

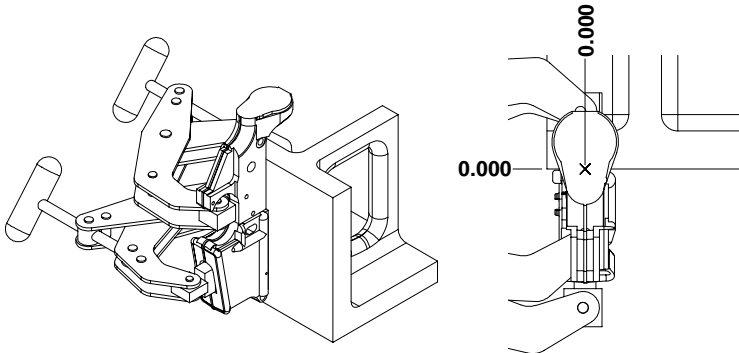
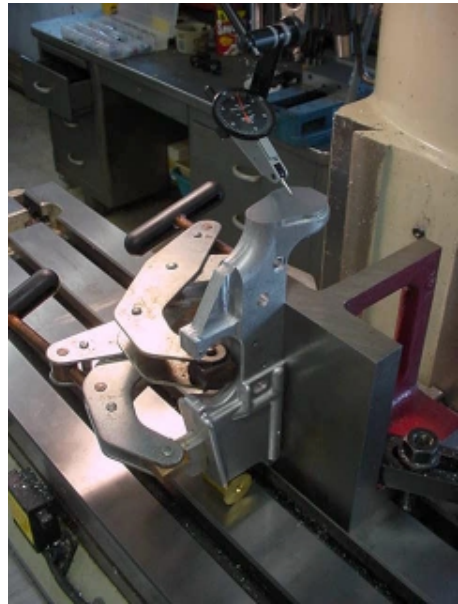
# Chapter 5

## The Buffer End

In this setup we will put in the hole for the bolt release pivot, take-down pin detent hole, the buttstock key hole and bore and thread the hole for the buffer tube. Also, two more surfaces on the pistol grip mount will get finished.

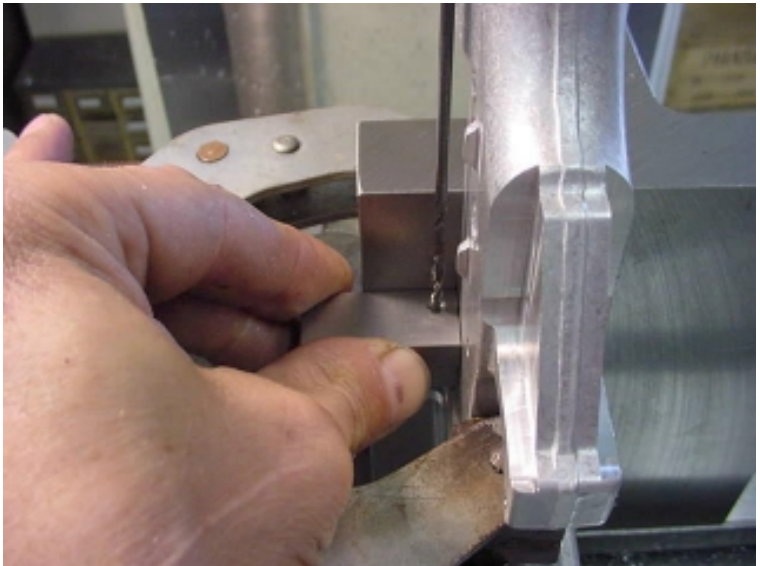
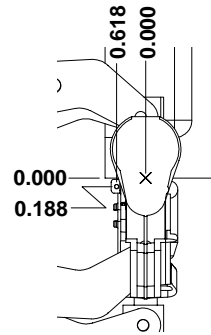
**Work Holding:** Once again, clamp the top face of the receiver to the angle plate in the orientation show at the right with the buffer end of the receiver up. Indicate it true and tighten the clamps.

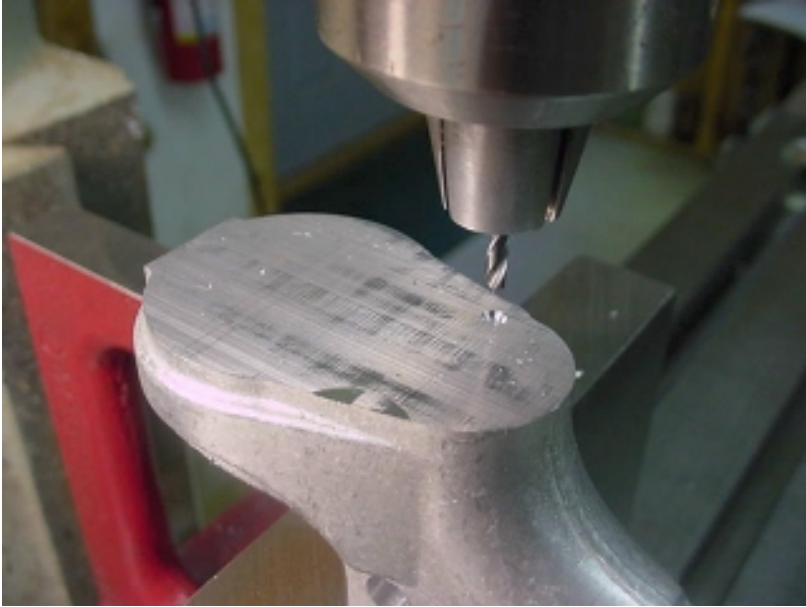
**Locating the spindle:** With you edge finder, locate the center of the .375 pistol grip mount. If you prefer, find the center using the left and right cheeks. This will be zero on the X axis. Edge find the face of the angle plate and make this surface zero. This will be your zero on the Y axis.





