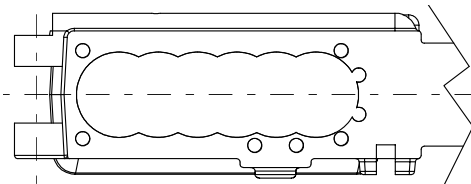
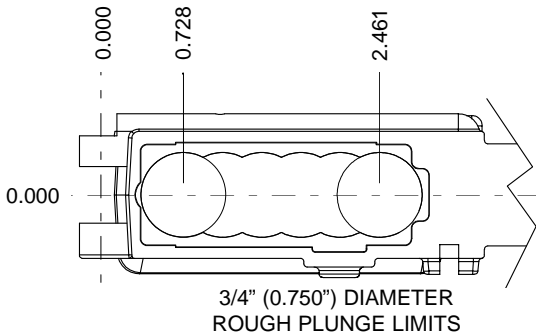
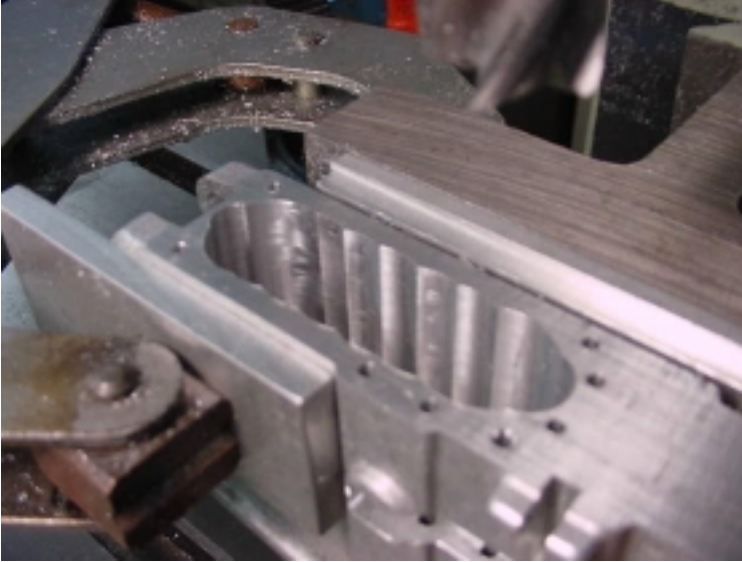


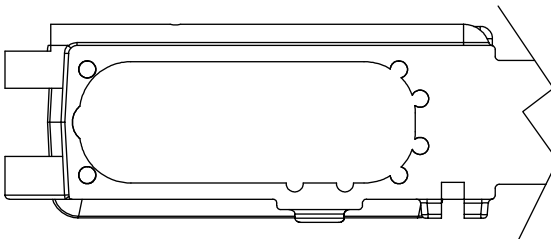
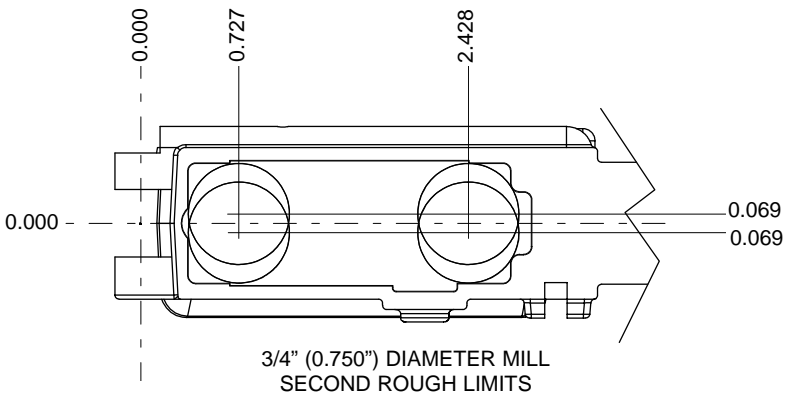
Now with a 3/4" diameter end mill (3" long) rough plunge out the material along the centerline. It is best to take out as much as possible with a heavy end mill so the smaller one will be under less stress. The dimensions shown below are the limits for this operation. The plunge positions inbetween are not critical. Take the first plunge on center of one of the inner 1/2" holes. Then move approximately .3" for each successive plunge, but be careful not to exceed the limits.



*Here is how the forging will look after the 3/4" rough mill.*



Using the same 0.750" diameter mill, follow the limits below for a second roughing pass. The numbers are calculated to leave 0.005" for final clean-up.

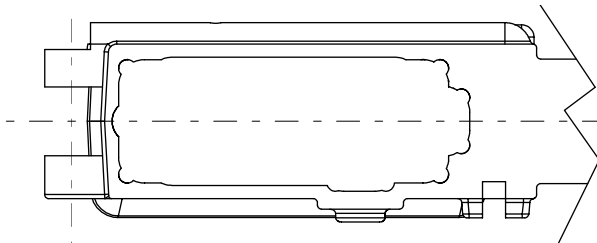
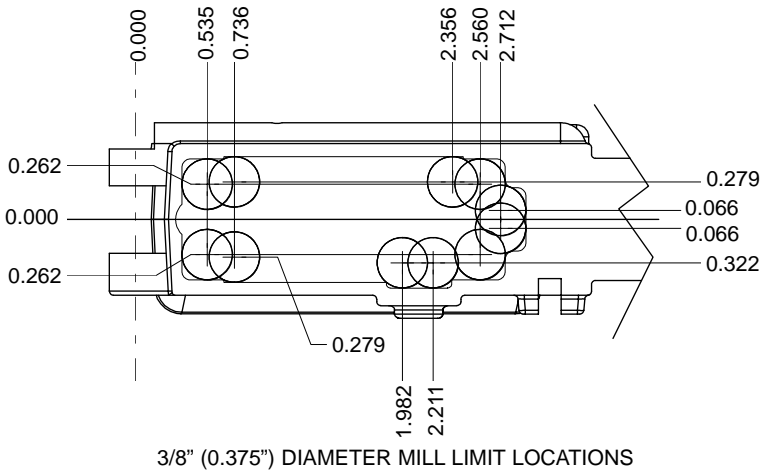


*Your roughed out magazine well should look like this at this point.*

Once you have removed as much stock as possible with the 3/4 end mill switch to a 3/8 end mill. I use a short one and take out the corners as far down as I can and then I put in a 2-1/2" long 3/8 mill and plunge out well to full depth.



Initially, you may want to stay a few thousandths away from the finished size then take a second pass with the full length endmill to the finished dimensions shown below.



*Milled out, the magazine well should look like this.*