOTTOM OUT IN THE COMPOUND SLIDE AT ASSEMBLY.

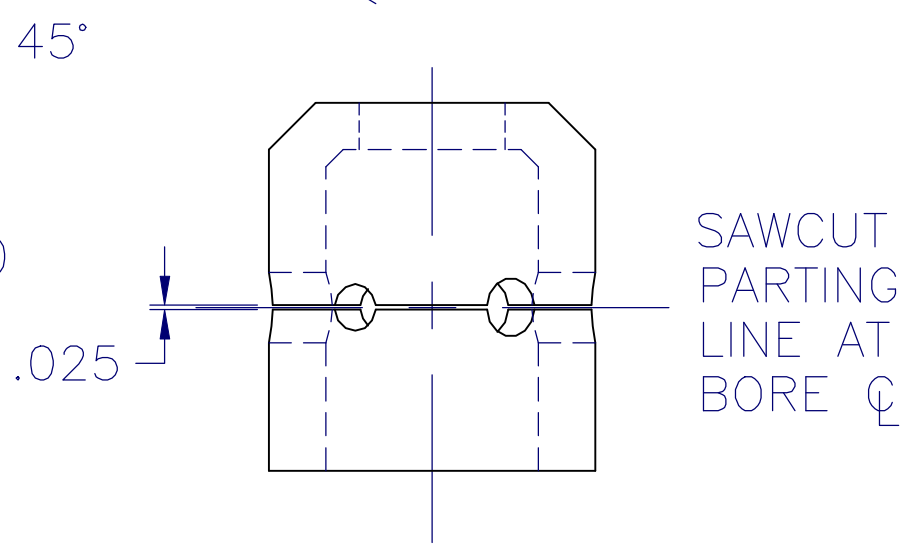
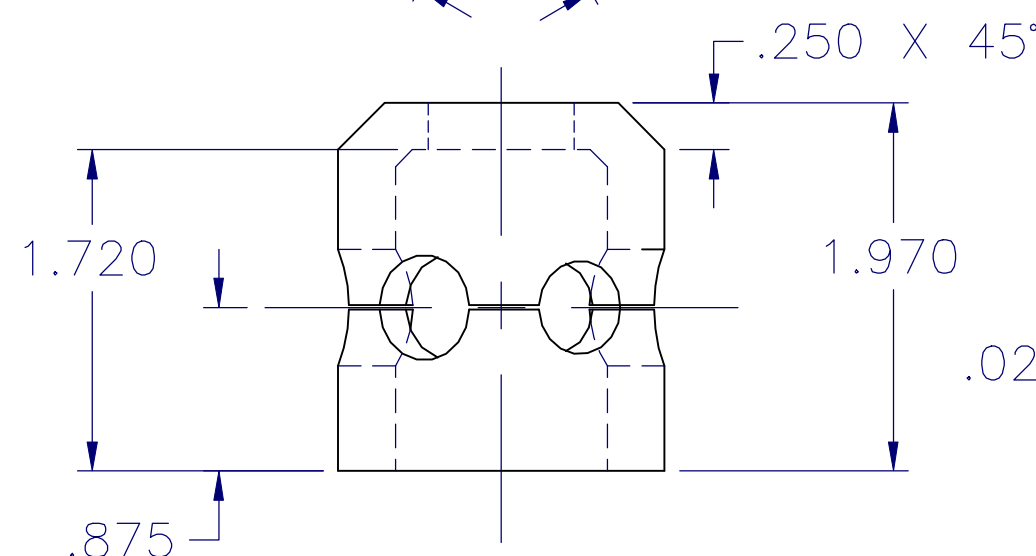
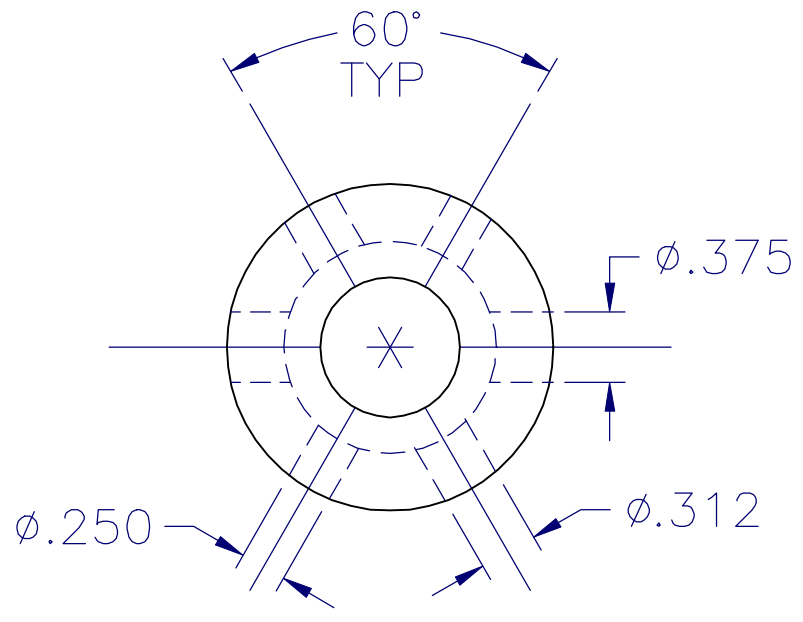
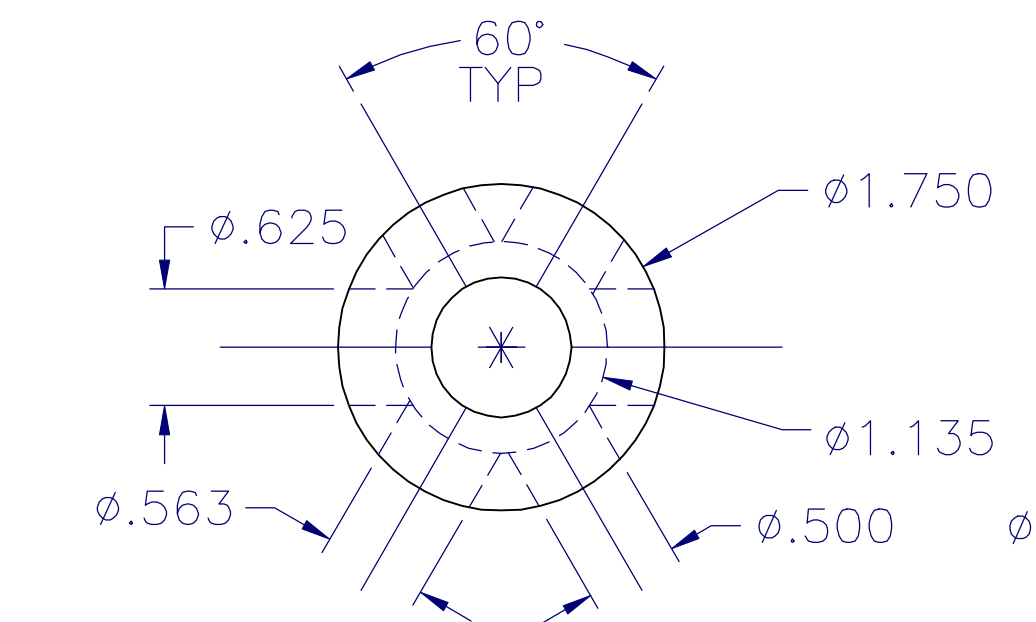
7	2	#8-32 X .375	SOCKET SET SCREW	STEEL, BLACK OXIDE	SETSCREW	7
6	1	ø3/16"	DRILL BLANK	HSS, M2, ROUND	CUTTER BIT	6
5	1 ea	SEE TABLE	SAE 1018 (CRS)	COLD FINISH STEEL	BORING BAR	5
4	4	M10X1.5-35	FH SOCKET SCREW	STEEL, BLACK OXIDE	SCREW, MOUNTING	4
3	3	.75-16X1.00	HEX HD CAP SCREW	STEEL, ZINC PLATE	CLAMP BOLT	3
2	2	ø1.75X2.00	SAE 1018 (CRS)	STEEL, COLD FINISH	SHELL	2
1	1	ø1.25 X 1.75	SAE 1018 (CRS)	STEEL, COLD FINISH	POST	1
SHEET	REQ'D	SIZE	SPECIFICATION	MATERIAL	DESCRIPTION	PC

