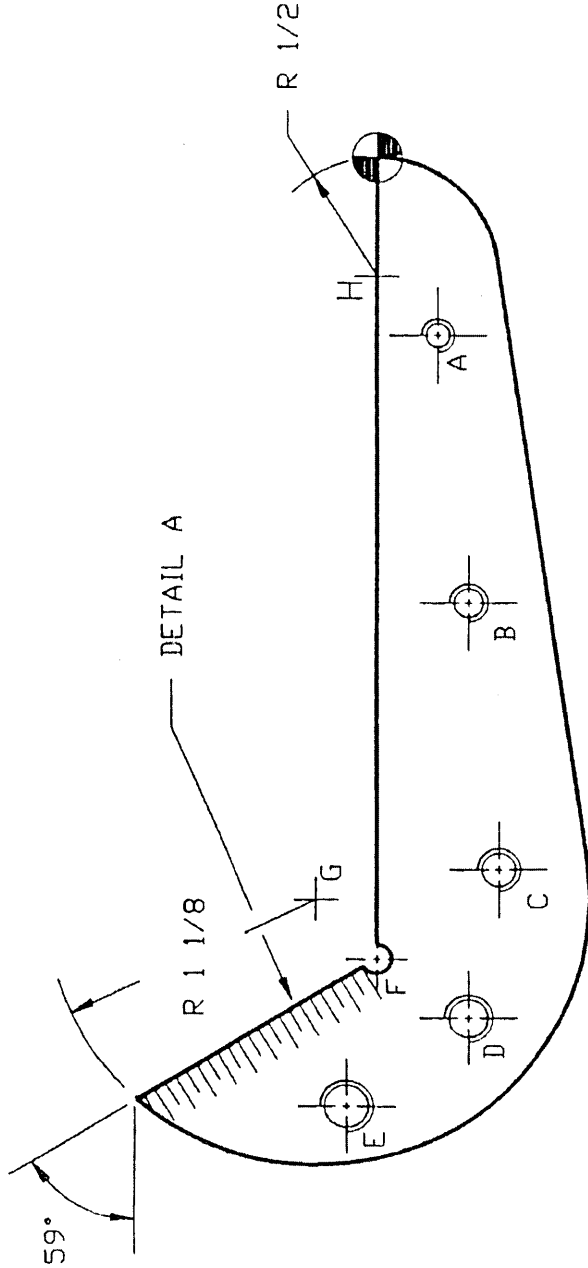
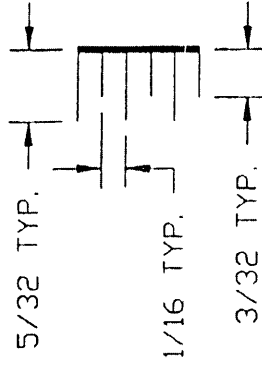


NOTES:

- 1= ALL SURFACES TO BE FINISHED BY DRAW FILING
- 2= THREAD DIMENSIONS OF HOLES TO BE STAMPED IN 1/8" LETTERING



DETAIL A



POSITION	DIM X	DIM Y	DESCRIPTION
A	-3/4	-1/4	5-40 UNC
B	-1 7/8	-3/8	6-32 UNC
C	-3	-1/2	8-32 UNC
D	-3 5/8	-3/8	10-24 UNC
E	-4	1/8	10-32 UNF
F	-3 3/8	0	DIA. 1/8
G	-3 1/8	1/4	CENTRE
H	-1/2	0	CENTRE

1	GAUGE	1	1/8 X 1 7/8 X 4 5/16	CR.S. SAE 1010
ITEM	NAME	QTE.	DESCRIPTION	MATERIAL

TITLE
THAT LAZY MACHINIST

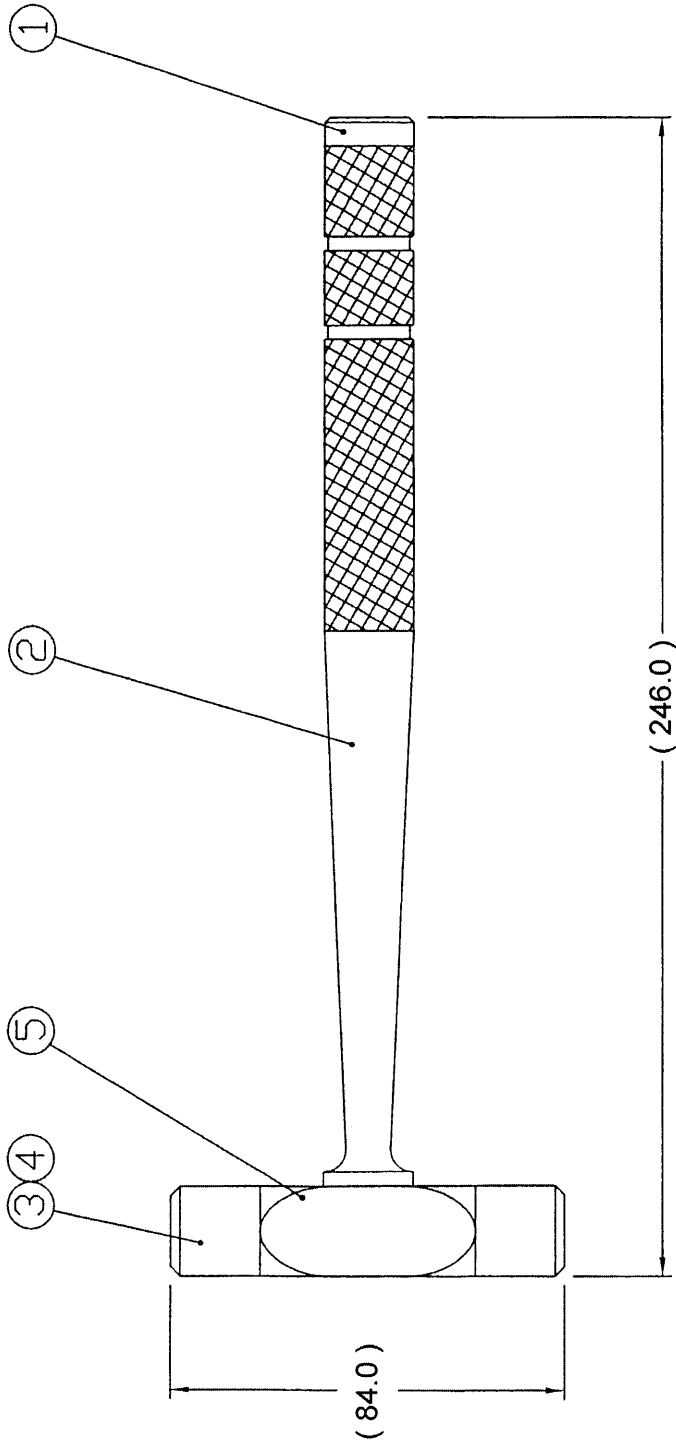
DRILL POINT GAUGE

DRAWN BY M. L'ECUYER	PROJECT INTRODUCTION TO BENCH WORK
VERIFIED BY	DRAWING 001
APPROVED BY	PAGE 1 OF 1
DATE 27/05/90	SCALE NOT TO SCALE

DIMENSION= IMPERIALE
TOLERANCES=

X ---
XX ---
XXX ---
XXXX ---
XXXXX ---

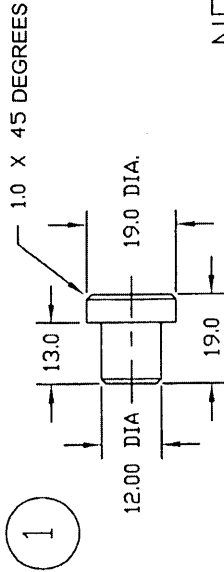
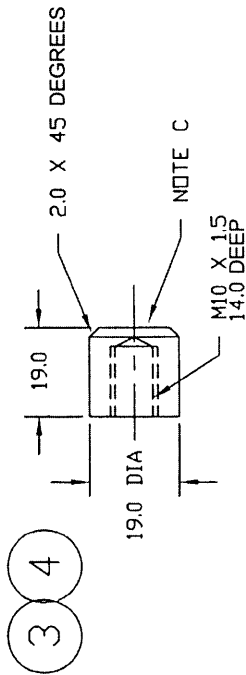
FRACTIONS= -- 1/64
ANGLES= -- 1 DEGRE
RAYONS= -- 1/64



ITEM	PART	QTE.	DESCRIPTION	MATERIAL
5	HEAD	1	19.5 X 19.5 X 80.0	C.R.S.
4	TIP 2	1	19.5 DIA. X 24.0	NYLON
3	TIP 1	1	19.5 DIA. X 24.0	KEEVATIN
2	HANDLE	1	19.5 DIA. X 237.0	C.R.S.
1	PLUG	1	19.5 DIA. X 24.0	C.R.S.

