

# Chapter 11

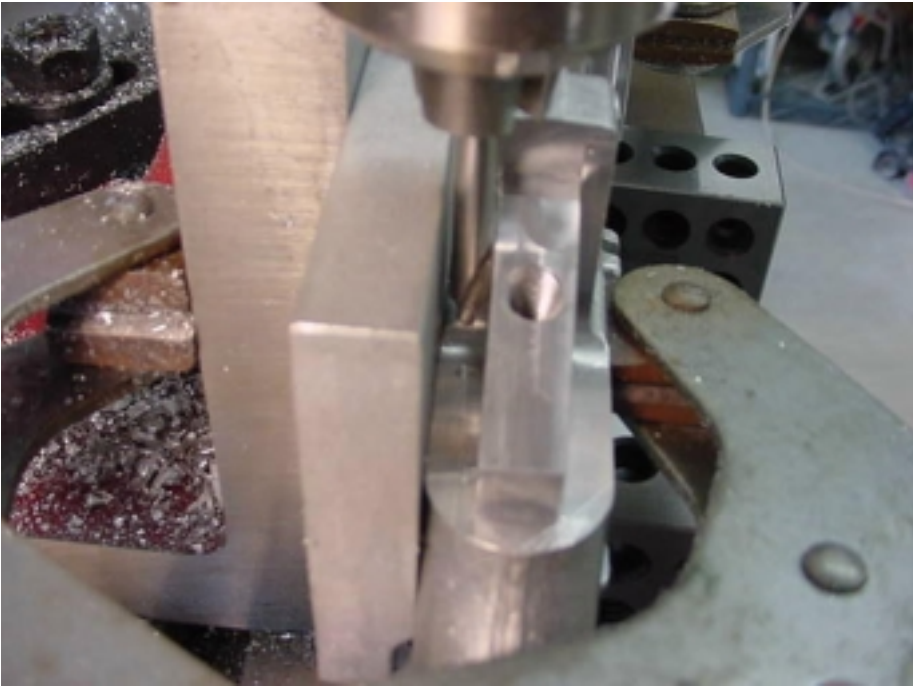
## Safety Detent & Trigger Guard

This is the next to last setup. Be careful now not to rush and make a mistake. Errors are very common near the end of the trail when one begins thinking about the next phase instead of focusing on the task at hand.

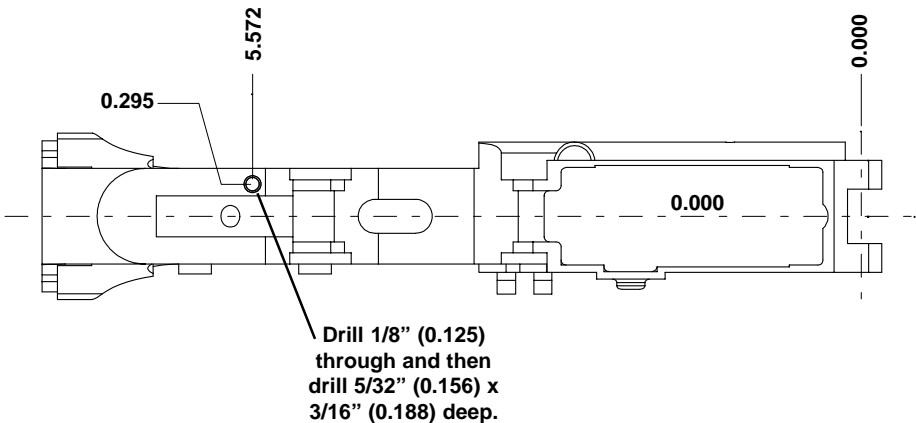
**Workholding:** Support your lower (it is more than 80% complete now so it is no longer a 'forging') on a couple of 1-2-3 blocks and clamp against the angle plate with one clamp at the magazine end. Use something between the clamp and the lower to help distribute the pressure.



**Location:** Edge find the butt face and then add a second clamp once you have your spindle located. Move 7.500" and set your X axis zero over the pivot pin hole. Y axis zero should be the same as the last setup.