MATERIALS AND COMPONENTS REQUIRED FOR 1 ASSEMBLY



POST WILL ACCEPT A BORING BAR UP TO 3/4" DIAMETER

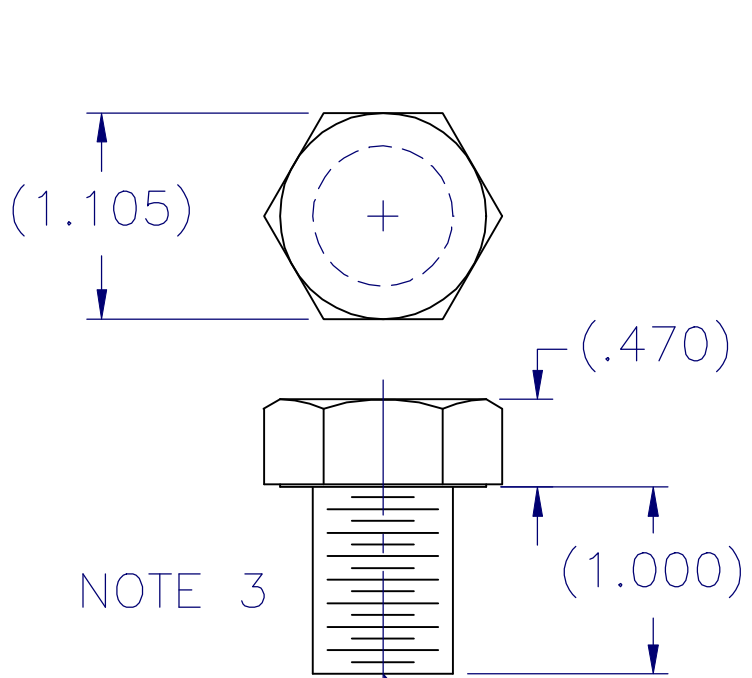
① POST



NOTE 2

② SHELL, CLAMP

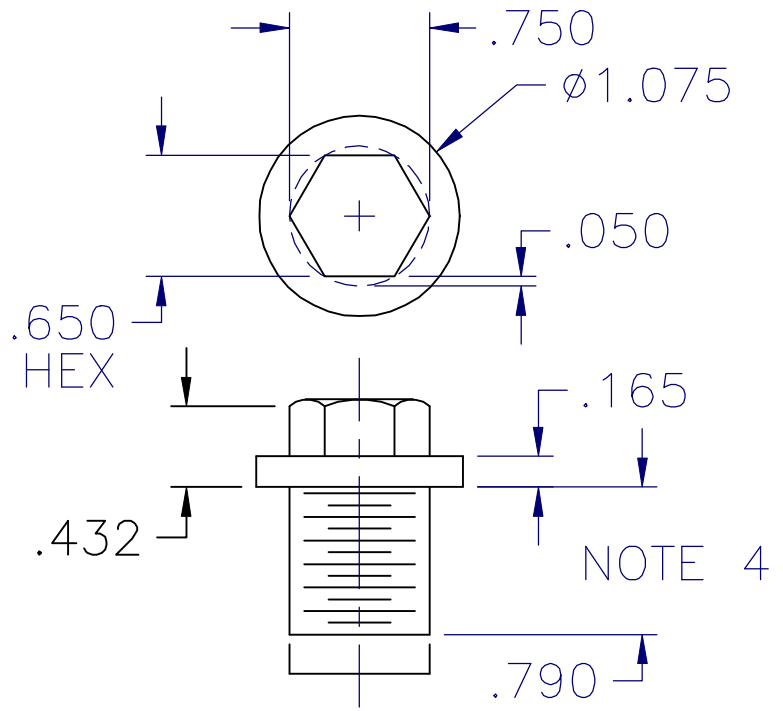
MAKE ADDITIONAL PARTS DRILLED FOR OTHER BAR SIZES



NOTE 3

3/4-16X1.0 UNF  