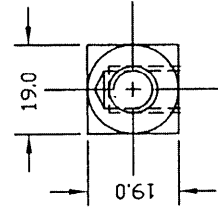
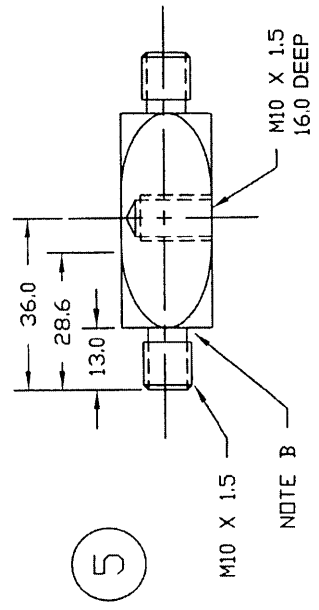
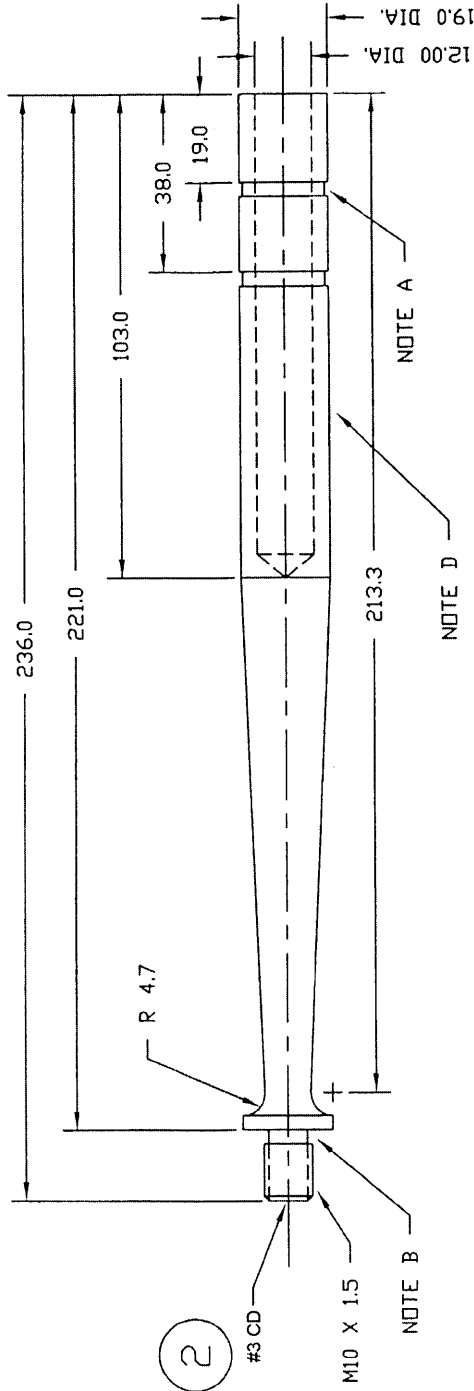
TITRE	
THAT LAZY MACHINIST	
POSITIONING HAMMER	
DRAWN BY	M L'ECUYER
PROJECT	METAL LATHE INTRODUCTION
VERIFIED BY	DRAWING 002
APPROVED BY	PAGE 1 OF 2
DATE	1990 06 23
	SCALE NOT TO SCALE

DIMENSION= METRIC
 TOLERANCES=
 X ++ .5
 XX ++ .3
 XXX ++ .1
 XXXX ++
 FRACTIONS= +-
 ANGLES= +- 30 MIN.
 RADII= +- .3



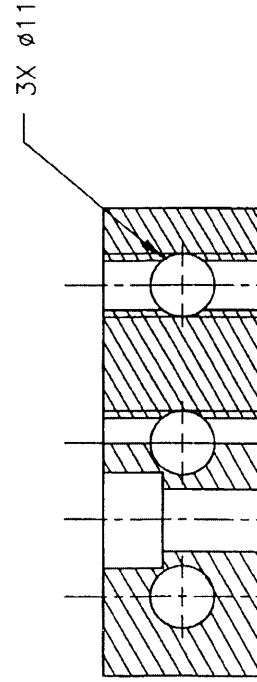
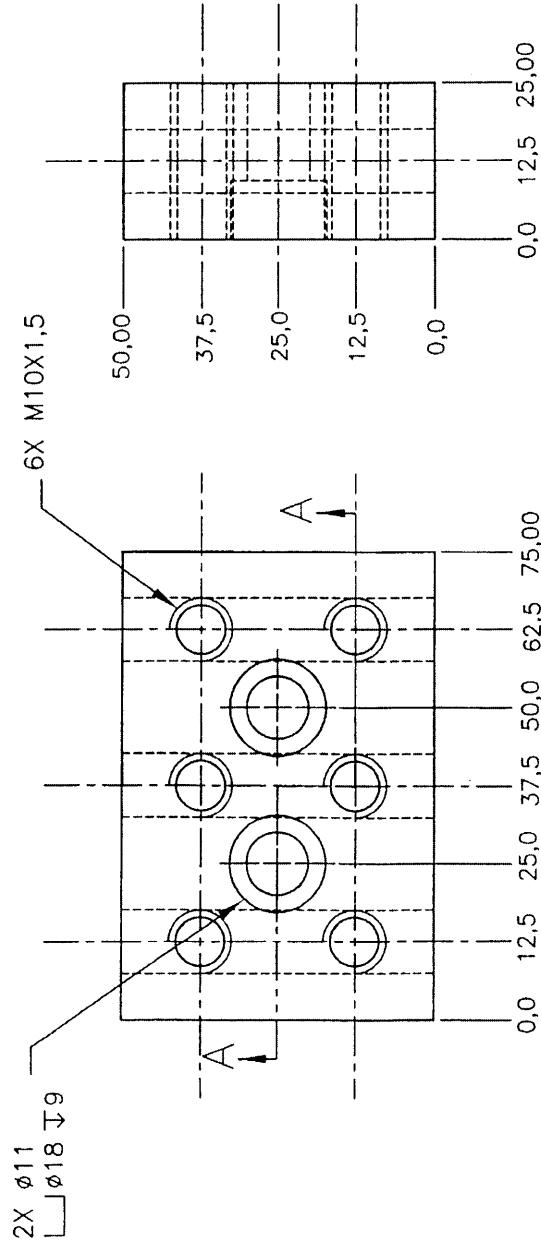
NOTES=

- A= GROOVES 3.0 X 16.5 DIA
2 PLACES
- B= GROOVES 3.0 X 8.0 DIA
3 PLACES
- C= PART 3 TO BE HARDENED
AND TEMPERED TO 48 Rc
- D= MEDIUM DIAMOND KNURL
ON 103 MM PORTION OF
HANDLE AS SEEN ON
ASSEMBLY DRAWING.

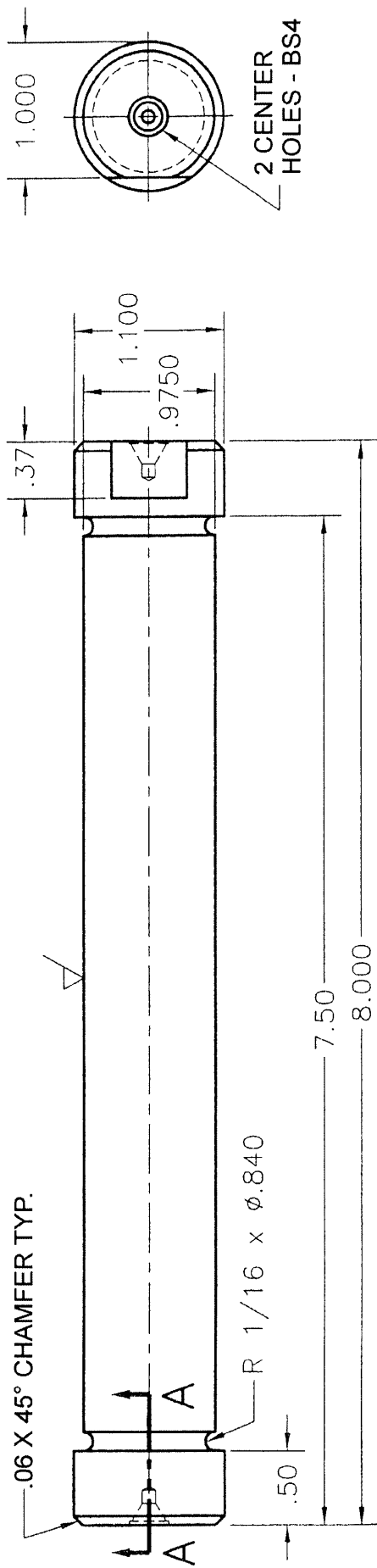


TITLE		THAT LAZY MACHINIST	
DIMENSION= METRIC		POSITIONING HAMMER	
TOLERANCES=		PROJECT	
X	++ .3	METAL LATHE INTRODUCTION	
XX	++ .05	DRAWING	
XXX	++	003	
XXXX	++	PAGE	
ANGLES=+-		2 OF 2	
RADII=+- .3		DATE	
		1990 06 24	
		SCALE	
		NOT TO SCALE	

- NOTES:
- 1- ALL EXTERIOR SURFACES TO BE GROUND
 - 2- REMOVE ALL SHARP EDGES
 - 3- HARDENED AND TEMPERED TO 45 - 50 Rc



1	BLOC	1	25,4 X 50,8 X 80	4140
ITEM	PART	QTE.	DESCRIPTION	MATERIAL
TITRE				
1-2-3 BLOC				
DIMENSIONS= METRIC		DRAWN BY		
TOLERANCES=		M L'ECUYER		
X = ±0,2	PROJECT	MILL, DRILL, GRIND 101		
XX = ±0,05	VERIFIED BY	IRON MAN		
XXX = ±	PROJECT #	1-3		
XXXX = ±	DATE	91/10/04		
FRACTIONS=±	REVISION	02/05/22		
ANGLES=±	DRAWING	1 DE 1		
RADII = +-	SCALE	NONE		



