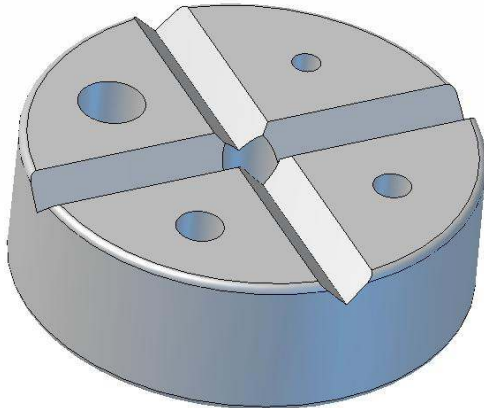


Hockey Puck V Bench Block, version 3

By R.G. Sparber



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Here is a simple and very old idea I picked up from the last Valley Metal Club² swap meet. It was told to me by “Beevo” and is a trick from the jewelry making community.

Take an old hockey puck, securely clamp it down to the mill table, and cut a V using a centering drill. I chose to use a 3/8” centering drill and ran it at 440 RPM. I also made 4 light passes because I didn’t know how well the clamps would hold on the puck.

The new bench block nicely grabs small cylinders placed in the V plus should provide a fair amount of friction between the bottom of the puck and a drill press table. For those cases where I just want to knock a hole in a rod, this new fixture should be rather handy.



¹ You are free to copy and distribute this article but not to change it.

² See <http://www.valley-metal.org/> for details about our club.

Many improvements were suggested after the initial publication of this article. All of the following came from the Yahoo group Mill_drill group.

Glenn N wrote -

“If you would mill an X you could have a smaller V for small stuff and an indication where the hole in the center of the puck is. Perhaps a few through holes in sizes appropriate for knocking pins out. The holes could even hold the pin in some cases.”

“Starlight Tool Services” pointed out -

“Most useful change I would make would be to drill a hole in the centre; usually 3/8" is what is common. Then drill about 4 more holes in each quadrant ranging from 3/32 to 5/16. The most common use of these is for removing split pins etc from shafts so having that hole in the bottom of the vee gives the pin an escape route.”

And also -

“Nylon and Rubber ones are used when the shaft you want to remove the pin from would be marred when hammered against a steel bench block. Also the rubber in a hockey puck is so dense you would not get much of a bounce from it.”

Paul Alciatore added –

“Seems to me that a variety of bench blocks would be useful: steel, brass or aluminum, hard rubber; different sizes, different sized holes.”

Dorn Peterson explained -

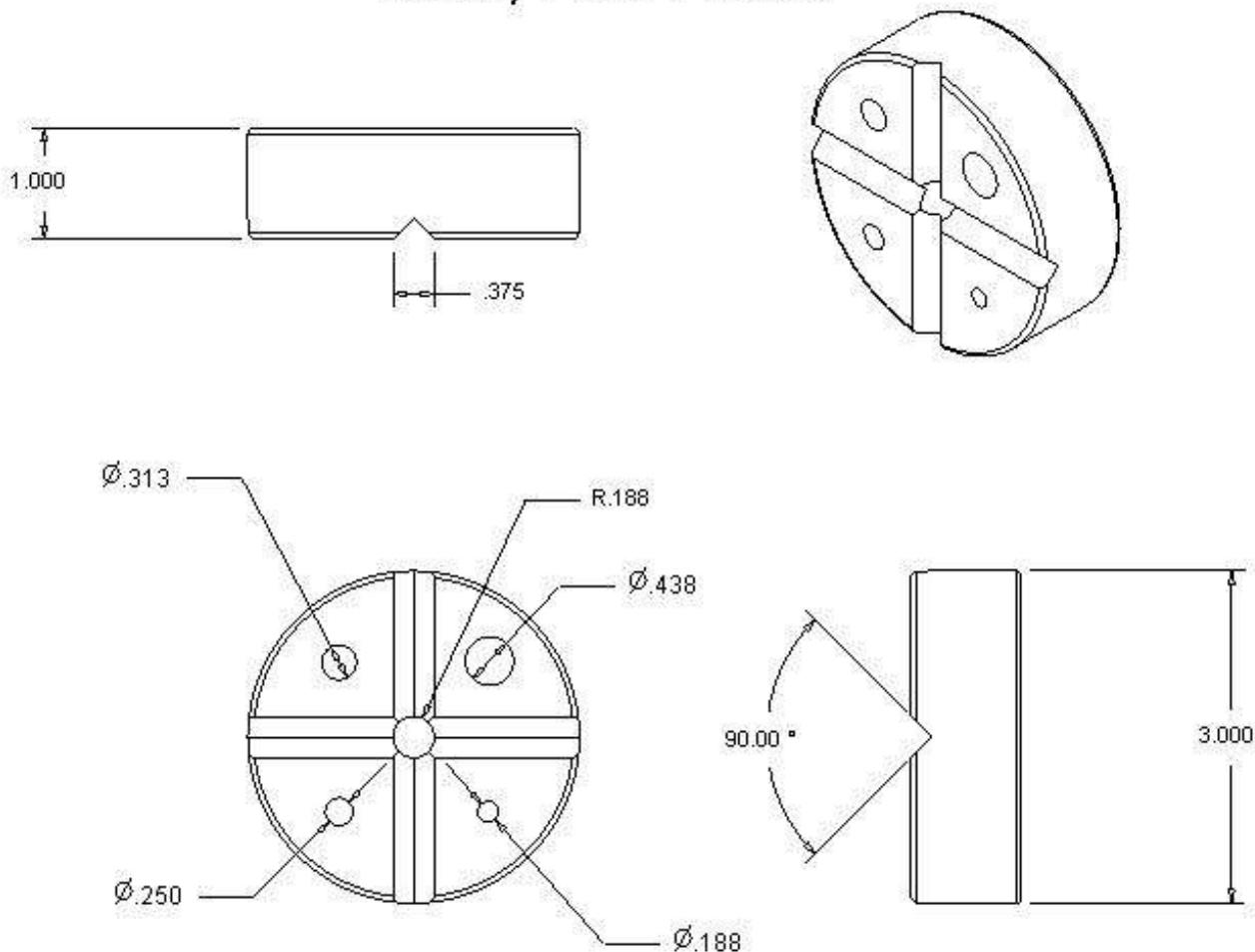
“One reason for having a hole in the center of the puck, centered on the single V you made or at the center of the X if you made it that way is because you can

center it up by chucking a rod in the drill chuck and insert the rod into the hole in the puck BEFORE you clamp the puck to the table. Depending on the fit you have (maybe put a metal bushing in the hole to keep it more accurate) it should be accurate to a couple of mils.”

Lead was also mentioned although health concerns cause me to stay with hard rubber.

And finally, I wanted to show off my newly formed skill with Alibre CAD ☺

Hockey Puck V Block



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