HEX HEAD CAP SCREW

STANDARD BOLT

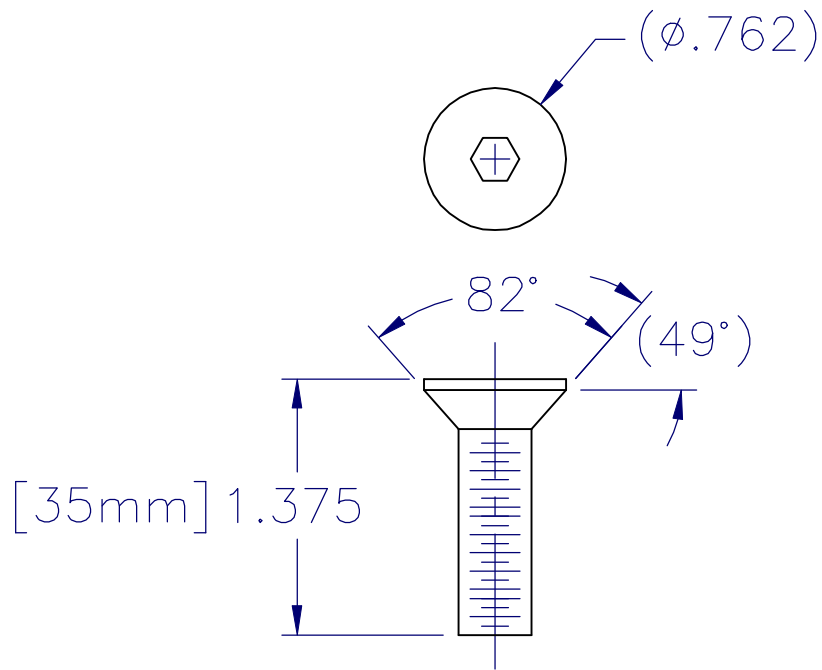


NOTE 4

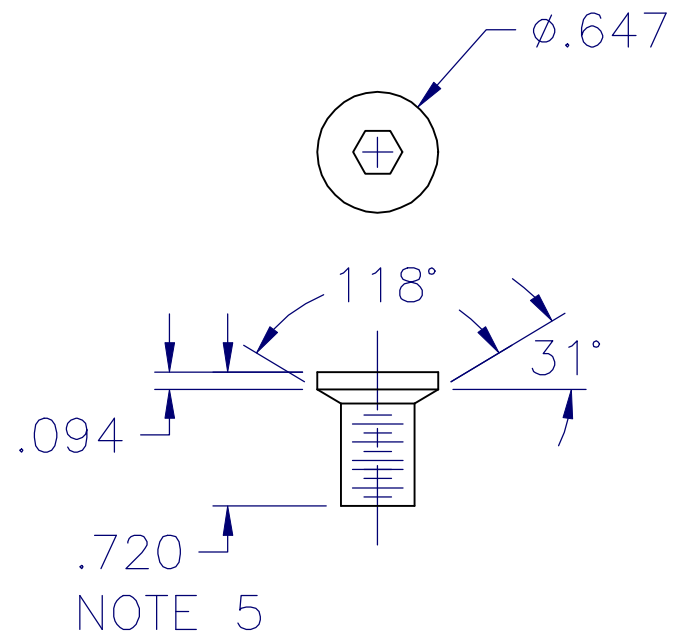
AFTER MODIFICATION

MODIFY HEX HD CAP SCREW

③ CLAMP BOLT



STANDARD SCREW

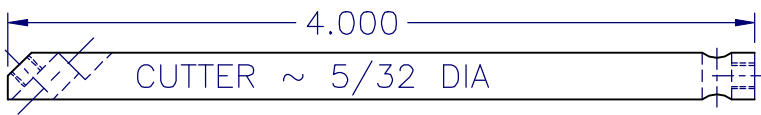
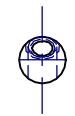