- NOTES: 1- STAMP IDENTIFICATION ON FLAT
 2- HARDENED AND TEMPERED, 46-52 RC
 3- GRIND ALL SURFACES INDICATED

1	BODY	1	Ø 1 1/8 x 8 1/8	AISI 4140
ITEM	PART	QTY	DESCRIPTION	MATERIAL

THAT LAZY MACHINIST

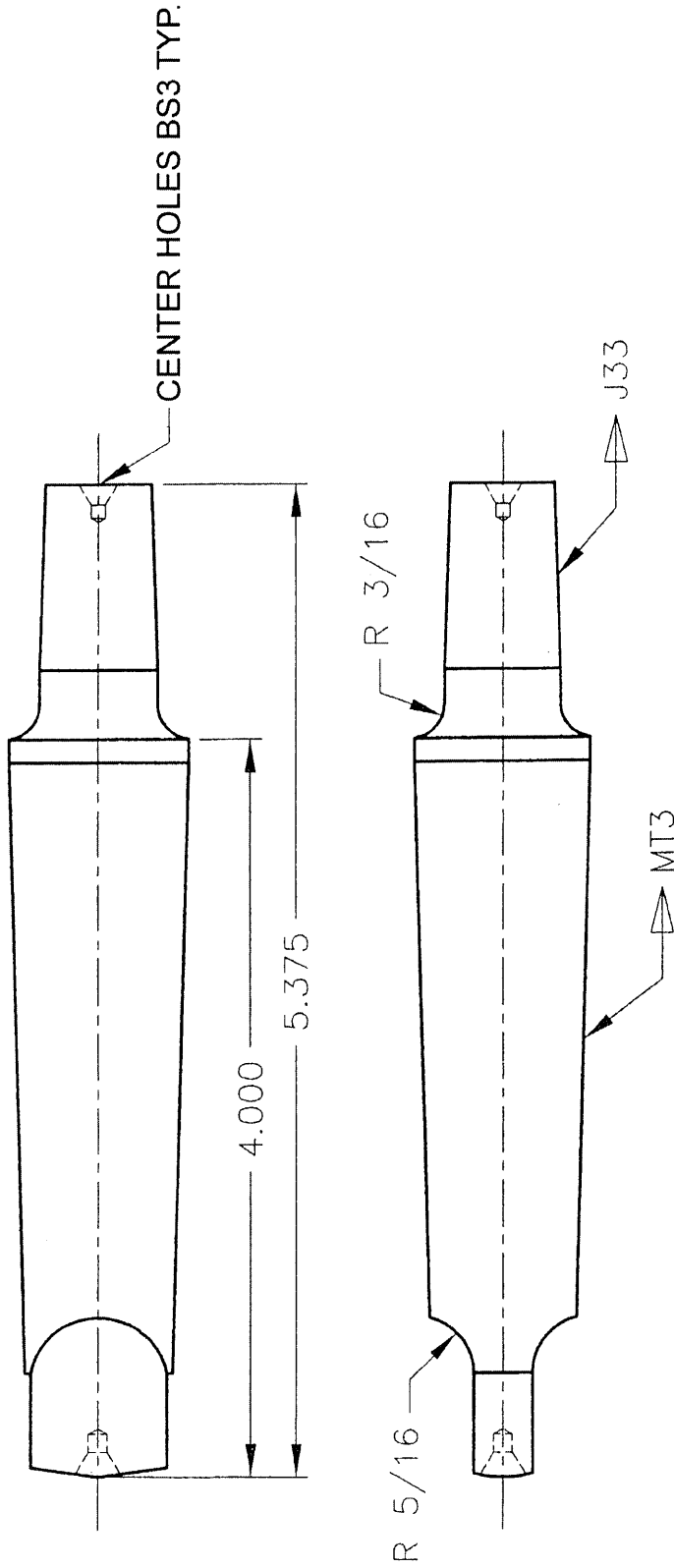
UNLESS SPECIFIED OTHERWISE
 DIMENSIONS = IMPERIAL
 TOLERANCES =

X = ±
 XX = ±.01
 XXX = ±.005
 XXXX = ±.0005

FRACTIONS = ± 1/64
 ANGLES = ± 0' 30'

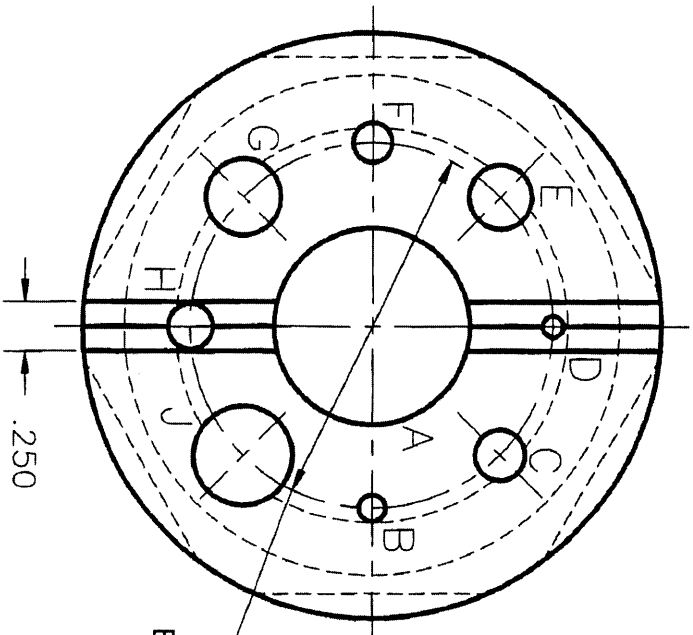
DRAWN BY	PROJECT
Y. LACHAPELLE	BASIC MACHINE SHOP
VERIFIED BY	DRAWING
M L'ECUYER	1 OF 1
APPROVED	SCALE
	NOT TO SCALE
DATE	
99/06/07	

SECTION A-A

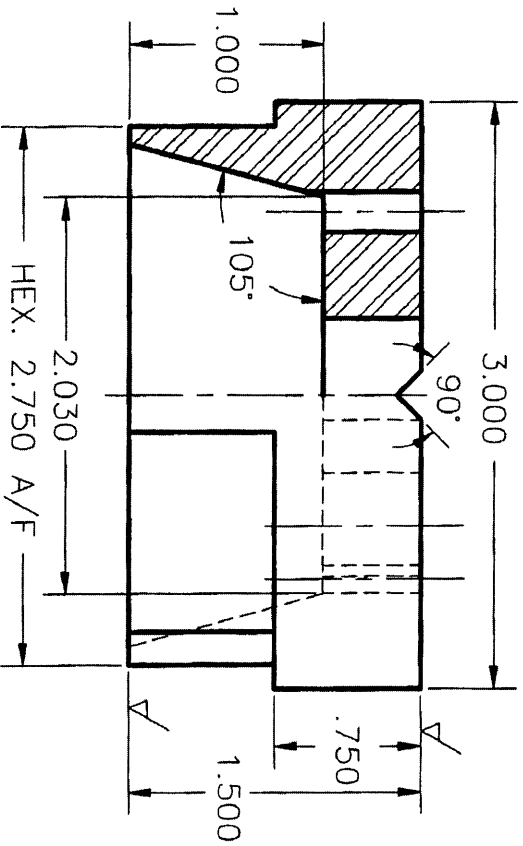


- NOTES: 1- STAMP IDENTIFICATION ON FLAT
 2- HARDEN AND QUENCH 48-52 RC
 3- BREAK ALL SHARP EDGES

1	BODY	1	Ø1 x 5 1/2	AISI 4140
ITEM	PART	QTY	DESCRIPTION	MATERIAL
THAT LAZY MACHINIST				
UNLESS SPECIFIED OTHERWISE TITLE				
DIMENSIONS= IMPERIAL				
TOLERANCES=				
X = ±				
XX = ±.01				
XXX = ±.005				
XXXX = ±.0005				
FRACTIONS= ±				
ANGLES= ±0° 30'				
DRAWN BY		PROJECT		
Y. LACHAPPELLE		BASIC MACHINE SHOP		
VERIFIED BY		DRAWING		
M L'ECUYER		1 OF 1		
DATE		SCALE		
02/05/17		NOT TO SCALE		
REVISED				



