

Chapter 9

The Magazine Well

This chapter deals exclusively with the magazine well. I have done some very minor re-design of the profile here to make it easier to machine in the home shop. This profile works just fine and saves time and heartburn as well! Don't let cutting the mag well frighten you, it is easier than you think! The process is only five steps:

One: Drill 1/8" diameter holes in all the corners. These will create the corner fillets.

Two: Then we will drill rough holes to remove most of the stock that is coming out.

Three: Rough out with a 3/4" end mill.

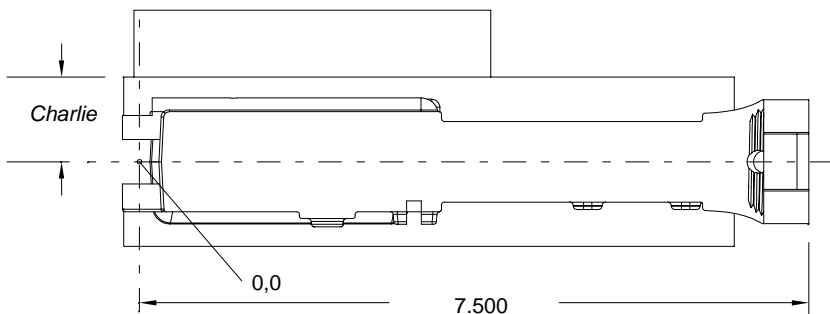
Four: Finish with a 3/8" end mill.

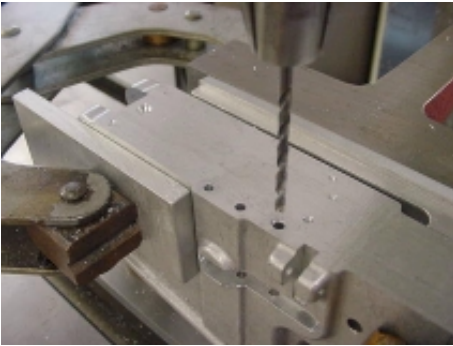
Five: Clean out the corners.

If you plan to stoke out the corners out using a special tool than you will not drill the 1/8" holes, but spot face with a 1/8" endmill instead.

Workholding: Use both clamp plates and clamp the passenger side against the angle plate and indicate the deck true.

Location: Pick-up the butt face, move 7.500" and set your X axis zero directly above the pivot pin hole. The Y axis zero is the forging centerline. Pick up the angle plate surface and move out distance *Charley*. This will be Y zero.

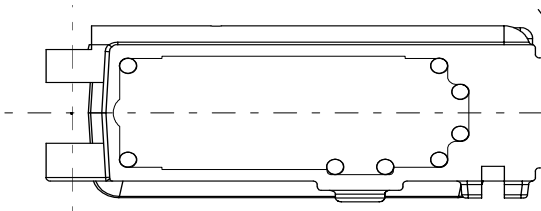
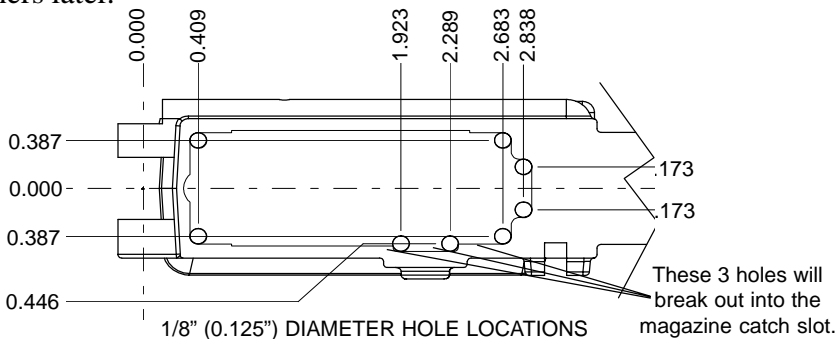




This step creates finished surfaces so drill slowly and carefully. Use cutting fluid and clear the chips often.

For each 1/8" hole: Move the spindle to the location and lock the table. With a small center drill spot the hole. Put a jobber length drill in the chuck and choke it up close so only about 1/2" is protruding. Start you hole with the choked up drill and drill slowly for about 1/4". Now chuck a 1/8" parabolic drill and drill the hole through. Check that you are actually through with a mirror. Move to the next location and repeat the process for all eight 1/8" holes.

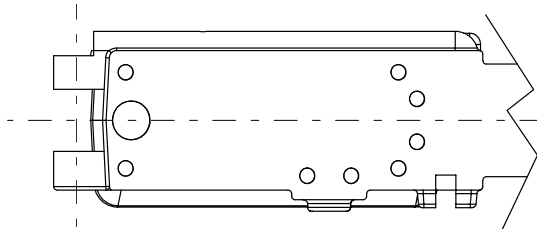
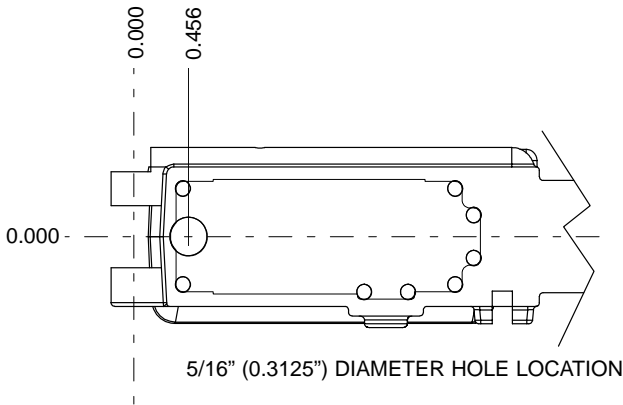
If you plan on stroking out the corners, just put a 1/8" dia. spot face by 0.005 deep on these locations as a lay-out for cutting the corners later.



The forging will look like this after the 1/8" holes are drilled.



Next, put the 5/16" diameter hole through at the location shown below. This hole creates the little arc in the front of the mag well for clearance for the magazine rivits. This cut will leave a finished surface so feed lightly, use cutting fluid and clear the chips often. If you have a 5/16" reamer, then finish the hole with it.



The forging will look like this after the 5/16" hole is drilled.