AFTER MODIFICATION

MODIFY M10.0 X 1.25 FLAT HD SOCKET SCREW

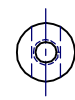
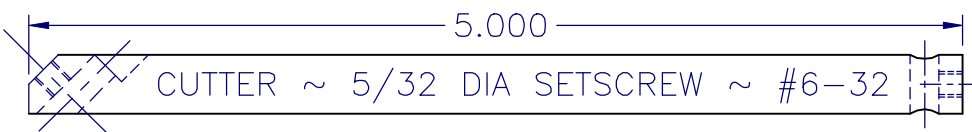
④ MOUNTING SCREW

1/4



SETSCREW ~ #6-32

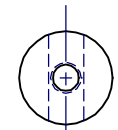
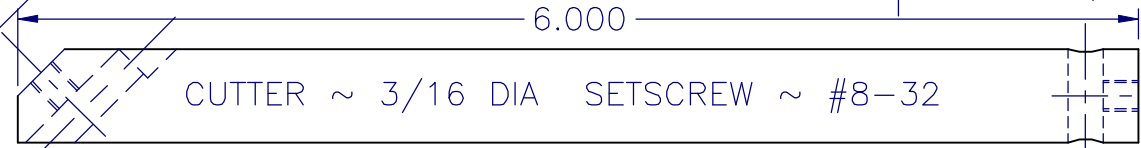
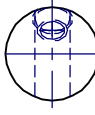
5/16



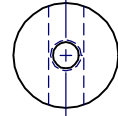
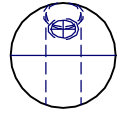
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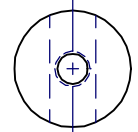
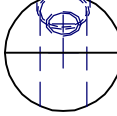
1/2



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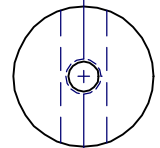
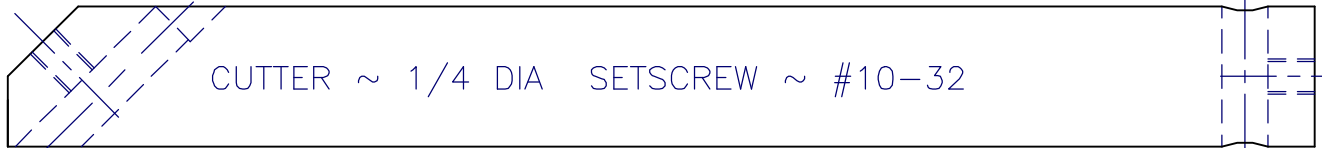
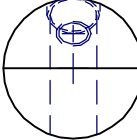


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SPOT FLAT WITH ENDMILL ABOUT .030 OVER CUTTER DIA BEFORE DRILLING - TYP

