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Not big on change overs/tool changes, if i can find a short cut, normally ill give it a shot, so i made up six (really seven, but one came out alittle short) MT3 blanks which will find some kind of use down the road.



4# center drill is my go to for center drilling for tail-stock live center use so a dedicated holder seemed like a good idea.

Currently both of my drill chucks are 1/2", which is too small for the 5/8 shank on a 7# center drill so that will go in the shorter blank (not that i will use the 7# center too much, but while i was at it figured i would make a holder for it).

- Popped a blank in the tail-stock and a center drill in the chuck.
- Then drilled .010 under size
- Finished with two reamers, "under/over" (4# center drill is .312 dia so first reamed with .311 and then finished with the .313 reamer)
- Put a 1.5 MT3 socket in the milling vice, center drilled, drilled and tapped.
- Ground a flat on the center drills for the set-screws to seat on.





End result:



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Comments

Looks good. I like the idea
Submitted by Anonymous (not verified) on Thu, 05/23/2013 - 12:30.

Looks good. I like the idea of making all the blanks at a single sittings. Thanks for the idea.

Glad you like it.Not that
Submitted by [Joe](#) on Fri, 05/24/2013 - 05:47.

Glad you like it.Not that setting up the tail-stock is a big deal, but once its set, it does make the rest of the blanks a 1-2-3 job even if you do not have any immediate plans for them.

Great! How did you get the
Submitted by Mike (not verified) on Tue, 05/14/2013 - 02:22.

Great! How did you get the blanks to be so shinny in the top right pic, next to your tool box ?

Used emery paper; 220, 320

Submitted by [Joe](#) on Tue, 05/14/2013 - 11:52.

Used emery paper; 220, 320 then stich brite (gray, thats what i had for woodworking). The finish from the tool was not too bad, did not have to do alot of work to get them smooth... They are *not* like ground and polished, but they are pretty good.

Great post

Submitted by [drill press \(not verified\)](#) on Wed, 07/29/2015 - 15:42.

One thing I do for multiples is use a round faceplate with four 'sides' added to it to trap and center the rosette block. Then a center screw in from the back will hold the blank in place, and the sides keep it from spinning.