ϕ 1.875 -
 8 HOLES -
 EQUALLY SPACED



HOLE	DIAMETER	POSITION	
		X	Y
A	1.010	0	0
B	.141		
C	.266		
D	.109		
E	.328		
F	.203		
G	.391		
H	.234		
J	.516		

NOTES

- 1- HARDENED AND TEMPERED 45 - 50 RC
- 2- GRIND ALL SURFACES INDICATED ∇
- 3- REMOVE ALL SHARP EDGES

ITEM	PART	QTY	DESCRIPTION	MATERIAL
1	BODY	1	ϕ 3 1/8 X 1 3/4	AIISI 4140

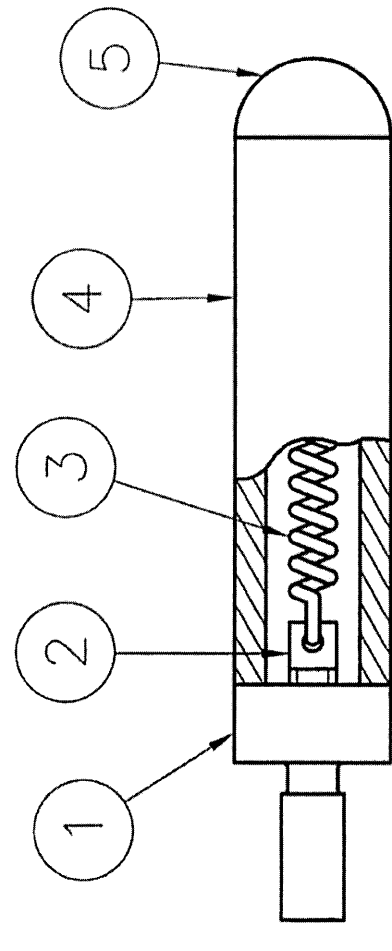
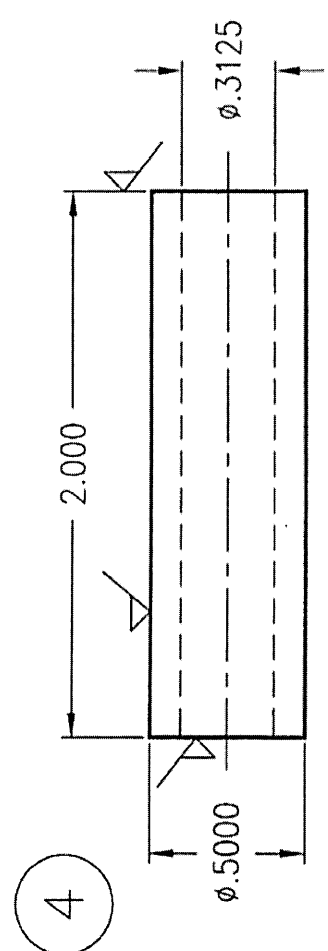
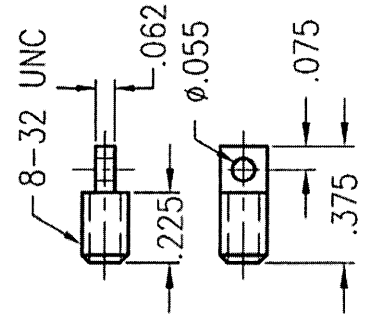
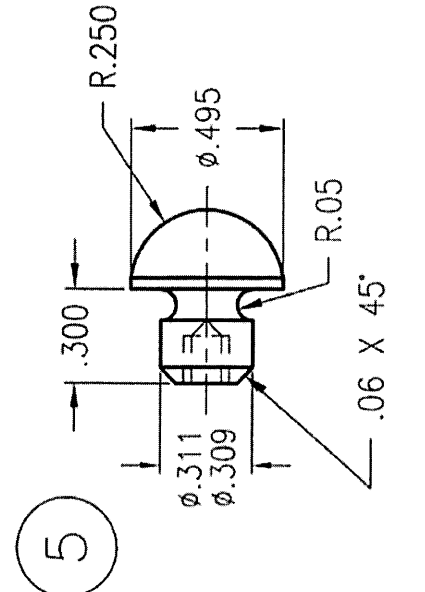
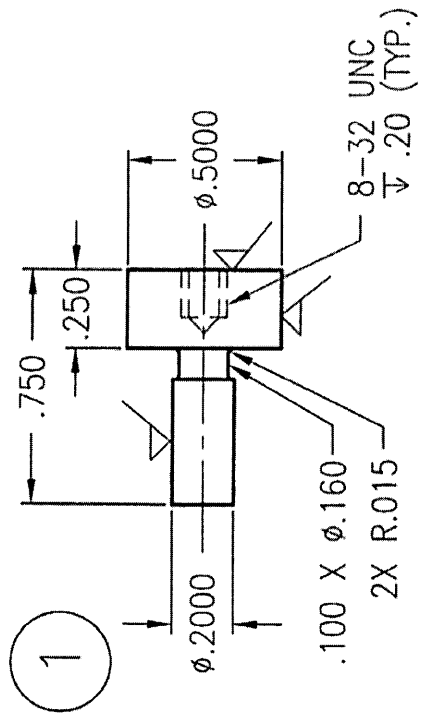
THAT LAZY MACHINIST

TITLE: **BENCH BLOCK**

UNLESS SPECIFIED OTHERWISE
 DIMENSIONS = IMPERIAL
 TOLERANCES =

X = ±
 XX = ±
 XXX = ±.005
 XXXX = ±
 FRACTIONS = ±
 ANGLES = ±0°30'

DRAWN BY Y. LACHAPELLE	PROJECT BASIC MACHINE SHOP
VERIFIED BY M L ECUYER	DRAWING 1 OF 1
DATE 99/06/07	SCALE NOT TO SCALE
REVISED 07/02/06	



NOTES: - PARTS 1 AND 4 TO BE HARDENED AND TEMPERED TO 58 - 60 RC
 - GRIND SURFACES INDICATED

ITEM	PART	QTY	DESCRIPTION	MATERIAL
5	PLUG	1	Ø 1/2 X 5/8	BRASS
4	BODY	1	Ø 5/8 X 2 1/8	ALSI 01
3	SPRING	1	WB E0120-020-1000M	STD
2	SCREW	2	Ø 3/16 X 1/2	C.R.S.
1	PROBE	1	Ø 5/8 X 7/8	ALSI 01

THAT LAZY MACHINIST

UNLESS SPECIFIED OTHERWISE TITLE: **EDGE FINDER**

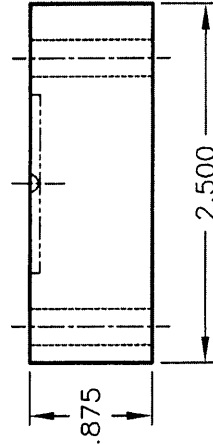
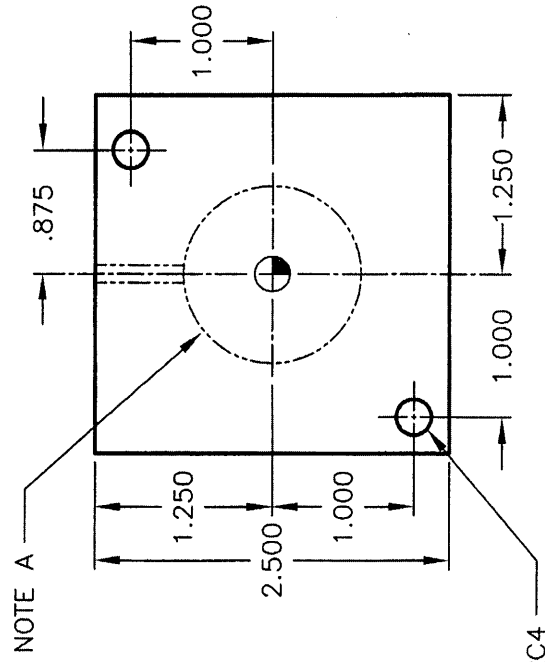
DIMENSIONS = IMPERIALES

TOLERANCES =

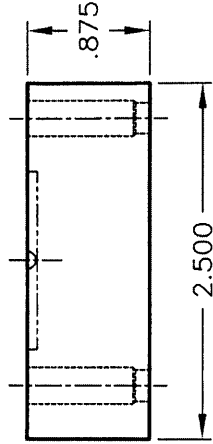
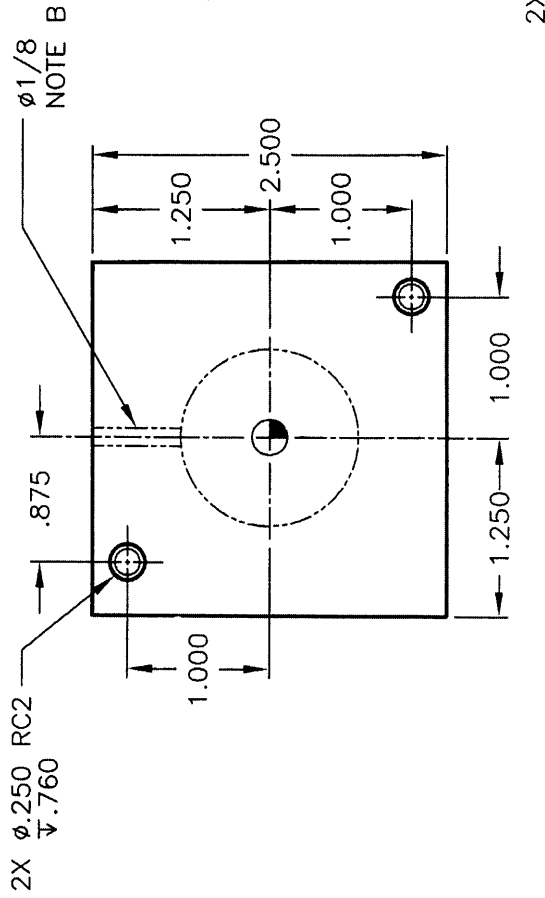
X = ± .01
 XX = ± .01
 XXX = ± .005
 XXXX = ± .0005

FRACTIONS = ±
 ANGLES = ±
 RADII = ± .010

DRAWN BY	PROJECT
M. L'ECUYER	BASIC MACHINE SHOP
VERIFIED BY	DRAWING
Y. LACHAPELLE	1 OF 1
DATE	SCALE
90/12/20	NOT TO SCALE
REVISED	
99/06/03	



