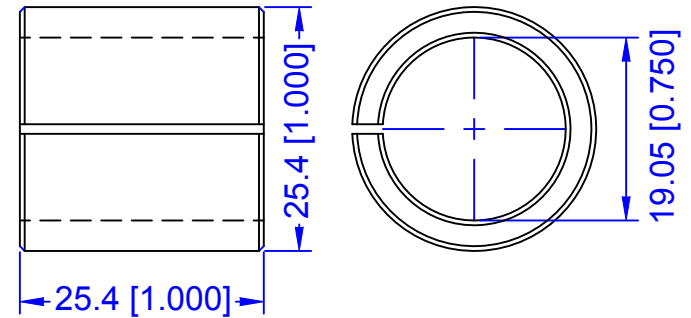


Bore Through  $\text{\O}7.144$  [ $\text{\O}0.281$ ]  
 For "DIY" 1/4-24 x 3 inch T-Bolt  
 Chamfer each end 0.5mm x 45°  
 Two Places



**Typical Split Bushing**

**NOTES:**

This "Big Bore" tool post is intended to hold large diameter tools such as a 3/4-16 tap exactly on center with the spindle. It can be used for smaller tools such as a 3/8 inch boring bar as well. The idea is to hold the tool via inserted split bushing of the correct diameter for the tool of interest.

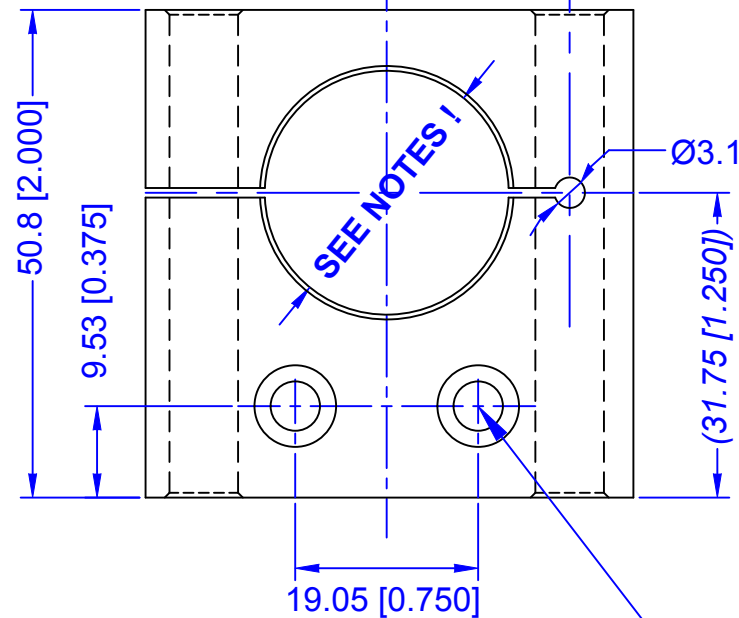
The center hole should be bored as accurately as possible to 1.000 inches [25.40mm] diameter with tool post mounted to the cross slide before the slit is cut. Whatever finishing tool is used needs to be indicated true with the spindle before boring.

The two holes in the bottom are optional. They can be used with Taig standard 10-32 capscrews and square nuts to mount the tool holder to the face of the cross slide or the optional vertical machining attachment.

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The author assumes no liability for the accuracy, fitness or application of the information or design herein. Lewis Balentine, Houston, Texas, 10 February 2020

Unless otherwise noted all dimensions are in millimeters [inches]



**OPTIONAL:**

Bore through  $\text{\O}5.14$  [ $\text{\O}0.202$ ]  
 Counterbore  $\text{\O}8.5$  [ $\text{\O}0.355$ ] by 6.9 [0.355] Deep  
 Two Places

**Big Bore Tool Post**