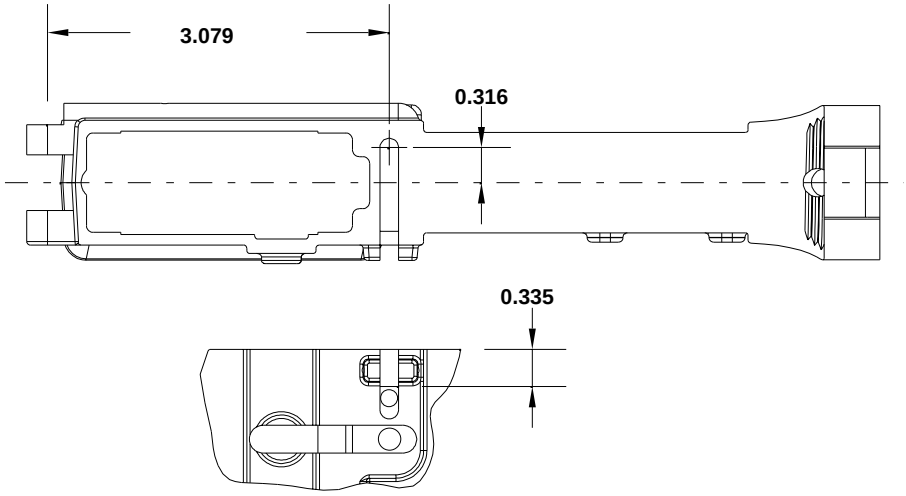
Chapter 10
Hammer & Trigger Cavity

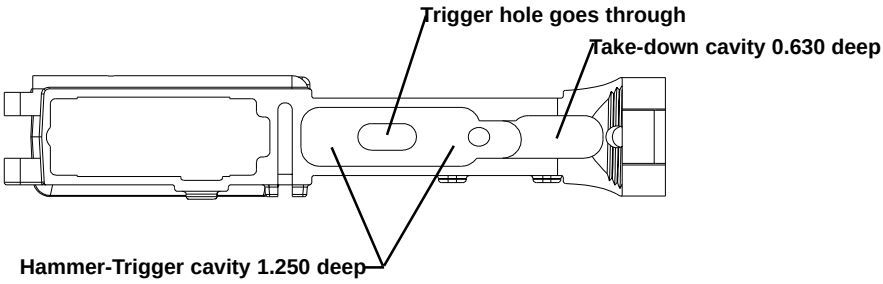
In this chapter we will finish the bolt release pocket and finish the hammer/trigger cavity.

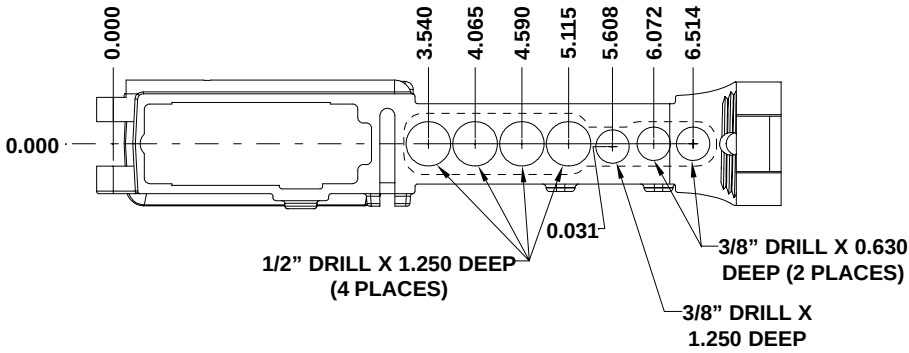
Workholding: Clamp up the forging and indicate it as in chapter nine. Position one clamp just behind and below the safety hole and the other clamp with a plate to protect the work just on otp of the magazine release hole. Shown above is an alternate method using a machine vise. Clamp lightly and indicate the deck true then tighten the vise.

Location: Pickup the butt face with your edge finder and move 7.5” to the pivot pin and set your X axis zero. The Y axis zero is the forging center line.

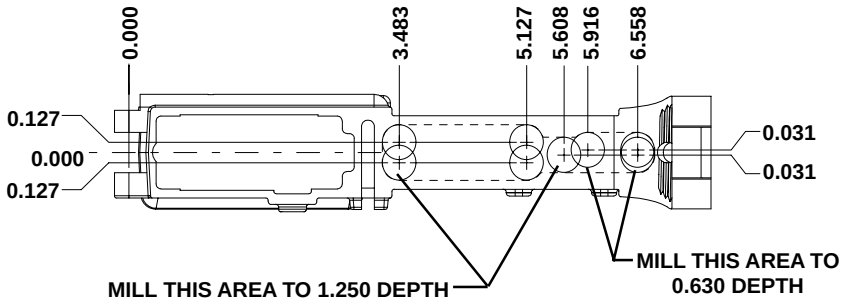
It is easy to forget to finish the bolt release slot so we will do that first and get it out of the way. Put a 1/8” or 5/32” diameter end mill in the spindle and move to 3.079 X. Set your endmill to stop on the deck. You will be cutting a total depth of 0.335” to 0.250” past the center line. Match the sides of your slot with the alredy milled surfaces from chapter three.