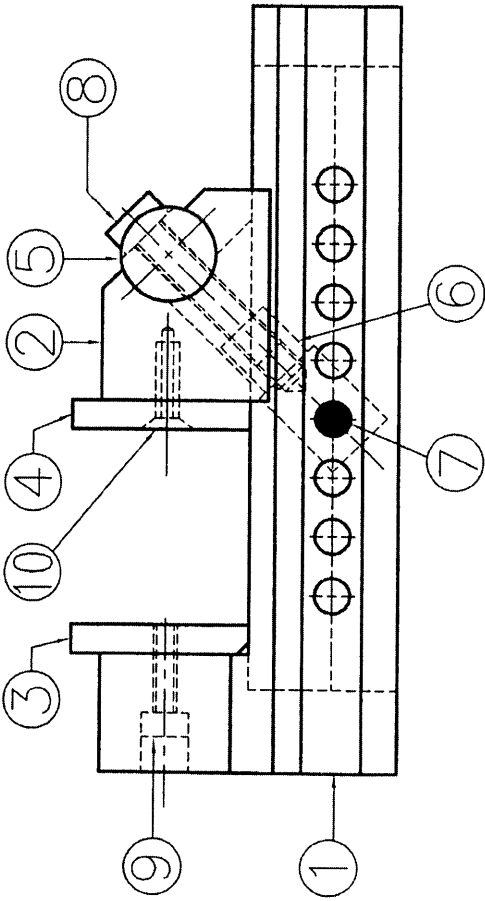
FRONT BLOCK



REAR BLOCK

NOTES : A- DEPTH OF CAVITY MUST BE .070, SHAPE IS PERSONAL BUT VOLUME MUST NOT EXCEED .2 CUBIC INCHES.
 B- SPRUE MUST BE DRILLED AND REAMED ON ASSEMBLY

1	BLOCK	2	2 1/2 x 2 5/8 x 1	6061-T6
ITEM	PART	QTY	DESCRIPTION	MATERIAL
THAT LAZY MACHINIST				
UNLESS SPECIFIED OTHERWISE				
DIMENSIONS= IMPERIAL				
TOLERANCES=				
X = ±				
XX = ± .005				
XXX = ± .002				
XXXX = ± .0005				
FRACTIONS= ± REVISED				
ANGLES= ± 0°30'				
TITLE		INJECTION MOLD		
DRAWN BY		PROJECT		
Y. LACHAPELLE		BASIC MACHINE SHOP		
VERIFIED BY		DRAWING		
M. L'ECUYER		1 OF 1		
APPROVED		SCALE		
07/01/05		NOT TO SCALE		
DATE		07/01/04		

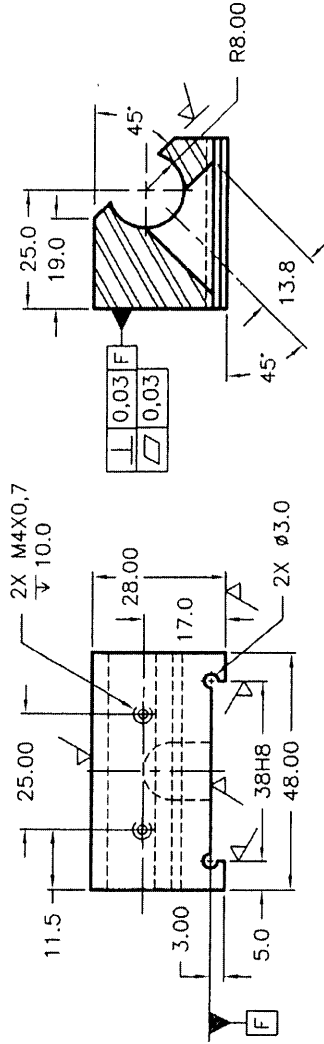


NOTES: - HEAT TREATMENT

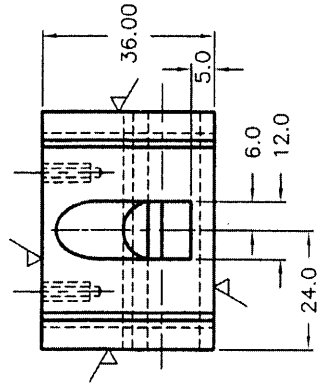
PARTS 1 & 2 : HARDEN & TEMPER 40 - 45 Rc

PARTS 3 & 4 : HARDEN & TEMPER 50 - 55 Rc

- GRIND ALL SURFACES INDICATED ▽



②



ITEM	PART	QTY	DESCRIPTION	MATERIAL
10	SCREW	2	FLAT HEAD SH - M4 X 0.7 X 10	STANDARD
9	SCREW	2	CAP SCREW SH - M4 X 0.7 X 16	STANDARD
8	SCREW	1	CAP SCREW SH - M6 X 1 X 30	STANDARD
7	DOWELL	1	HARDENED & GROUND Ø6 X 18	STANDARD
6	ANKOR	1	12.7 x 12.7 x 30	C.R.S. C1020
5	PIVOT	1	Ø19.05 x 50	C.R.S. C12L14
4	JAW	1	6.35 x 31.8 x 50	AISI 01
3	JAW	1	6.35 x 31.8 x 50	AISI 01
2	SLIDE	1	31.8 x 38.1 x 50	AISI 4140
1	BASE	1	50.8 x 50.8 x 134 LG.	AISI 4140

THAT LAZY MACHINIST

TITLE	
MACHINIST VICE	
DRAWN BY	PROJECT
Y. LACHAPELLE	BASIC MACHINE SHOP
VERIFIED BY	DRAWING
M. L'ECUYER	1 OF 2
DATE	SCALE
91/12/13	NOT TO SCALE
06/01/02	

UNLESS SPECIFIED OTHERWISE

DIMENSIONS= METRIC

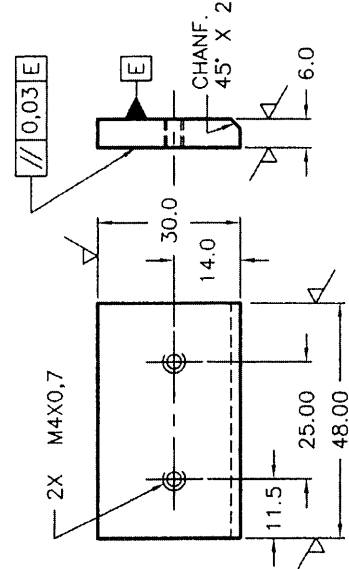
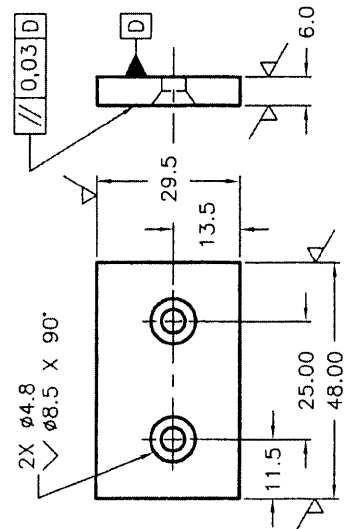
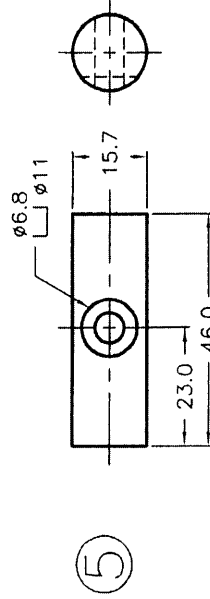
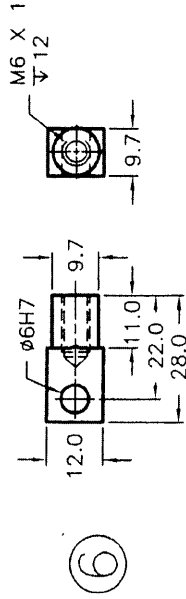
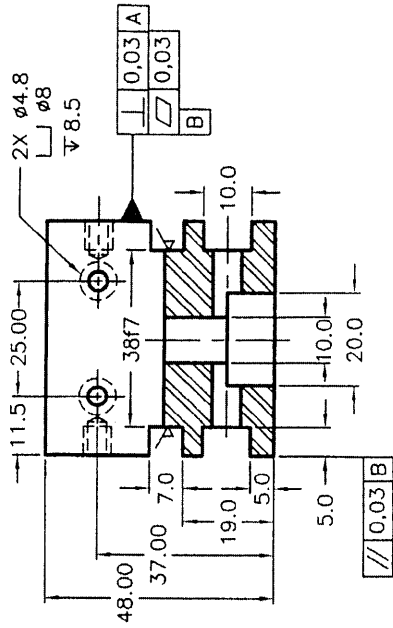
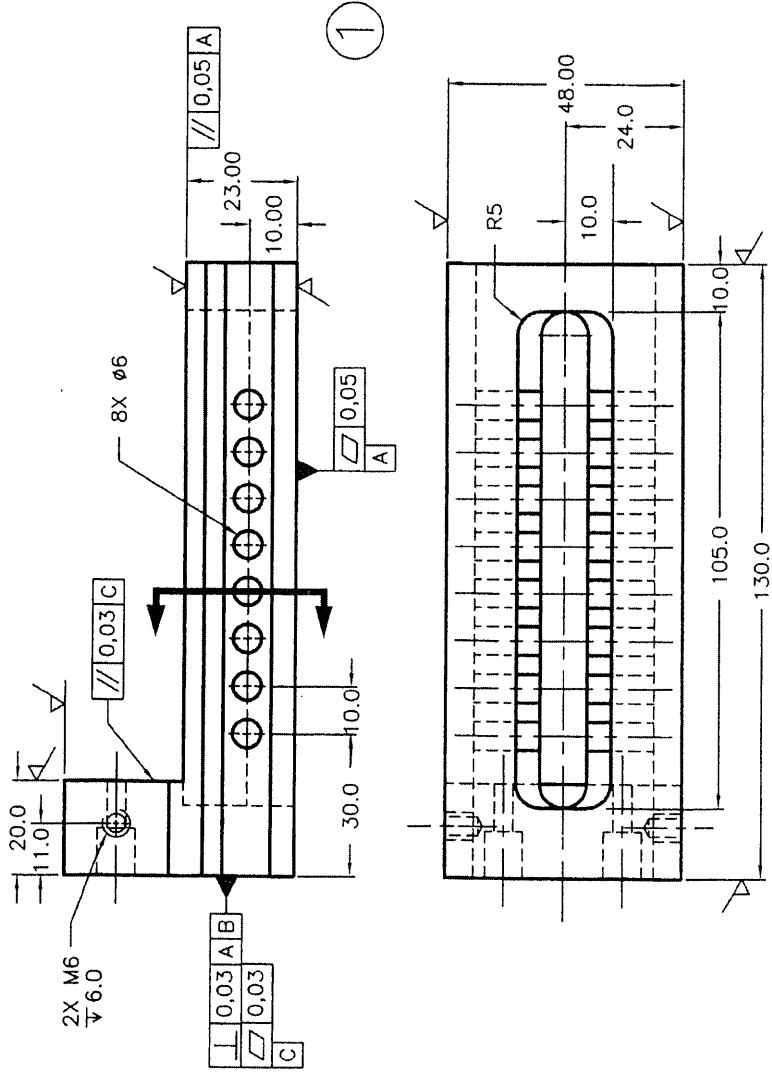
TOLERANCES=

