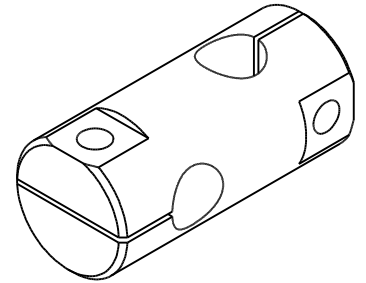


Section A-A

.159 holes are tapped 10-32  
2 each. Bolt shank clearance .191

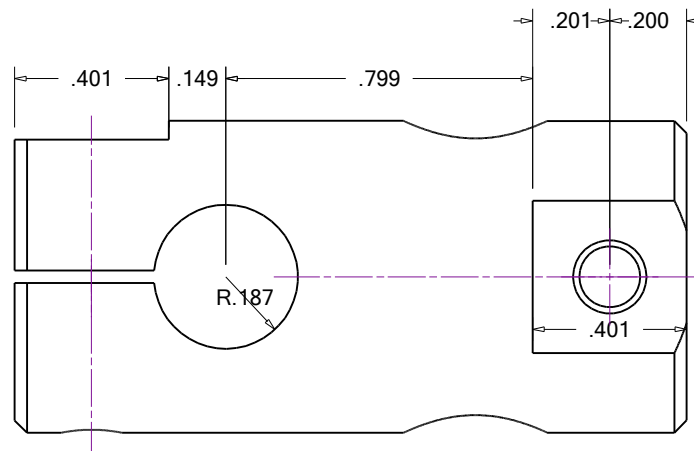
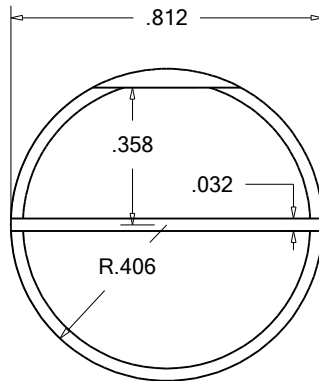
Both holes Ream to .376  
Before making the split cut.



This part is symmetrical.  
Make 2 each.

**Sequence of operations:**

Use a square collet block to hold the .812 rod with 2.225 inch of stock extending. Another approach would be to put 4 flats .050 deep on each side. The flats can be used to hold the part in the vise so the 90 deg rotation can be accurately set up.  
Drill both .374 holes with 23/64 drill for reaming.  
Ream both of the 23/64 drilled holes to .375. Slicing fit for rods.  
Add flats in two places at each end on same axis as the .375 reamed hole.  
Drill .159 thru joint at each flat. On the flat side open the .159 to .191 for .4375 deep. (clearance for the 10-32 screw shank.)  
Tap the .159 holes 10-32.  
Cutoff the part from the stock and chamfer the ends.  
Use a slitting saw or hack saw to cut the slot in each end.



Vise_Stop	
xy_Joint	
12/17/2024	JR