3/4

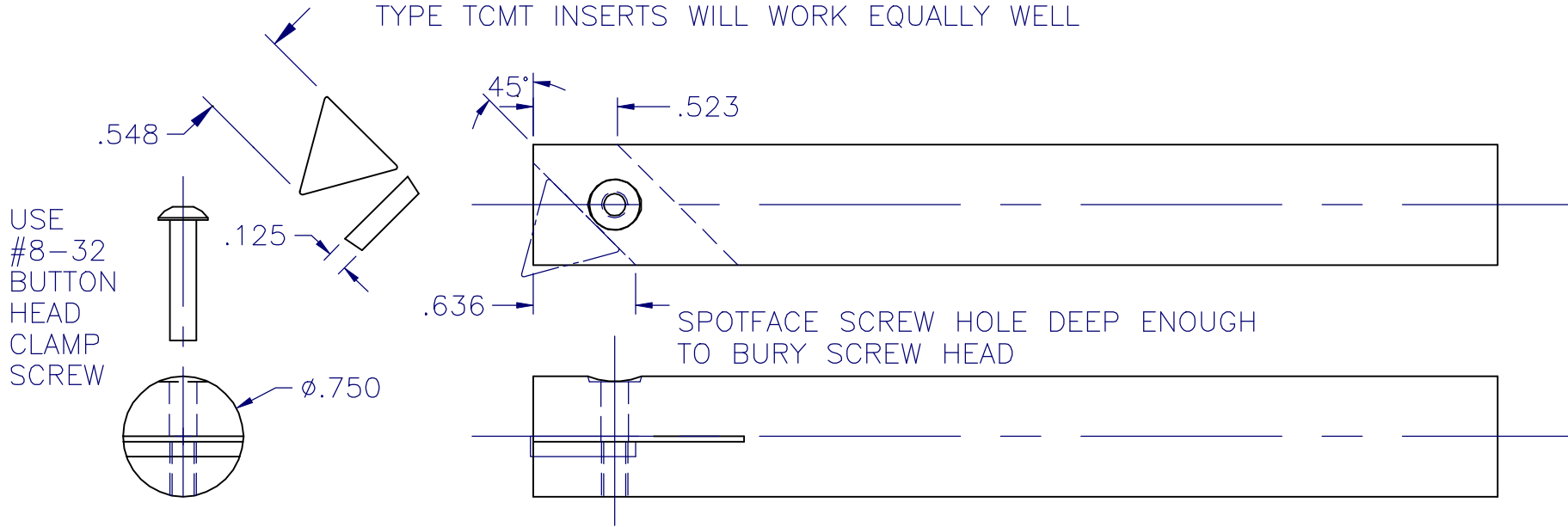


BAR DIAMETER

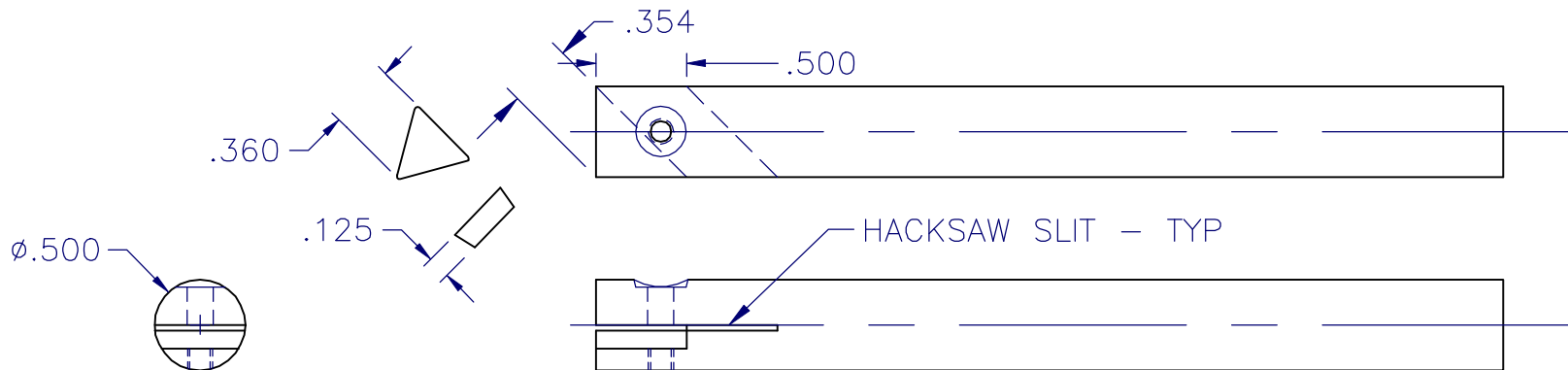


VARIOUS ROUND BORING BARS - COLD FINISH STEEL  
USING ROUND CUTTER BITS GROUND FROM DRILL BLANK STOCK