- X = ± 0,25
- XX = ± 0,05
- XXX = ±
- XXXX = ±

FRACTIONS= ±

ANGLES= ± 0°30'

RAYONS= ±



UNLESS SPECIFIED OTHERWISE DIMENSION = METRIC TOLERANCES =		TITLE THAT LAZY MACHINIST	
X = ± 0.25	XX = ± 0.05	DRAWN BY Y. LACHAPPELLE	PROJECT BASIC MACHINE SHOP
XXX = \pm	XXXX = \pm	VERIFIED BY M. L'ECUYER	DRAWING 2 OF 2
FRACTIONS = \pm	ANGLES = $\pm 0'30''$	DATE 91/12/13	SCALE NOT TO SCALE
		REVISED 06/01/02	

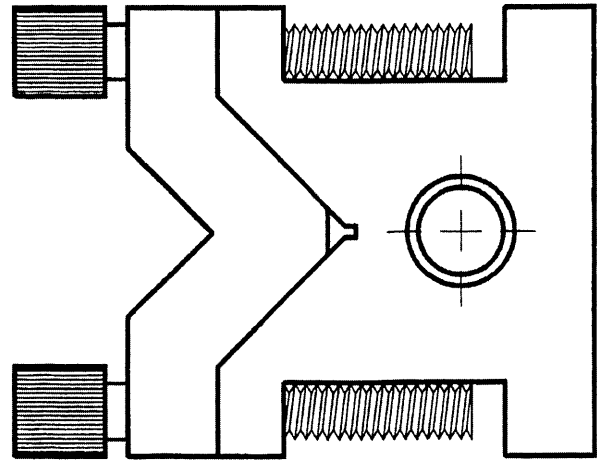
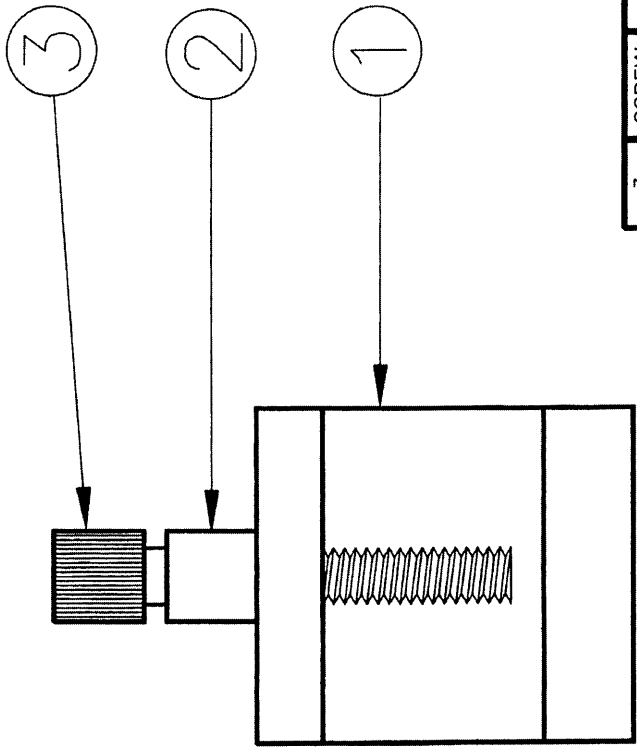
1

3

4

5

6



ITEM	PART	QTY	DESCRIPTION	MATERIAL
3	SCREW	2	1/4-20 UNC	STANDARD
2	CLAMP	1	1/2 X 1 2 1/8	C1020
1	BLOCK	1	2 X 2 X 2 1/8	AISI 4140

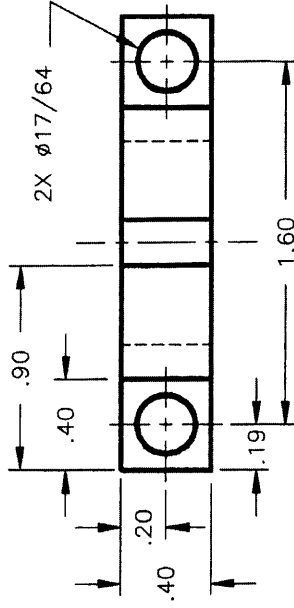
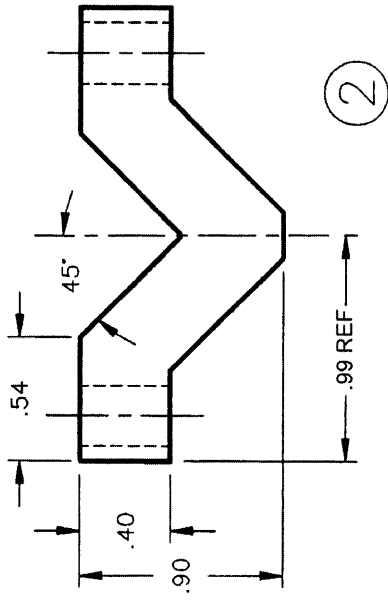
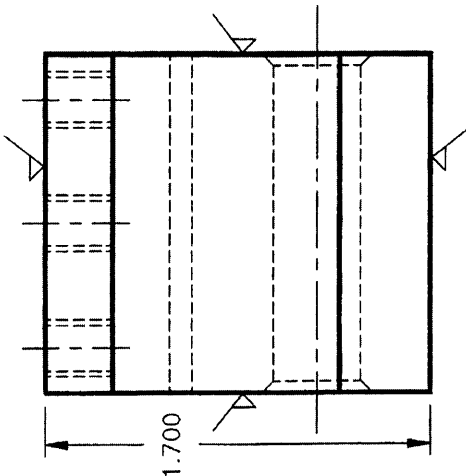
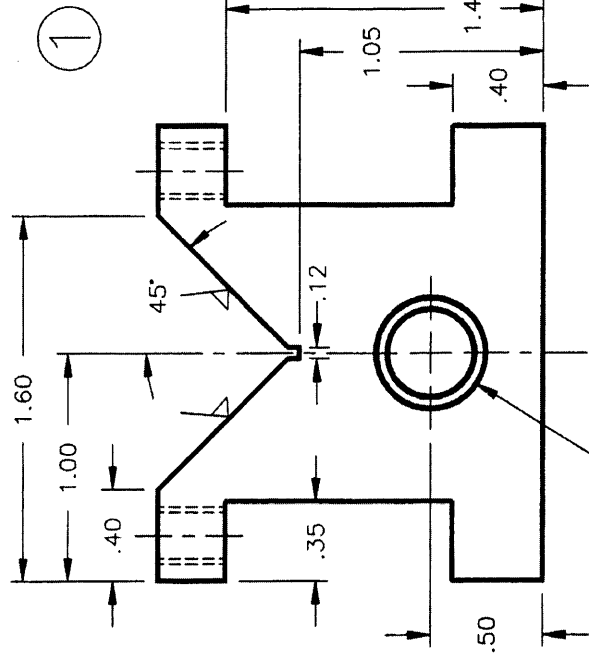
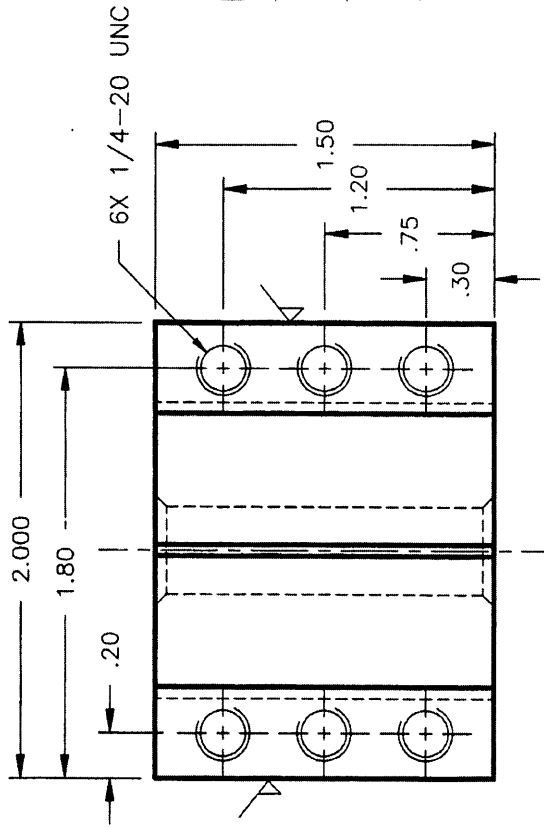
THAT LAZY MACHINIST

