

## Chapter 6

### Pivot Pin Details

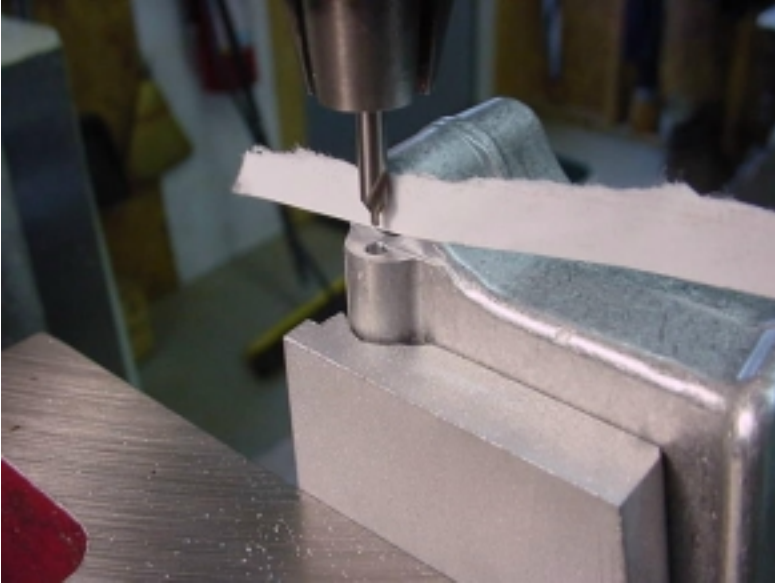
In this chapter we will put in the pivot pin detent hole and mill out the pivot pin boss where the upper receiver goes in.

Once again we will use our passenger side plate to hold the work. You need to know the exact thickness of the side plate where it contacts the cheek of the receiver so if you haven't miked it yet, do it now and write the dimension down on the passenger side plate drawing.

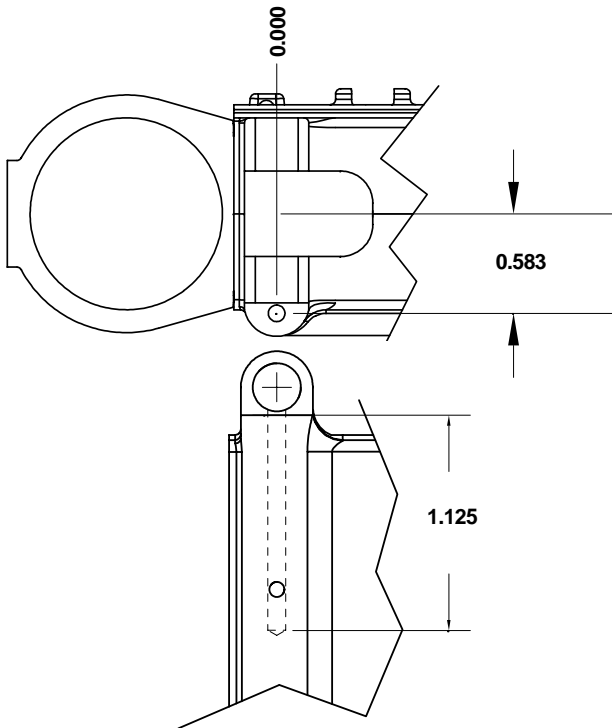


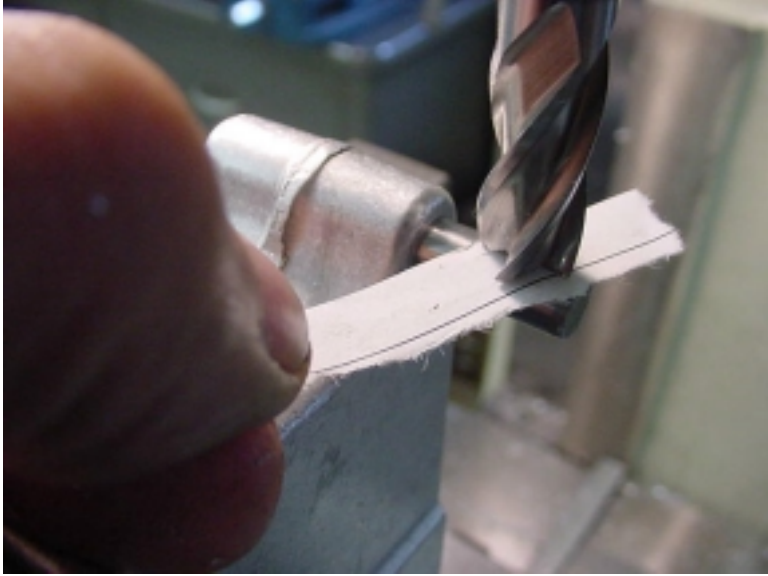
**Workholding:** Clamp the forging to the angle plate using the passenger side plate. Put the butt face against the table. Indicate the deck true to the quill.

**Location:** Edge find the deck and move in 0.250 and set X zero. Edge find the face of the angle plate and move out the thickness of the side plate (that you just recorded) plus half the width of your forging ( $\text{dim. } \alpha / 2$ ) and set Y zero.



First in will be the pivot pin detent hole. Position your spindle at 0.000-0.583 and center drill with a #0 center drill. Choke a 3/32 drill and start the hole. Chuck the bit normally and finish the hole to 1.125" deep from the surface.

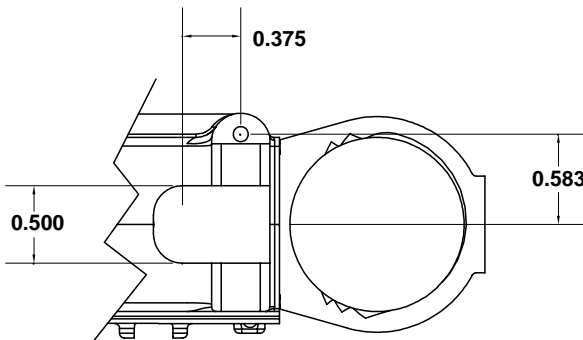




For the slot where the upper and lower meet, chuck a 3/8" end mill. Put a pin in the take-down hole and touch off on the top of the pin. From here you will go down 0.385" to the finished surface.

Mill down along the center-line 3/8" past the pin hole until you are within 0.010" of the finished depth. Then widen the slot equally on both sides to 0.500 +.004 -.000.

To check if you are deep enough, put the pivot pin in the hole and see that a 1/8" dowel pin fits freely between the pivot-pin and the receiver. An even better check is to see if your upper fits.



Chapter 6 check list. Check that all operations are complete before moving on.

Drill pivot-pin  
detent hole

Mill pivot recess