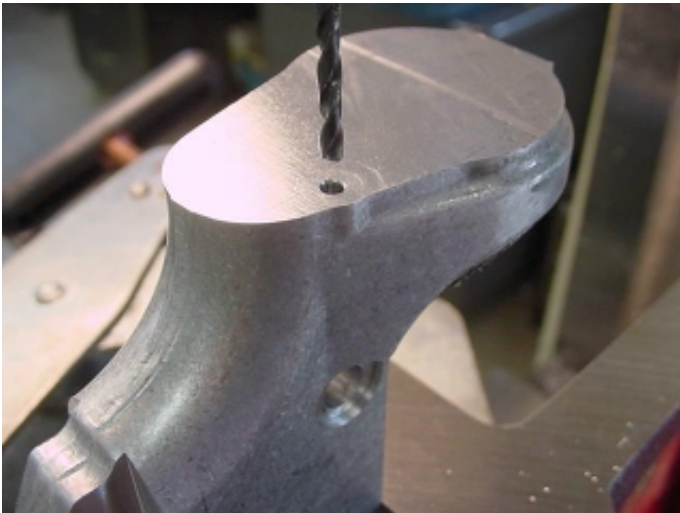
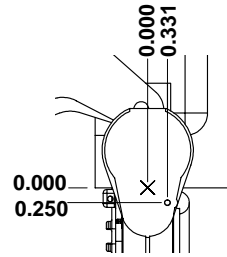
Locate the spindle at 0.618-.188 and chuck that long 3/32 drill. Here is where you will use that little block I told you to make in chapter one. Hold the block tightly against the angle plate and the forging. The drill should line up exactly with the hole in the block. Holding the block tightly, drill the hole through the lug on the forging. Drilling this hole any other way will drive you nuts!





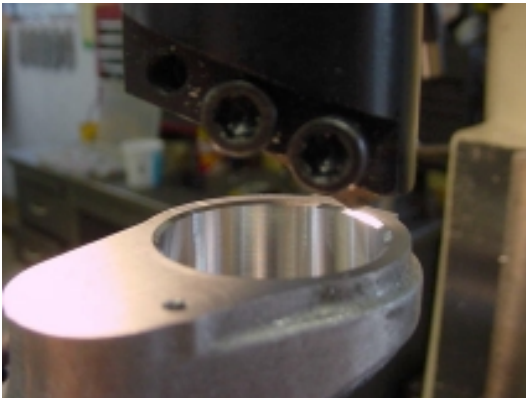
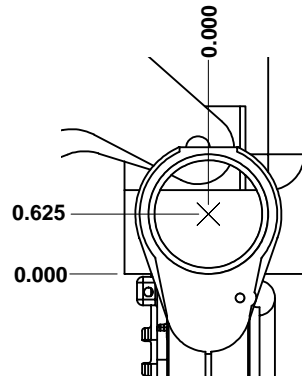
Next is the hole for the take down pin detent. Locate your spindle at 0.331-0.250 and drill a 3/32" hole down to the take down pin hole.

When drilling deep holes, a poor start will get the drill walking off right away. Start the hole with the drill choked up close in the chuck. Once the hole is started, chuck the bit normally and finish the hole.





Now for the buffer tube hole.  
Locate your spindle at 0.000-0.625 and bore a 1.125" hole through the tang.



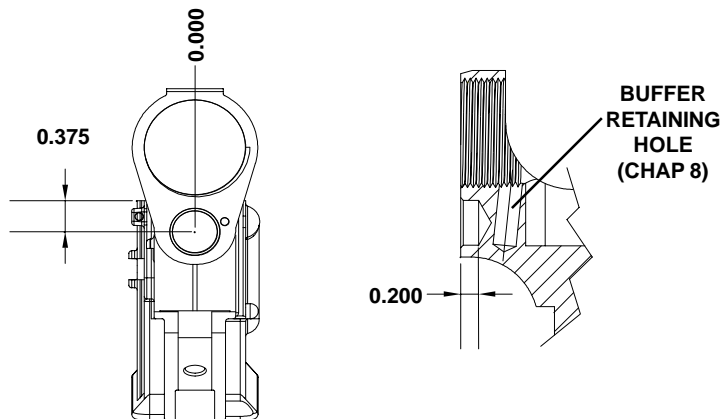
You can put a tool in your boring head or flycutter to put a nice 45 degree chamfer on the corner.