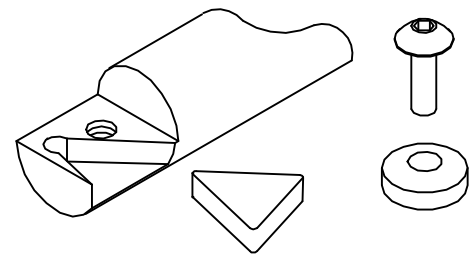
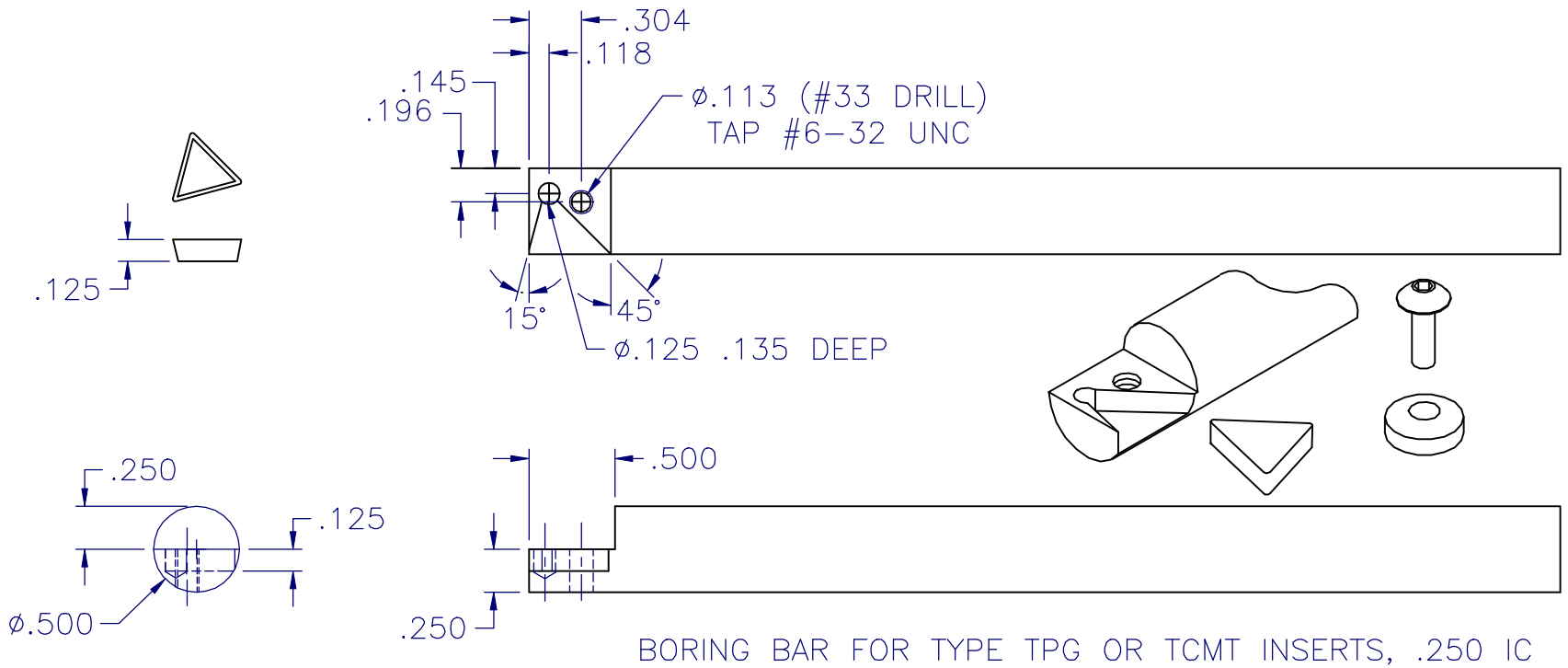
CUSTOM STRAIGHT BORING BAR, USING TPG 321 CARBIDE INSERT  
 TYPE TCMT INSERTS WILL WORK EQUALLY WELL