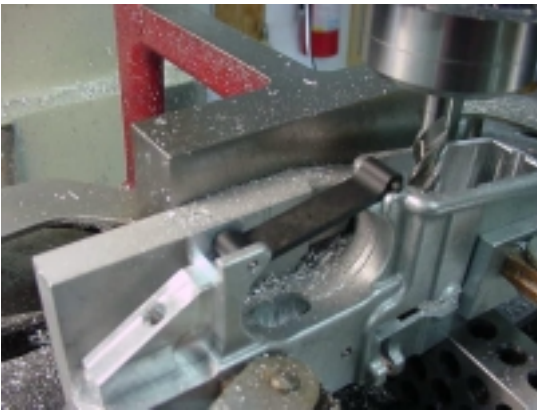


The first thing to do in this setup is the is the safety detent hole. Move back to 5.572" and off the center line by 0.295" and spot the location with a 3/16 center drill. Eyeball it with the safety hole as a double check before you drill 1/8" through. This detent is the headed variety and you must now drill a larger diameter for the head. Use a 5/32 drill, but be careful to only go 0.188" deep or you will be in bad shape.



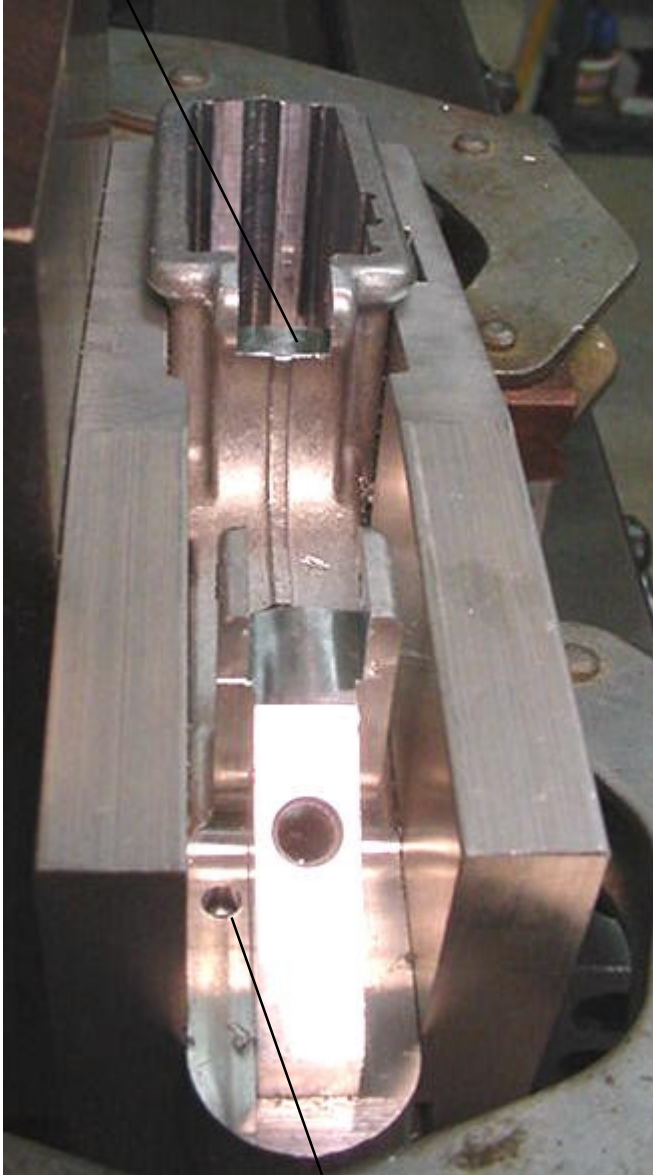


The trigger guard slots are  $7/16$ " wide, but I like to use a  $3/8$ " cutter. While on the centerline, cut down until you are flush with the flat surface of the pistol grip mount and stop there. Now take passes evenly on each side until you have the  $7/16$ " wide slot.



Always check your parts with the feature that is to receive them. I don't have to tell you it is a lot easier now to widen a tight slot than to find out later after you have anodized your work and the trigger guard won't fit!

Trigger Guard



Safety Detent