TITLE: **V BLOCK**

UNLESS SPECIFIED OTHERWISE
 DIMENSION = IMPERIAL
 TOLERANCES =

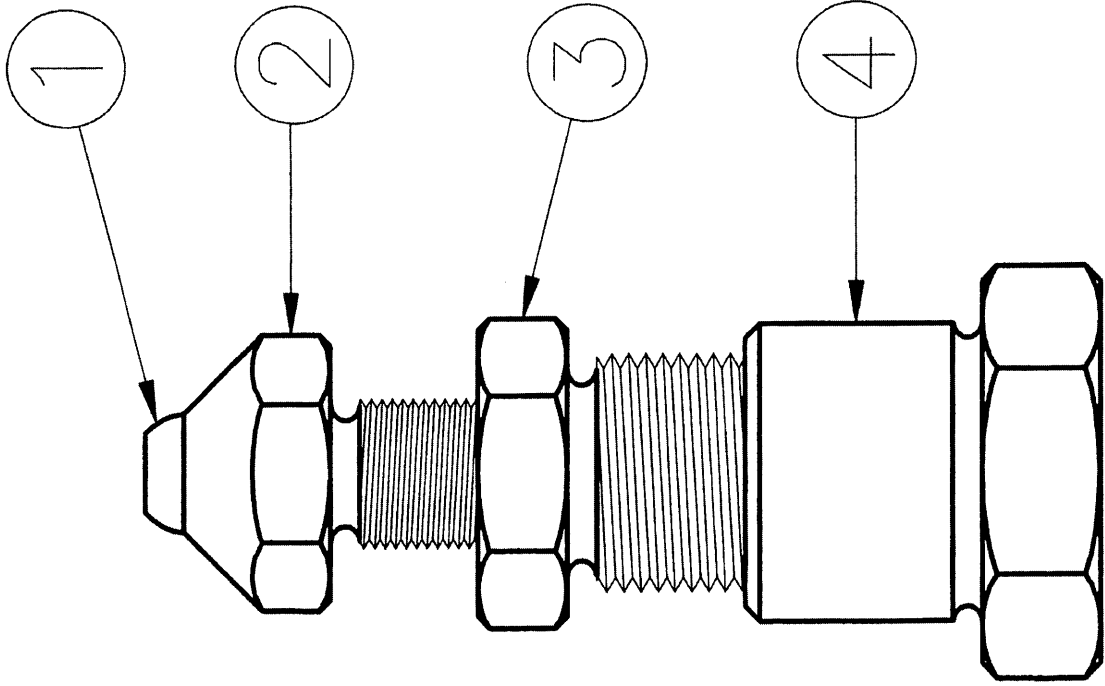
X = +-
 XX = +-
 XXX = +-
 XXXX = +-
 FRACTIONS = +-
 ANGLES = +-
 RAYONS = +-

DRAWN BY	M L ECUYER	PROJECT	BASIC MACHINE SHOP
VERIFIED BY	Y. LACHAPPELLE	DRAWING	1 OF 2
DATE	90/12/17	SCALE	NOT TO SCALE
REVISED	06/12/21		



- NOTES:
- PART 4 TO BE HARDENED AND TEMPERED TO 50 Rc
 - GRIND ALL SURFACES INDICATED
 - THE "V" MUST BE CENTERED ON THE BLOCK TO ± 0.001"

THAT LAZY MACHINIST		V BLOCK	
UNLESS OTHERWISE SPECIFIED DIMENSION= IMPERIAL TOLERANCES=	TITLE	DRAWN BY M L'ECUYER	PROJECT BASIC MACHINE SHOP
X = ±0.015 XX = ±0.005 XXX = ±0.002 XXXX =		VERIFIED BY Y. LACHAPPELLE	DRAWING 2 OF 2
FRACTIONS= ±1/64 ANGLES= ±15 MINUTES		DATE 90/12/18	SCALE NOT TO SCALE
		REVISED 06/12/21	



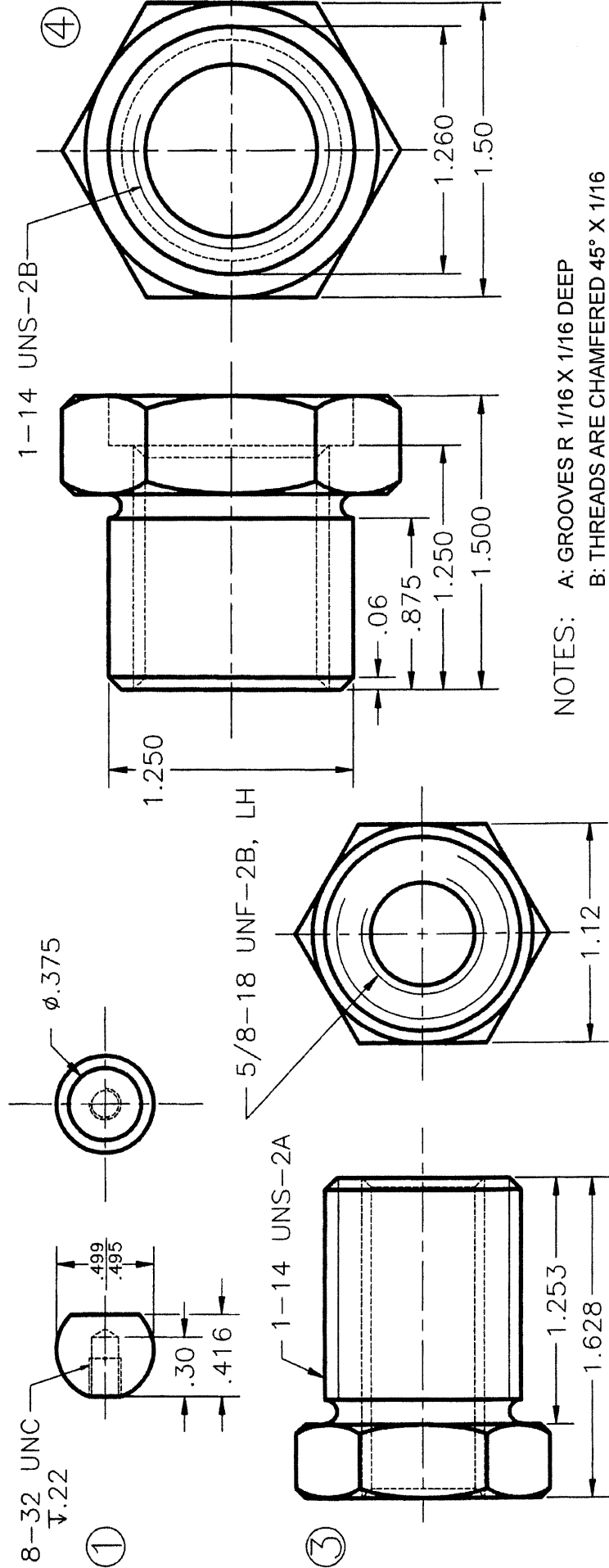
NOTE: EDGE OF PART 2 IS ROLLED ON ASSEMBLY IN ORDER TO HOLD IN PART 1 BUT NOT SO TIGHT AS TO IMPEDE ALL MOVEMENT

ITEM	PART	QTY	DESCRIPTION	MATERIAL
5	SET SCREW	1	8-32 UNC X 3/8 LG	STANDARD
4	BASE	1	HEX 1 1/2 AF X 1 3/4	C12L14
3	BODY	1	HEX 1 1/8 AF X 1 3/4	C12L14
2	HEAD	1	HEX 1 AF X 2 1/8	C12L14
1	PIVOT	1	ø5/8 X 1 1/4	AISI4140

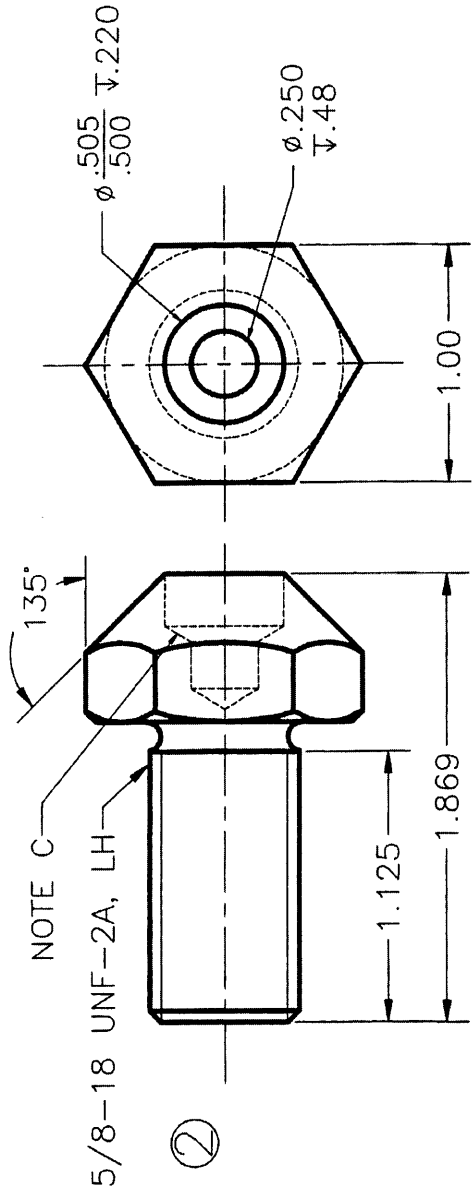
THAT LAZY MACHINIST

TITLE	
SCREW JACK	
DRAWN BY: M L'ECUYER	PROJECT: BASIC MACHINE SHOP
VERIFIED BY: Y LACHAPPELLE	DRAWING 1 OF 2
DATE 99/06/07	SCALE NOT TO SCALE
REVISED 08/12/22	

