

# Chapter 7

## Finishing the Pistol Grip Mount

We will now finish up the pistol grip mount. First we will mill the 30 degree face and then drill and tap 1/4-28 for the pistol grip screw.

**Workholding:** This is an easy setup (if your milling machine is level!). Set your combination protractor to 60 degrees and using the nest plate, clamp the forging to the angle plate with the butt face at 60 degrees. Tap until the bubble is centered and then add a second clamp. Re-check the angle after tightening the second clamp.



**Location:** Find the center line as usual and then put a .250 pin in the take down hole. Edge find the pin then move to its center and set zero. Chuck a 1/2" endmill and set the spindle stop and bring the spindle down and lock it against the stop. Raise the table until the cutter touches the pin and zero the elevation dial.



From the pin center-line to the surface to be milled is 1.228". Since we touched off on the top of the pin we will subtract the radius, .125" from the 1.400" giving us 1.103". Lower the table by this amount and mill the angle face of the pistol grip mount.

Locate the spindle at 1.400-0.000. Then drill with a #3 drill about 1-1/4" deep. Counter sink to 5/16" diameter (this helps getting the screw started) and then tap 1/4-28. That's it for this setup. Clean the machine and then go to the checklist on the next page before breaking down.



Chapter 7 check list. Check that all the features are completed before breaking your set-up.

Mill pistol grip bottom face  Drill and tap 1/4-28 pistol grip mounting hole