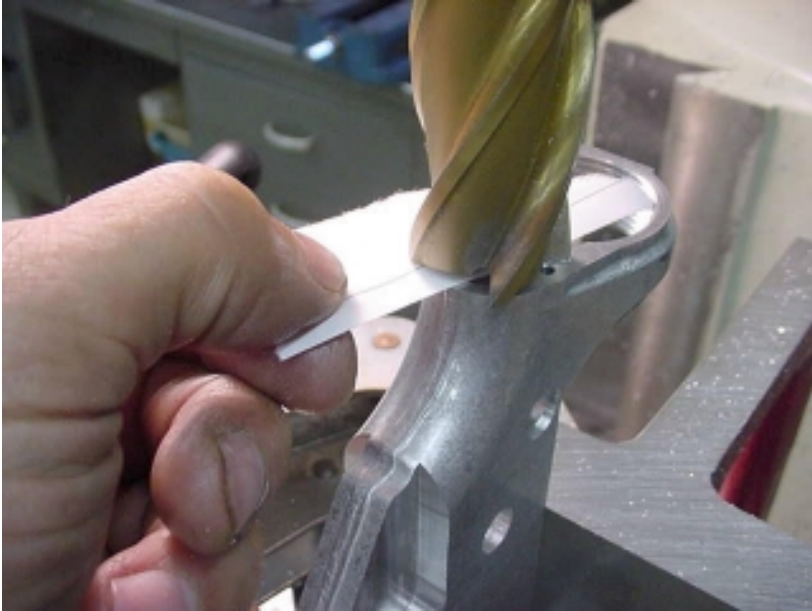


If you have the 1-3/16 - 16 tap go ahead and tap the hole. Put a center in the spindle to keep the tap aligned and with a light pressure on the down handle turn the tap with a wrench. If you don't have a tap, you can single-point the thread in a lathe, see the appendix.



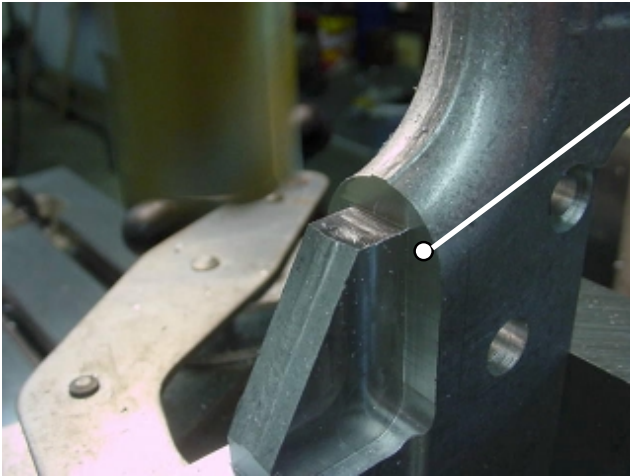
At 0.000-0.375 spot and bore the buttstock anti-rotation hole. The size of this hole is 0.499 plus .004 minus nothing. If you drill a pilot hole first, your 1/2" drill should not cut oversize. It is important not to drill this hole too deep since the buffer retainer hole will go just on the other side. I like to drill a 1/4" hole 1/4" deep and then go in with a 0.500" diameter end mill about .225".





Chuck up a cutter and touch off on the butt face. I use printer paper that is 0.004" thick and set my dial that amount before the zero.

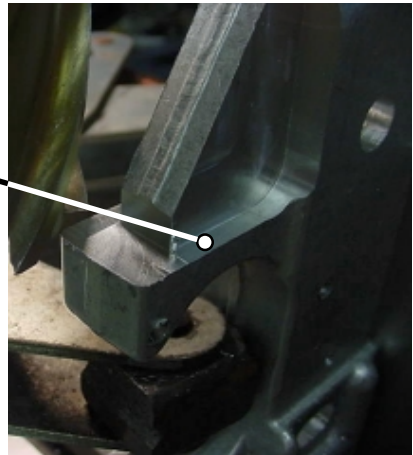




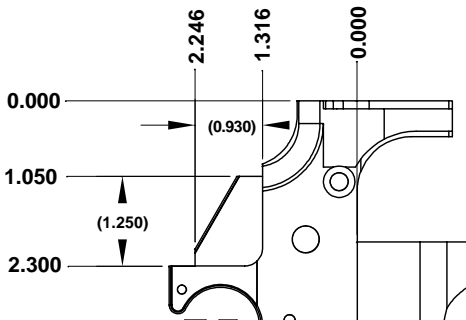
Mill flush with this surface

The first surface to mill is 1.050" down from the butt face. Mill until you are flush with the side faces of the pistol grip mount.

The next surface should be 1.250" further down and 0.930 away from the surface just milled. Move to your depth slowly and make your cut flush with the existing surfaces.



Mill flush to this surface





Once again, before moving on, check that all operations are complete before breaking this setup.