UNLESS SPECIFIED OTHERWISE
 DIMENSIONS= IMPERIAL
 TOLERANCES=
 X = ±
 XX = ±
 XXX = ±
 XXXX = ±
 FRACTIONS= ±
 ANGLES= ±



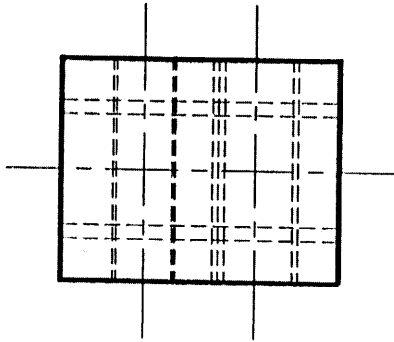
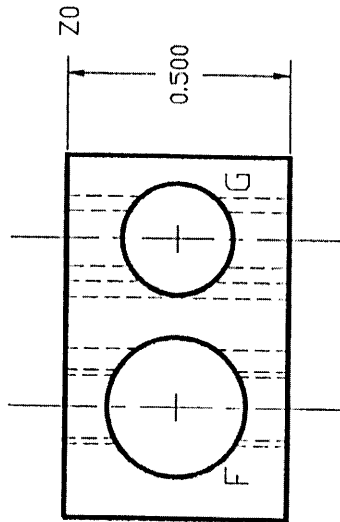
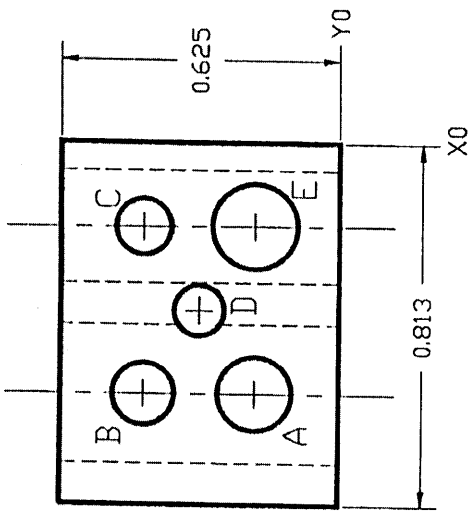
NOTES: A: GROOVES R 1/16 X 1/16 DEEP
 B: THREADS ARE CHAMFERED 45° X 1/16
 C: STANDARD DRILL POINT ANGLE OF 118°
 D: ALL CAMFERS ARE 45°
 E: PART 1 IS HARDENED AND TEMPERED TO 48 Rc



THAT LAZY MACHINIST		PROJECT	
UNLESS SPECIFIED OTHERWISE		BASIC MACHINE SHOP	
DIMENSIONS = IMPERIAL		DRAWING 2 OF 2	
TOLERANCES =		SCALE	
X = ±	XX = ± .01	DATE	99/06/07
XXX = ± .005	XXXX = ±	REVISED	08/12/22
FRACTIONS = ±		NOT TO SCALE	
ANGLES = ± 30'			

SCREW JACK

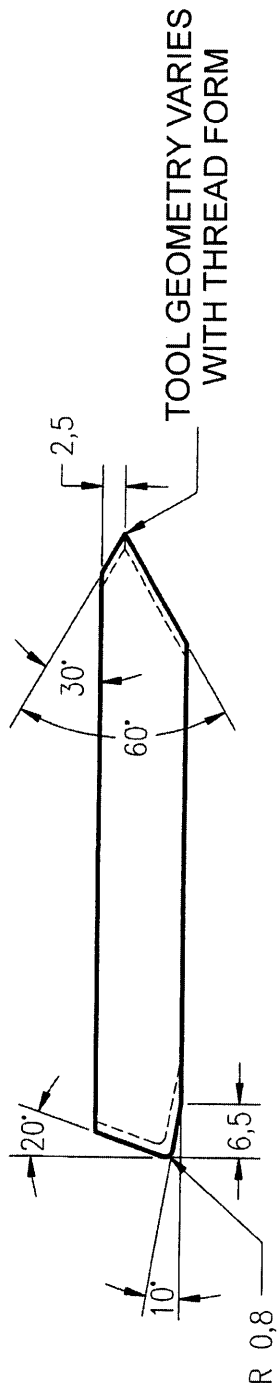
DRAWN BY: M. L'ECUYER
 VERIFIED BY: Y. LACHAPELLE
 DATE: 99/06/07
 REVISED: 08/12/22



HOLE	X	Y	Z	Ø
A	-.56	.18	—	.166
B	-.56	.43	—	.140
C	-.18	.43	—	.125
D	-.37	.31	—	.113
E	-.18	.18	—	.191
F	-.56	—	-.25	.312
G	-.18	—	-.25	.250

- NOTES:
- 1: GRIND ALL EXTERIOR SURFACES
 - 2: REMOVE ALL SHARP EDGES
 - 3: HARDEN AND TEMPER TO 40 - 45 Rc

ITEM	BLOCK	QTY.	DESCRIPTION	MATERIAL
1	BLOCK	1	5/8 X 1/2 X 1	4140
THATLAZYMACHINIST				
TITLE TAP BLOCK				
DIMENSIONS = IMPERIAL				
TOLERANCES =				
X	=++			
XX	=+- .010			
XXX	=+ .005			
XXXX	=++			
DRAWN BY M. L'ECUYER				
PROJECT MILLING & DRILLING 101				
VERIFIED BY Y. LACHAPPELLE				
DRAWING 16				
APPROVED BY				
PAGE 1 OF 1				
DATE 03/06/91				
SCALE NOT TO SCALE				



NOTE: ALL SIDE RELIEF ANGLES ARE 8°

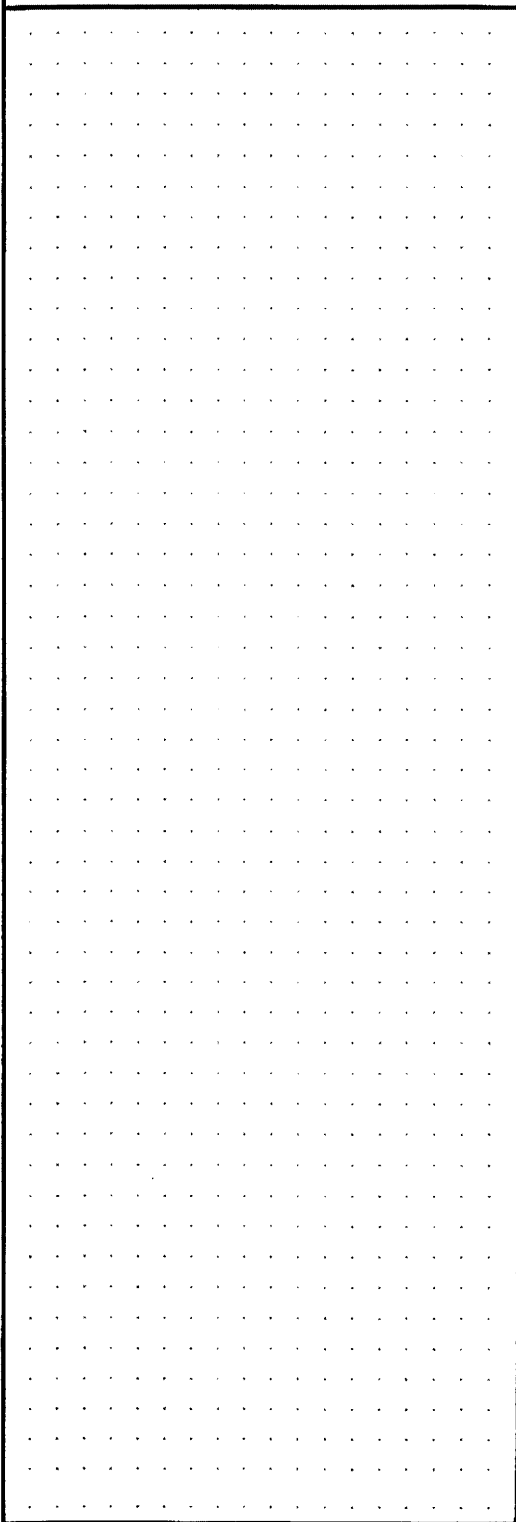
1	TOOL	1	9,5 ∅ x 70	C1020
ITEM	PART	QTY	DESCRIPTION	MATERIAL
THAT LAZY MACHINIST				
UNLESS OTHERWISE SPECIFIED				
DIMENSIONS= METRIC				
TOLERANCES=				
X	=	±		
XX	=	±0,4		
XXX	=	±0,15		
XXXX	=	±		
ANGLES= ±0° 15'				
TITLE GENERAL PURPOSE TURNING TOOL				
DRAWN BY		PROJECT		
Y. LACHAPELLE		MACHINE SHOP 101		
VERIFIED BY		DRAWING		
M L'ECUYER		17592 OR SOMETHING		
APPROVED		SHEET		
06/12/21		1 OF 1		
DATE		SCALE		
95/01/02		NOT TO SCALE		

THATLAZYMACHINIST.COM

SEQUENCE OF OPERATIONS

Project: _____ Part: _____ Quantity: _____

Prepared by: _____ Material: _____

SKETCH	OPERATION	TOOLING	RPM/FEED
			

SKETCH	OPERATION	TOOLING	RPM/FEED