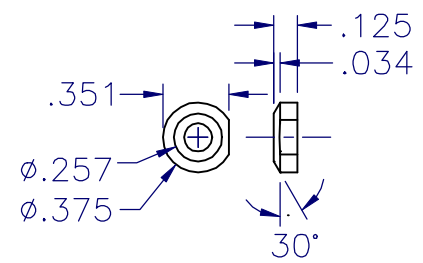
CUSTOM STRAIGHT BORING BAR, USING TPG 221 OR TCMT 21.51 INSERTS



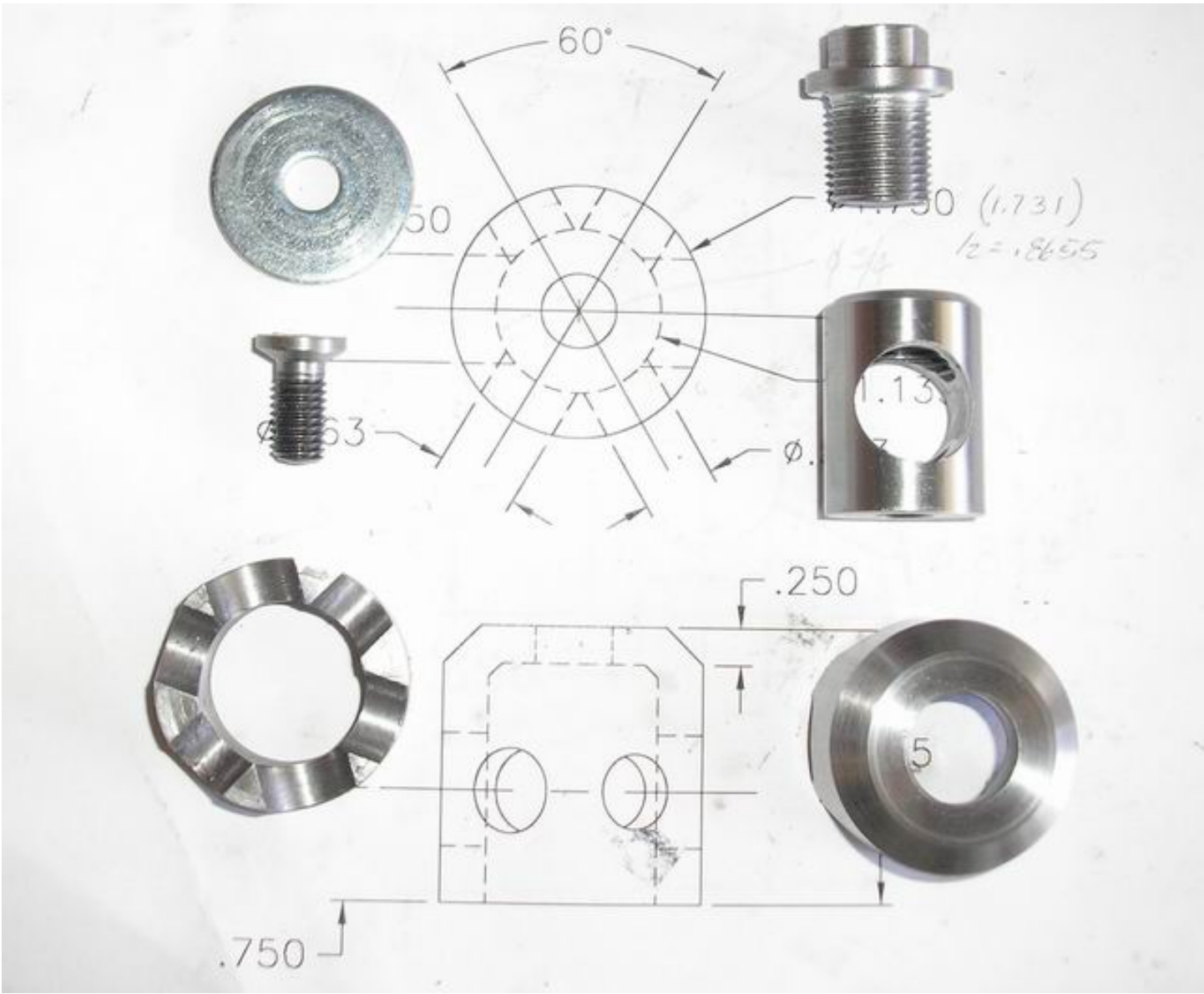




CLAMP SCREW  
 #6-32 UNC X .375 LONG  
 BUTTON HEAD SOCKET SCREW



CLAMP WASHER  
 MATERIAL: CRS  
 1 REQUIRED PER BORING BAR





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All ideas, procedures, modifications and whatever is described or shown here is to be used at risk of the reader.

Take care and work safely.