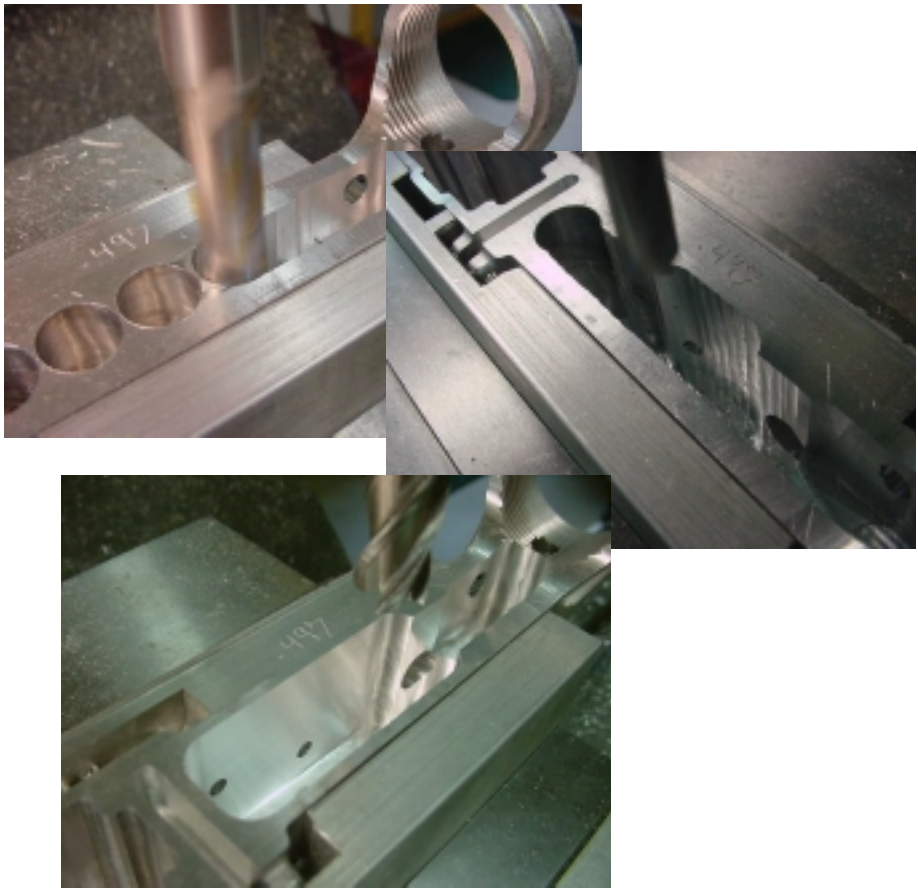




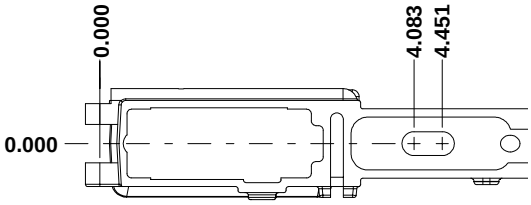
Once again we need to remove a lot of metal and the best way to do it is with drills. Drills are inexpensive and rugged. With some planning we can take out lots of stock before we have to put our end mills to work. Once the hole locations are spotted with a center drill, chuck up a 1/2" drill. Touch off on the deck surface and set for a depth of cut of 1.240" to leave some metal on the bottom for clean-up. Drill The four 1/2" holes and the one 3/8" hole in the trigger/hammer pocket. Then set the depth of cut to 0.615" and drill the rear two 3/8" holes in the take down pin area.

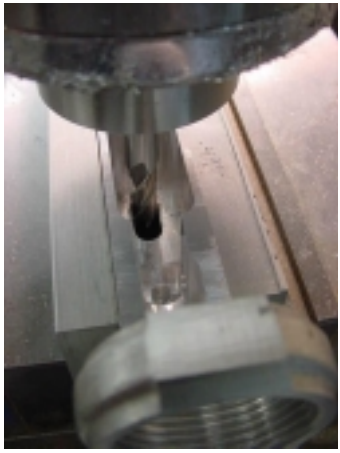


The cavity will be milled out using a 7/16” (0.4375”) end mill. This will leave the proper radii in the corners. Refer to the diagram above for the travel limits. It is best to rough it out first leaving about 0.005” per side and on the bottom for finishing. Plunging works well for roughing. Blow the chips out often to avoid binding the cutter.



The last operation will be cutting the slot for the trigger. Drill two 1/4” holes through as shown. Then chuck a 5/16 end mill and mill the slot through using the same center locations.





Clean your machine and then check your work before breaking the setup.